

Thread Whirling

Features



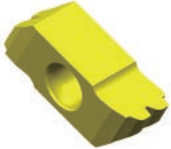
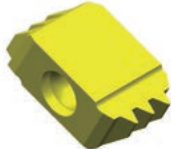


WATCH ON
New Double-lead video is on [YouTube](#)

- NTK's unique patented design technology makes precise and correct inserts the first time, *without any redesign or remanufacture even if it is a multiple-lead thread*
- Sharp cutting edges produce a better surface finish and longer tool life than competitor's inserts

Form Double-lead or Multiple-lead with Single Pass

Patented

	Double-lead threads	Triple-lead threads
Work	Bone screw	Worm gear
Work material	Ti-6Al-4V ELI	brass
Work appearance		
Insert appearance		
Major Dia.	$\phi .157$ "(4.0mm)	$\phi .278$ "(7.0mm)
Minor Dia.	$\phi .094$ "(2.4mm)	$\phi .185$ "(4.7mm)
Lead [Pitch×No. of Lead]	.135"(3.42mm) [.067"×2(1.71mm×2)]	.193"(4.9mm) [.064"×3(1.63mm×3)]

- Can reduce cycle time by more than half
- NTK can achieve what other competitors cannot

Double-lead Bone Screw Process Example

- 1 1st thread whirl at taper part
- 2 Rotate the bar 180° and whirl the 2nd thread on same part as **1**
- 3 Thread whirl whole straight part
- 4 Thread whirl at very last part to get two-exits, after back of bar has been backed up a half lead (one pitch) and rotated 180°