

# Telephone Inquiry / Quote Request / Programming Assistance / Tool Testing Form



Advent's Technical Support Staff offers free programming assistance to first time users of any Advent Thread Milling product. If you are not familiar with thread milling, we highly recommend you copy the program request form below and fill out all information. You can then fax it to **1-847-549-9714** or email us at [info@Advent-Threadmill.com](mailto:info@Advent-Threadmill.com) and we will return a suggested CNC program. A free CD-ROM of programming software is available upon request.

Company Name : \_\_\_\_\_ Date : \_\_\_\_/\_\_\_\_/\_\_\_\_\_  
 Contact : \_\_\_\_\_ Phone : (\_\_\_\_)\_\_\_\_\_  
 Tooling Purchased From : \_\_\_\_\_ Fax : (\_\_\_\_)\_\_\_\_\_

## 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 Specifications : \_\_\_\_\_  
 Length of Full Thread : \_\_\_\_\_  
 Thread From :  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 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 Limitation :  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.