

Copy this form, fill in the information then fax it to: 1-850-236-2425

Programming Request Form

Company Name: _____ Date: _____
 Contact: _____ Telephone: _____
 Tooling Purchase From: _____ Fax Number: _____

Machine Information:

Brand Make: _____
 Model: _____
 Spindle Taper: 35 Cat 40 Cat 50 Cat
 Max RPM: _____

CNC Controller Information:

Brand Make: _____
 Model: _____
 ISO - ASCII Compatible: Yes No Don't Know
 Is Helical Option Available: Yes No Don't Know

Thread Specification To Be Produced:

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

Material To Be Machined:

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

Thread Mill Selected: Solid Carbide Indexable

Tool Description: _____


Insert Selected (If Indexable): _____

Tool Purchased From: _____

If you are not sure what tool to select, check one of the following and we will recommend a tool for you:

Shortest Cycle Time Lowest Tooling Cost

Tool Recommended: _____

 Distributor you purchased tool from must be filled in to receive a program for your application, otherwise a tool recommendation will be faxed back with approximate cycle time given.

Programming Data:

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

K Value: Not Required Required

If Required: In Radians Per Revolution

Feed Direction: Climb Mill Conventional

Note: Climb Milling is always recommended for carbide tooling. In some cases where thin wall parts, long extensions or worn spindle bearings are encountered, conventional milling may be an option to production of a given thread.