P.) 800-255-1701 F.) 800-338-4857
www.morsecuttingtools.com

Thread Mill Programming Request Form

Distributor Name _____ *Date* _____
Dist. Contact _____ *Phone Number* _____
End User _____ *Fax Number* _____
End User Contact _____ *E-mail* _____

Machine Information

Brand _____
Model _____
Spindle taper _____
Max RPM _____

Control Information

Brand _____
Model _____
ISO – ASCII Compatible ☐Yes ☐No ☐Don't Know
Helical Milling Available? ☐Yes ☐No ☐Don't Know

Thread To Be Produced

Thread Specification _____
Length of Full Thread _____
Thread Form ☐ 100% ☐ 75% Other
☐ Internal Thread ☐ External Thread
Drill Size _____" ☐Thru ☐Blind ☐Counterbored

Material Being Machined

Material _____
Hardness _____
Condition ☐ Annealed ☐ Normalized ☐ Heat Treated
☐ Cast ☐ Forged ☐ Rolled ☐ Plate ☐ Bar
☐ Pre-Machined ☐ Flame Cut ☐ Scale ☐ Sand

Morse Thread Mill To Be Used (EDP No. or Description) _____

Programming Data

Dimensions ☐ Inch ☐ Metric
Program Values ☐ Absolute (G90) ☐ Incremental (G91)
Arc Center ☐ I & J ☐ R (Radius)
Tool Path ☐ Offset ☐ No Offset
Arc Limitation ☐ Full Circle ☐ Quadrant

K Value ☐ Not Required ☐ Required
If Required ☐ In Radians ☐ Per Revolution
Feed Direction ☐ Climb ☐ Conventional

Note: Climb Milling is always recommended for carbide tooling. In some cases where thin-walled parts, long extensions, or poor spindle conditions are encountered conventional milling may be an option to produce a given thread.