

Twenty-Eighth Edition

Machinery's Handbook



Industrial Press

A REFERENCE BOOK
FOR THE MECHANICAL ENGINEER, DESIGNER,
MANUFACTURING ENGINEER, DRAFTSMAN,
TOOLMAKER, AND MACHINIST

Machinery's Handbook

28th Edition

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2008
INDUSTRIAL PRESS
NEW YORK

P = the infeed method adjustment – positive (not available on all controls)

F = the feed rate (thread lead)

Two Block Cycle: The two-block G76 format includes several additional programmable features that make the cycle more flexible. For a two-block G76 cycle, the format is:

N__ G76 P__ Q__ R__
N__ G76 X__ Z__ R__ P__ Q__ F__

Where the first block:

P = a six-digit data entry in three pairs:

Digits 1 and 2 – number of finishing cuts (01-99)

Digits 3 and 4 – number of leads for gradual pull-out (0.0-9.9 times lead), no decimal point used (00-99)

Digits 5 and 6 – angle of thread (00, 29, 30, 55, 60, 80 degrees only)

Q = the minimum cutting depth (positive radial value - no decimal point)

R = the fixed amount for finish allowance (decimal point allowed)

Where the second block:

X = the diameter of the last threading pass

Z = the end of thread along the Z axis

R = the amount of taper over the total length (per side)

P = the single depth of the thread (positive radial value - no decimal point)

Q = the depth of the first threading pass (positive radial value - no decimal point)

F = the feed rate (thread lead)

The P/Q/R addresses of the first block are not related to the P/Q/R addresses of the second block. They have their own meaning, applied within each block only.

The G76 threading cycle is used to program the majority of CNC thread cutting operations. Several of parameters of the G76 cycle can be changed at the machine to optimize the threading operation.

Example: The code block for cutting an external thread on 2 inch diameter, 12 threads per inch, using tool number 6 to the length of 1.5 inches (thread ends in a recess) would be:

N31 T0600; N32 G97 S800 M03; N33 G00 X2.2 Z0.3 T0606 M08 (START POINT FOR THE THREAD); N34 G76 P010060 Q0040 R0.002; N35 G76 X1.8978 Z-1.5 R0 P0511 Q0100 F0.083333; N36 G00 X8.0 Z5.0 T0600; N37 M01;

Multi-start Threads.—Threads with more than one start can be programmed using either G32 or G76 threading commands. The lead (and feed rate) for multi-start threads is always the number of starts times the pitch. For example, a triple start thread with the pitch of 0.0625 (16 TPI) will be 0.1875 (F0.1875). In order to achieve proper distribution of each start around the cylinder, each thread has to start at an equal angle, determined by the following calculation:

$$\text{Thread cylindrical spacing angle} = 360 / \text{Number of starts}$$

To achieve this angular spacing, the Z-axis point for each start must be one pitch further than the previous start:

$$\text{Shift amount} = \text{Pitch}$$

$$\text{Number of shifts} = \text{Number of starts} - 1$$

Subprograms, Macros and Parametric Programming

CNC programs use several techniques to allow the programmer to create complex pieces of code using CNC code building blocks.

Subprograms.—*Subprograms* (also known as subroutines), are specially designed programs that can be called on demand by another program and repeated as desired. Such rep-

by hand, such as hose couplings and thread plug gages, to prevent cutting of hands and crossing of threads. It was formerly known as a Higbee cut.

Chamfer: This is a conical surface at the starting end of a thread.

Class of Thread: The class of a thread is an alphanumerical designation to indicate the standard grade of tolerance and allowance specified for a thread.

Clearance Fit: This is a fit having limits of size so prescribed that a clearance always results when mating parts are assembled at their maximum material condition.

Complete Thread: The complete thread is that thread whose profile lies within the size limits. (See also *Effective Thread* and *Length of Complete Thread*.) *Note:* Formerly in pipe thread terminology this was referred to as "the perfect thread" but that term is no longer considered desirable.

Crest: This is that surface of a thread which joins the flanks of the thread and is farthest from the cylinder or cone from which the thread projects.

Crest Truncation: This is the radial distance between the sharp crest (crest apex) and the cylinder or cone that would bound the crest.

Depth of Thread Engagement: The depth (or height) of thread engagement between two coaxially assembled mating threads is the radial distance by which their thread forms overlap each other.

