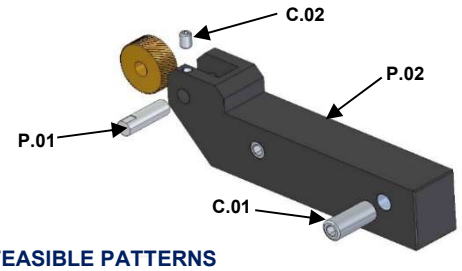



## 1 FEASIBLE PATTERNS

| KNURLING PROFILE | KNURL | FEED (Drawing.3) F | R |
|---|---|---|---|
| RAA | AA | ✓ | ✓ |
| RBL 30° | BR30° | ✓ | ✓ |
| RBL 45° | BR45° | ✓ | ✓ |
| RBR 30° | BL30° | ✓ | ✓ |
| RBR 45° | BL45° | ✓ | ✓ |
| RGE 30° | GV30° | × | ✓ |
| RGE 45° | GV45° | × | ✓ |
| RGV 30° | GE30° | × | ✓ |
| RGV 45° | GE45° | × | ✓ |
| RKE | KV | × | ✓ |
| RKV | KE | × | ✓ |

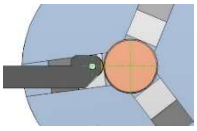
The M4 form knurling tool is conceived for knurling on pieces:

- If the knurl is Ø20, diameters between 8 and 200 mm
- If the knurl is Ø25, diameters between 8 and 300 mm

## 2 CLAMPING AND SETTING THE TOOL IN THE MACHINE

Clamp the tool to the turret of the lathe. While the chuck rotates very slowly, approach the tool to the workpiece until the knurl makes contact with the workpiece.

Approach the knurling wheel to the workpiece following the 'F' direction up until the teeth plunge a little into it. Check out the resulted print. The printed width (h) must be equal to the width of the teeth on the knurl. If the width isn´t correct, change the clearance angle.



Drawing.2

## 3 KNURLING ON STEPPED WORKPIECES

When knurling stepped workpieces, it is not possible to knurl up to a shoulder.

Using this tool, no knurling should be performed closer to 5,5 mm from the shoulder itself.

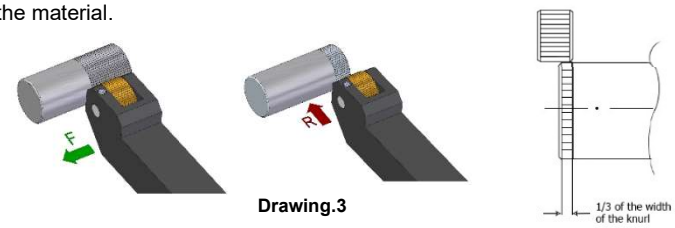
## 4 BEGINNING TO KNURL

While the chuck is rotating at the speed recommended, feed the tool so that 1/3 of the width of the knurling wheel gets in contact with the workpiece.

Press the knurl against the workpiece. The value of the radial feed must be according to the conditions recommended on the table 1.

After that, you will be able to feed longitudinally.

To calculate up to what diameter we must deepen with the knurl, we must take into account the height of the tooth (**in the case of standard knurls is always equal to half the step**) and the increase in diameter that suffers the material.




Drawing.3

## 5 BEAR IN MIND BEFORE AND WHILE WORKING PROCESS

Make sure that the knurl pins are firmly fastened.

Make sure that the axis of the knurl is aligned with the axis of the workpiece.

Always work plenty of coolant, lubricant or cutting oil.

The working direction, longitudinal advance, will always be against the tool.

## 6 TROUBLE SHOOTING

| PROBLEM | CAUSE | SOLUTION |
|---|---|---|
| Double knurling | Too slow radial feed at the beginning of the knurling | Increase radial feed at the beginning of the knurling* |
| | The perimeter of the workpiece is not an exact multiple of the pitch | Turn a diameter so that the perimeter to be knurled is an exact multiple of the pitch* |
| Knurling wheels easily breakable | Knurling too deep | Reduce the depth to values according to the pitch |
| Knurling wheels wear out too fast | Knurling too deep | Reduce the depth to values according to the pitch |
| | Working conditions are not adequate | Check cutting speed and traverse feeding speeds |

* Sometimes, it is not possible to increase radial feed or it just cannot be radially fed in the workpiece is too weak.

## 7 RECOMMENDED SETTINGS

| Material | ØWorkpiece (mm) | ØKnurl (mm) | Cutting speed (m/min) | Radial feed (mm/rev) | Traverse feed (mm/rev) Pitch (mm) 0.3÷0.6 | 0.6÷1.2 | 1.2÷1.6 | 1.6÷2.0 |
|---|---|---|---|---|---|---|---|---|
| Steel 600 N/mm² | 10÷50 | 20 | 25÷55 | 0.05÷0.10 | 0.20 | 0.15 | 0.13 | 0.10 |
| | | 25 | | | | | | |
| | 50÷100 | 20÷25 | 30÷60 | | 0.25 | 0.20 | 0.15 | 0.13 |
| | 100÷200 | | | | | | | |
| | 200÷300 | 25 | | | | | | |
| Steel 900 N/mm² | 10÷50 | 20 | 20÷45 | 0.04÷0.08 | 0.15 | 0.10 | 0.08 | 0.06 |
| | | 25 | | | | | | |
| | 50÷100 | 20÷25 | 25÷50 | | 0.20 | 0.15 | 0.10 | 0.08 |
| | 100÷200 | | | | | | | |
| | 200÷300 | 25 | | | | | | |
| Stainless steel | 10÷50 | 20 | 20÷45 | 0.04÷0.08 | 0.15 | 0.10 | 0.08 | 0.06 |
| | | 25 | 25÷50 | | | | | |
| | 50÷100 | 20÷25 | 25÷50 | | 0.20 | 0.15 | 0.10 | 0.08 |
| | 100÷200 | | | | | | | |
| | 200÷300 | 25 | | | | | | |
| Cast steel | 10÷50 | 20 | 25÷45 | 0.05÷0.10 | 0.20 | 0.15 | 0.13 | 0.10 |
| | | 25 | | | | | | |
| | 50÷100 | 20÷25 | 30÷50 | | 0.25 | 0.20 | 0.15 | 0.13 |
| | 100÷200 | | | | | | | |
| | 200÷300 | 25 | 30÷50 | | | | | |
| Aluminium | 10÷50 | 20 | 30÷50 | 0.05÷0.10 | 0.20 | 0.15 | 0.10 | 0.06 |
| | | 25 | 35÷60 | | | | | |
| | 50÷100 | 20÷25 | 35÷60 | | 0.25 | 0.20 | 0.15 | 0.13 |
| | 100÷200 | | | | | | | |
| | 200÷300 | 25 | | | | | | |
| Brass | 10÷50 | 20 | 35÷55 | 0.05÷0.10 | 0.25 | 0.20 | 0.18 | 0.15 |
| | | 25 | | | | | | |
| | 50÷100 | 20÷25 | 40÷65 | | 0.30 | 0.25 | 0.20 | 0.18 |
| | 100÷200 | | | | | | | |
| | 200÷300 | 25 | | | | | | |

Table 1