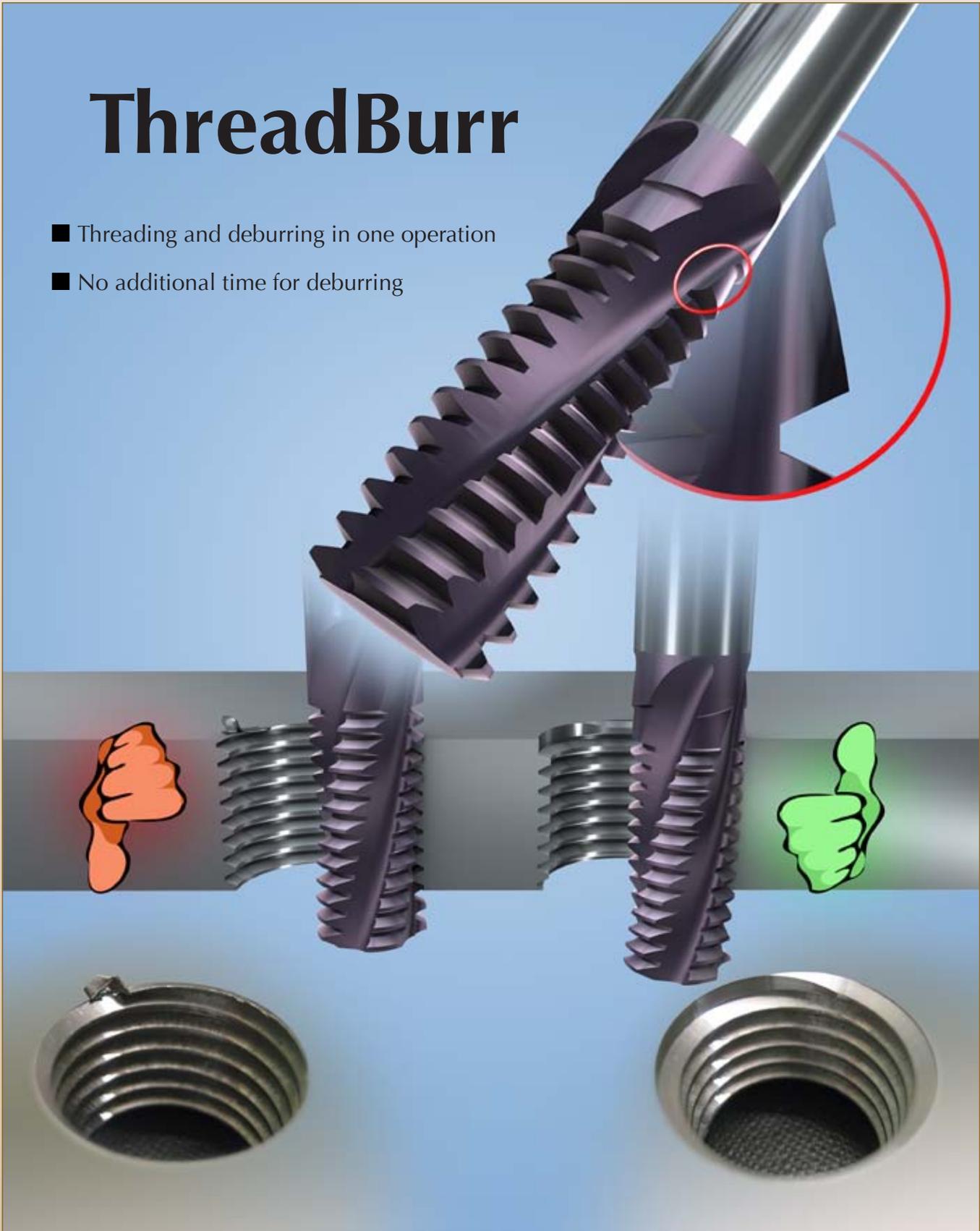


ThreadBurr

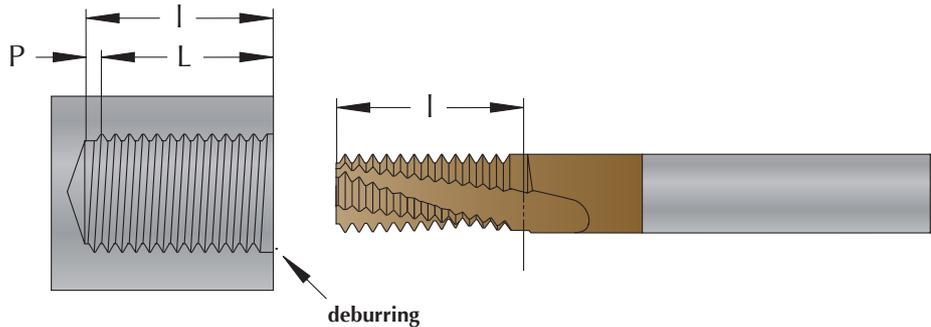
- Threading and deburring in one operation
- No additional time for deburring



ThreadBurr

The advantage with ThreadBurr is that you can thread and deburr in one operation. No additional time for deburring and countersink is needed. The deburring operation is made automatically when thread milling, which gives you the deburring without any extra costs.