Design Size: This is the basic size with allowance applied, from which the limits of size are derived by the application of a tolerance. If there is no allowance, the design size is the same as the basic size.

Deviation: Deviation is a variation from an established dimension, position, standard, or value. In ISO usage, it is the algebraic difference between a size (actual, maximum, or minimum) and the corresponding basic size. The term deviation does not necessarily indicate an error. (See also *Error*.)

Deviation, Fundamental (ISO term): For standard threads, the fundamental deviation is the upper or lower deviation closer to the basic size. It is the upper deviation *es* for an external thread and the lower deviation *EI* for an internal thread. (See also *Allowance* and *Tolerance Position*.)

Deviation, Lower (ISO term): The algebraic difference between the minimum limit of size and the basic size. It is designated *EI* for internal and *ei* for external thread diameters.

Deviation, Upper (ISO term): The algebraic difference between the maximum limit of size and the basic size. It is designated *ES* for internal and *es* for external thread diameters.

Dimension: A numerical value expressed in appropriate units of measure and indicated on drawings along with lines, symbols, and notes to define the geometrical characteristic of an object.

Effective Size: See *Pitch Diameter*, *Functional Diameter*.

Effective Thread: The effective (or useful) thread includes the complete thread, and those portions of the incomplete thread which are fully formed at the root but not at the crest (in taper pipe threads it includes the so-called black crest threads); thus excluding the vanish thread.

Error: The algebraic difference between an observed or measured value beyond tolerance limits, and the specified value.

External Thread: A thread on a cylindrical or conical external surface.

Fit: Fit is the relationship resulting from the designed difference, before assembly, between the sizes of two mating parts which are to be assembled.

Flank: The flank of a thread is either surface connecting the crest with the root. The flank surface intersection with an axial plane is theoretically a straight line.

Flank Angle: The flank angles are the angles between the individual flanks and the perpendicular to the axis of the thread, measured in an axial plane. A flank angle of a symmetrical thread is commonly termed the half-angle of thread.

Flank Diametral Displacement: In a boundary profile defined system, flank diametral displacement is twice the radial distance between the straight thread flank segments of the

Minor Cone: The imaginary cone that would bound the roots of an external taper thread or the crests of an internal taper thread.

Minor Cylinder: The imaginary cylinder that would bound the roots of an external straight thread or the crests of an internal straight thread.

Minor Diameter: On a straight thread the minor diameter is that of the minor cylinder. On a taper thread the minor diameter at a given position on the thread axis is that of the minor cone at that position. (See also *Minor Cylinder* and *Minor Cone*.)

Multiple-Start Thread: A thread in which the lead is an integral multiple, other than one, of the pitch.

Nominal Size: Designation used for general identification.

Parallel Thread: See *Screw Thread*.

Partial Thread: See *Vanish Thread*.

Pitch: The pitch of a thread having uniform spacing is the distance measured parallel with its axis between corresponding points on adjacent thread forms in the same axial plane and on the same side of the axis. Pitch is equal to the lead divided by the number of thread starts.

Pitch Cone: The pitch cone is an imaginary cone of such apex angle and location of its vertex and axis that its surface would pass through a taper thread in such a manner as to make the widths of the thread ridge and the thread groove equal. It is, therefore, located equidistantly between the sharp major and minor cones of a given thread form. On a theoretically perfect taper thread, these widths are equal to one-half the basic pitch. (See also *Axis of Thread* and *Pitch Diameter*.)

Pitch Cylinder: The pitch cylinder is an imaginary cylinder of such diameter and location of its axis that its surface would pass through a straight thread in such a manner as to make the widths of the thread ridge and groove equal. It is, therefore, located equidistantly between the sharp major and minor cylinders of a given thread form. On a theoretically perfect thread these widths are equal to one-half the basic pitch. (See also *Axis of Thread* and *Pitch Diameter*.)

Pitch Diameter: On a straight thread the pitch diameter is the diameter of the pitch cylinder. On a taper thread the pitch diameter at a given position on the thread axis is the diameter of the pitch cone at that position. *Note:* When the crest of a thread is truncated beyond the pitch line, the pitch diameter and pitch cylinder or pitch cone would be based on a theoretical extension of the thread flanks.

Pitch Diameter, Functional Diameter: The functional diameter is the pitch diameter of an enveloping thread with perfect pitch, lead, and flank angles and having a specified length of engagement. It includes the cumulative effect of variations in lead (pitch), flank angle, taper, straightness, and roundness. Variations at the thread crest and root are excluded. Other, nonpreferred terms are *virtual diameter*, *effective size*, *virtual effective diameter*, and *thread assembly diameter*.

