

---

Abstract

---

## METHOD OF MACHINING AN END PORTION OF A LONG TUBULAR MEMBER

Thread cutting of the end portion of a long tubular member (1) held by a chuck system (3) is carried out with high accuracy without leaving mill scale on the complete thread portion of the resulting threads. The protruding length  $L$  of the  
5 long tubular member from the chuck system (3) to the end face of the tubular member is controlled so that the ratio  $L/D$  of the protruding length  $L$  to the outer diameter  $D$  of the long tubular member (1) is in a range predetermined depending on the outer diameter  $D$  and the ratio  $t/D$  of the wall thickness  $t$  to the outer  
10 diameter  $D$  of the tubular member (1). When the chuck system is a floating chuck system having a floating chuck and a positioning chuck, the protruding length  $L$  of the tubular member from the floating chuck and the protruding length  $L'$  thereof from the positioning chuck are controlled.