There is no disadvantage to use the ThreadBurr, even if you don't use the deburring function. ThreadBurr is standard on all thread mills from SmiCut.

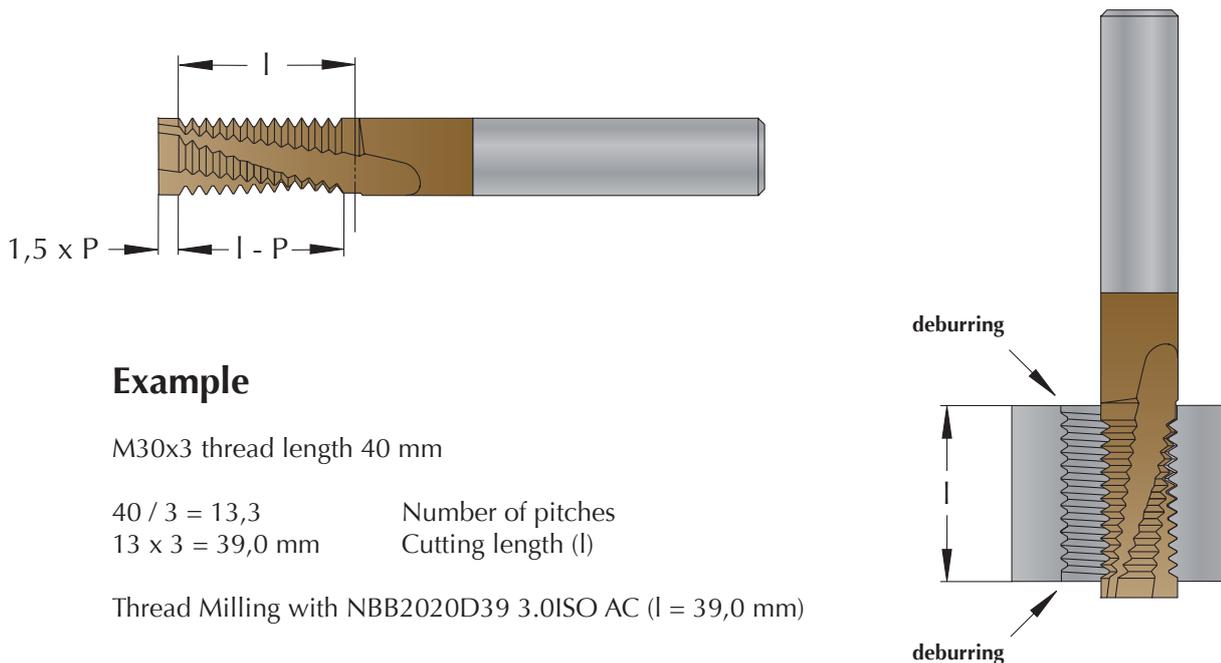


To get a nice entry and a burr free thread you need to start out with going to full depth (l) in to the hole before starting the threading operation. The thread length (L) will be the cutting length (l) minus one pitch (P).