Pitch Line: The generator of the cylinder or cone specified in *Pitch Cylinder* and *Pitch Cone*.

Right-hand Thread: A thread is a right-hand thread if, when viewed axially, it winds in a clockwise and receding direction. A thread is considered to be right-hand unless specifically indicated otherwise.

Root: That surface of the thread which joins the flanks of adjacent thread forms and is immediately adjacent to the cylinder or cone from which the thread projects.

Root Truncation: The radial distance between the sharp root (root apex) and the cylinder or cone that would bound the root. See also *Sharp Root (Root Apex)*.

Runout: As applied to screw threads, unless otherwise specified, runout refers to circular runout of major and minor cylinders with respect to the pitch cylinder. Circular runout, in accordance with ANSI Y14.5M, controls cumulative variations of circularity and coaxiality. Runout includes variations due to eccentricity and out-of-roundness. The amount of runout is usually expressed in terms of full indicator movement (FIM).

ACME SCREW THREADS

American National Standard Acme Screw Threads

This American National Standard ASME/ANSI B1.5-1997 is a revision of American Standard ANSI B1.5-1988 and provides for two general applications of Acme threads, namely, General Purpose and Centralizing.

The limits and tolerances in this standard relate to single-start Acme threads, and may be used, if considered suitable, for multi-start Acme threads, which provide fast relative traversing motion when this is necessary. For information on additional allowances for multi-start Acme threads, see later section on page 1828.

General Purpose Acme Threads.—Three classes of General Purpose threads, 2G, 3G, and 4G, are provided in the standard, each having clearance on all diameters for free movement, and may be used in assemblies with the internal thread rigidly fixed and movement of the external thread in a direction perpendicular to its axis limited by its bearing or bearings. It is suggested that external and internal threads of the same class be used together for general purpose assemblies, Class 2G being the preferred choice. If less backlash or end play is desired, Classes 3G and 4G are provided. Class 5G is not recommended for new designs.

Thread Form: The accompanying Fig. 1 shows the thread form of these General Purpose threads, and the formulas accompanying the figure determine their basic dimensions. Table 1 gives the basic dimensions for the most generally used pitches.

Angle of Thread: The angle between the sides of the thread, measured in an axial plane, is 29 degrees. The line bisecting this 29-degree angle shall be perpendicular to the axis of the screw thread.

Thread Series: A series of diameters and associated pitches is recommended in the Standard as preferred. These diameters and pitches have been chosen to meet present needs with the fewest number of items in order to reduce to a minimum the inventory of both tools and gages. This series of diameters and associated pitches is given in Table 3.

Chamfers and Fillets: General Purpose external threads may have the crest corner chamfered to an angle of 45 degrees with the axis to a maximum width of $P/15$, where P is the pitch. This corresponds to a maximum depth of chamfer flat of $0.0945P$.

Basic Diameters: The max major diameter of the external thread is basic and is the nominal major diameter for all classes. The min pitch diameter of the internal thread is basic and is equal to the basic major diameter minus the basic height of the thread, h . The basic minor diameter is the min minor diameter of the internal thread. It is equal to the basic major diameter minus twice the basic thread height, $2h$.

Length of Engagement: The tolerances specified in this standard are applicable to lengths of engagement not exceeding twice the nominal major diameter.

Major and Minor Diameter Allowances: A minimum diametral clearance is provided at the minor diameter of all external threads by establishing the maximum minor diameter 0.020 inch below the basic minor diameter of the nut for pitches of 10 threads per inch and coarser, and 0.10 inch for finer pitches. A minimum diametral clearance at the major diameter is obtained by establishing the minimum major diameter of the internal thread 0.020 inch above the basic major diameter of the screw for pitches of 10 threads per inch and coarser, and 0.010 inch for finer pitches.

Major and Minor Diameter Tolerances: The tolerance on the external thread major diameter is $0.05P$, where P is the pitch, with a minimum of 0.005 inch. The tolerance on the internal thread major diameter is 0.020 inch for 10 threads per inch and coarser and 0.010 for finer pitches. The tolerance on the external thread minor diameter is $1.5 \times$ pitch diameter tolerance. The tolerance on the internal thread minor diameter is $0.05P$ with a minimum of 0.005 inch.