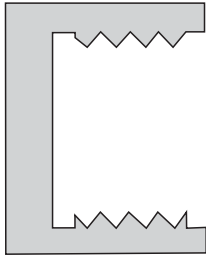
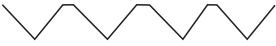




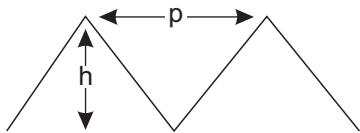
## CUTTING A THREAD



Cut the female thread with a 1 - 2 mm flat lead-in and a 1 - 2 mm run-out.

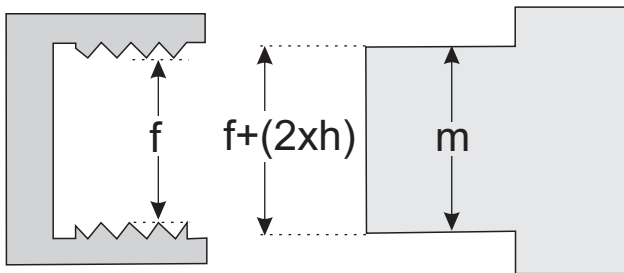
Close-up the thread should have small flats instead of a point. 

Note that the cutter will not go fully to the bottom. Nor will it later cut all the length of the male part. So the lead-in and run-out flats are important to ensure that the parts fit together. They also make it easier for the threads to meet when putting the parts together.

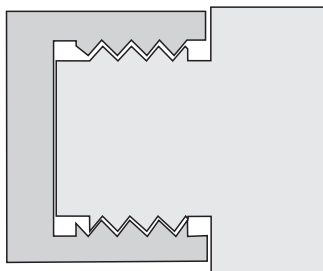


If a 60° cutter is used then the thread height is equal to  $p \times 0.866$

With this height known and the female thread measured ( $f$ ), the male part of the work can be made to a measured size of  $f + (2 \times h)$



But  $m$  actually needs to be a little smaller than  $f + (2 \times h)$  to allow for the flat points on  $f$  and to ensure that there is a little bit of space between the two parts of the thread.



Now, cut a thread on the male part with a lead-in and run-out so that it will fit into the female part.

Note that if the lead-in is generous on each part there is no need for a run-out on either part.