Double ThreadBurr

It is possible to get the thread deburred on both sides. For this operation you need to use a special tool as thread length depends on the thickness of the material. Have in mind the following when you order a tool for deburring on both sides.

- The cutting length (l) should be equivalent to the thickness of the material.



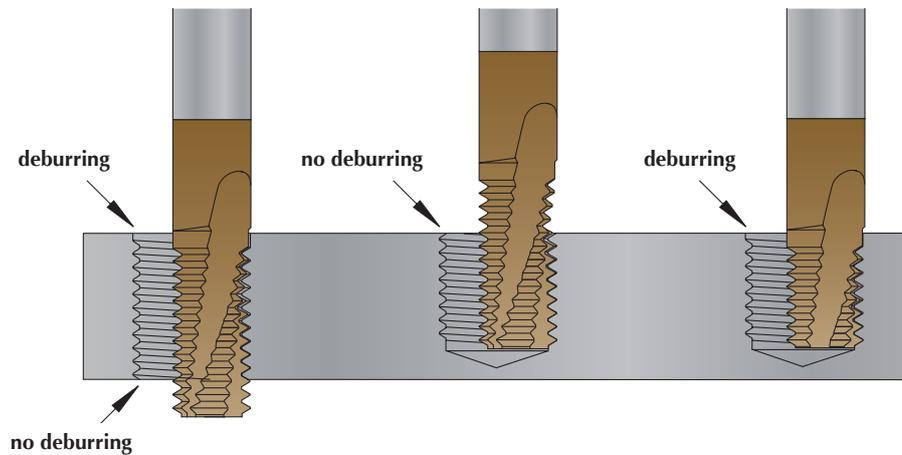
Example

M30x3 thread length 40 mm

$40 / 3 = 13,3$ Number of pitches
 $13 \times 3 = 39,0$ mm Cutting length (l)

Thread Milling with NBB2020D39 3.0ISO AC (l = 39,0 mm)

ThreadBurr



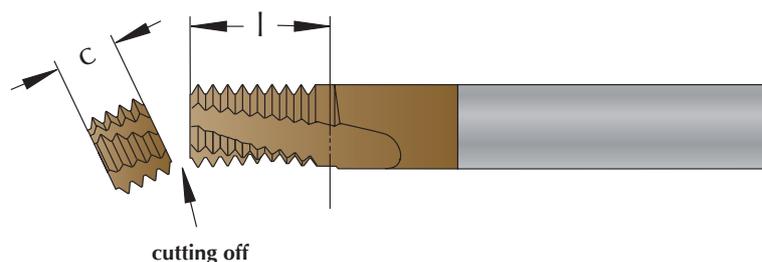
Through Holes

You can always use a standard tool for through holes. Please take in mind you should use a tool as short as possible to get best stability and economy.

Blind Holes

With blind holes it is important to have the correct cutting length (l) on the tool to get the thread deburred. Normally you will find a suitable standard tool. If not, we will cut the tool to the correct length with extremely short delivery time and at a reasonable price. Have in mind the following when you order a tool for blind holes.

- The cutting length (l) should be required thread length (L) plus one pitch (P).
- The distance to cut off (c) has to be dividable by the pitch (P).



Example

M16x1,5 thread length 24 mm
Thread Milling with NB1212D29 1.5ISO AC (L = 29,25 mm)

$24 + 1,5 = 25,5$ mm
 $29,25 - 25,5 = 3,75$ mm
 $3,75 / 1,5 = 2,5$
 $2 \times 1,5 = 3,0$ mm
 $29,25 - 3,0 = 26,25$ mm
 $26,25 - 1,5 = 24,75$ mm

Required cutting length (l)
 Maximum cutting off
 Number of pitches to cut off
 Distance to cut off (c)
 Cutting length (l) after cutting off
 Thread length (L) after cutting off

You only need to cut of the tool when you want to use the deburring function on blind holes and if there is no standard tool with suitable cutting length.