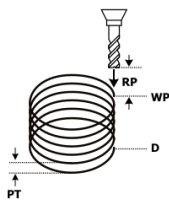


Thread Mill Event

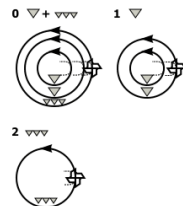
DynaPath WinDelta CNC Mill · Conversational Programming Quick Guide

The **Thread mill** event cuts internal or external threads with a helical toolpath, including tapered and multi-start threads. [15.6.3]

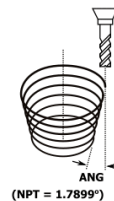
Geometry	Closed circles (thread diameter); several circles in one event
How it runs	Starts with a tool change and tool length compensation, moves to the safe height, starts the spindle and coolant, rapids to the plunge height, then plunges at plunge feed. It then interpolates a helix at the thread pitch to depth and retracts.
Inside or outside	COM sets an internal (inside the circle) or external (outside) thread



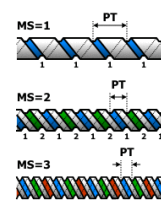
Depths RP, WP, D, L



RF rough / finish



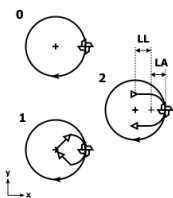
ANG taper (e.g. NPT)



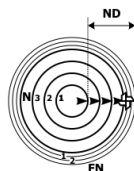
MS multi-start threads

Parameters Manual 15.6.3

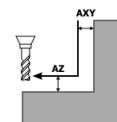
Code	Meaning	Code	Meaning
T	Tool number	RF	Rough, finish or both
MODE	Thread, or contour with a finish pass at depth	DIR	CW / CCW, going down or up
COM	Inside (internal) or outside (external)	RP	Plunge safe height (above WP)
WP	Start depth (absolute)	D	End depth (absolute)
L	Thread pitch	ANG	Taper angle from vertical
SAN	Start angle (0 = X+, positive CW)	MS	Number of thread starts
LS	Lead: none, automatic, centre, custom	LL / LA	Lead line length / arc radius
NT	Side passes: none, count or distance	N / ND	Number / total distance of side passes
STEP / FSEP	Rough / finish step-over	FN	Number of finish passes
AXY / AZ	Stock left on walls / floor	S	Spindle RPM (– for CCW)
P / F	Plunge feed / cutting feed	CL	Coolant: off, air, flood, CTS, CTS + flood



Lead in / out



Side passes N, ND, FN



Allowances AXY, AZ

NOTE

Set L to the thread pitch, MS to the number of starts and DIR for the thread hand you need. Check the first part with a thread gauge before running a batch.