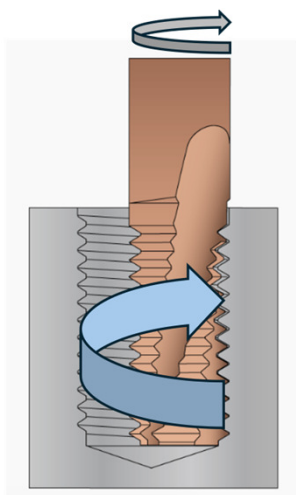




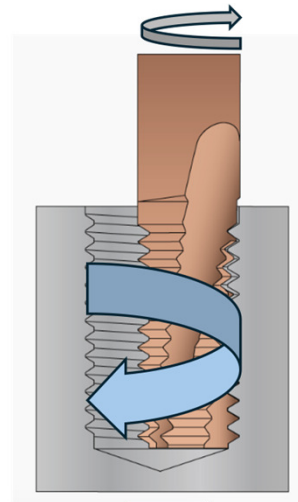
How to produce a LH thread when thread milling

All of our standard thread milling tools are ground or orientated to be RH cutting. To cut a LH thread by thread milling the tool will rotate as normal in a CW direction when viewed down the tool from the clamping end and will need to be pitched up or down as below.

Internal LH Thread



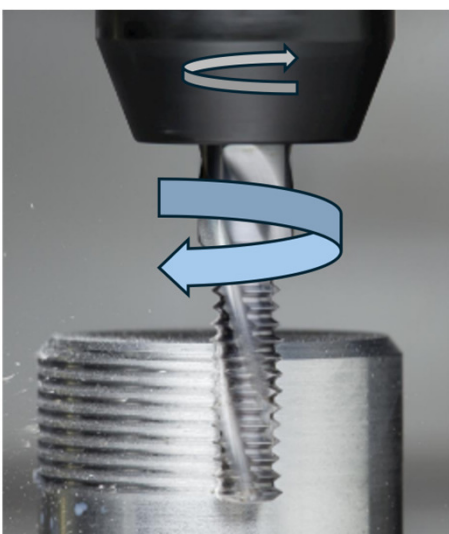
PITCH UP CW



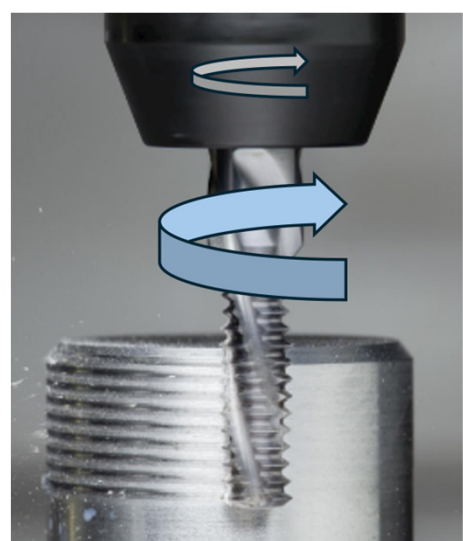
PITCH DOWN CCW

✓
Preferred Method

External LH Thread



PITCH DOWN CCW



PITCH UP CW

✓
Preferred Method

Be aware of swarf at the bottom of blind holes as this can cause issues for the thread mills