





FORM KNURLING



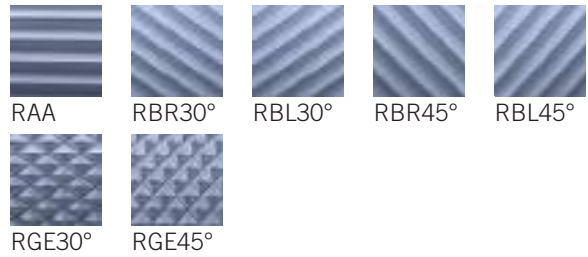
OVERVIEW OF FORM KNURLING

With the product finder for form knurling you can find your desired QUICK product even faster. You receive all relevant tool data, as well as possible profiles, the corresponding knurling wheels and the possible direction of machining at a glance.

Tool series	Workpiece Ø [mm]	Profile on workpiece	Profile on knurling wheel	
 <p>F711</p>	<p>2.5 – 24</p> <p>7 – 120</p>	<p>RAA RBR30° RBL30° RBR45° RBL45° RGE30° RGE45°</p>	<p>Single-wheel: 1 x AA 1 x BL30° 1 x BR30° 1 x BL45° 1 x BR45°</p>	<p>Double-wheel: 2 x AA 2 x BL30° 2 x BR30° 2 x BL45° 2 x BR45° 1 x BR30°/ 1 x BL30° 1 x BR45°/ 1 x BL45°</p>
 <p>F712 (B0)</p>	<p>3.5 – 50</p> <p>7 – 120</p>	<p>RAA RBR30° RBL30° RBR45° RBL45° RGE30° RGE45°</p>	<p>Single-wheel: 1 x AA 1 x BL30° 1 x BR30° 1 x BL45° 1 x BR45°</p>	<p>Double-wheel: 2 x AA 2 x BL30° 2 x BR30° 2 x BL45° 2 x BR45° 1 x BR30°/ 1 x BL30° 1 x BR45°/ 1 x BL45°</p>
 <p>F751</p>	<p>5 – 20</p> <p>0 – 15</p>	<p>RAA RBR30° RBL30° RBR45° RBL45° RGE30° RGE45°</p>	<p>2 x AA 2 x BL30° 2 x BR30° 2 x BL45° 2 x BR45° 1 x BR30° / 1 x BL30° 1 x BR45° / 1 x BL45°</p>	
 <p>F761</p>	<p>10 – 45</p>	<p>RAA RBR30° RBL30° RBR45° RBL45° RGE30° RGE45°</p>	<p>2 x AA 2 x BL30° 2 x BR30° 2 x BL45° 2 x BR45° 1 x BR30° / 1 x BL30° 1 x BR45° / 1 x BL45°</p>	
 <p>F791</p>	<p>1.8 – 20</p> <p>2.6 – 20</p>	<p>RAA RBR30° RBL30° RBR45° RBL45° RGE30° RGE45°</p>	<p>3 x AA 3 x BL30° 3 x BR30° 3 x BL45° 3 x BR45° 1 x BR30° / 2 x BL30° or 1 x BL30° / 2 x BR30° 1 x BR45° / 2 x BL45° or 1 x BL45° / 2 x BR45°</p>	
 <p>F792</p>	<p>2.6 – 20</p>	<p>RAA RBR30° RBL30° RBR45° RBL45° RGE30° RGE45°</p>	<p>3 x AA 3 x BL30° 3 x BR30° 3 x BL45° 3 x BR45° 1 x BR30° / 2 x BL30° or 1 x BL30° / 2 x BR30° 1 x BR45° / 2 x BL45° or 1 x BL45° / 2 x BR45°</p>	

Shank [mm]	Knurling wheel Ø [mm]	Knurling				
			RAA	RBL	RBR	RGE
10 / 12	10	Workpiece centre/without plunge cut (radial)	●	●	●	●
		Starting at workpiece beginning	●	●	●	●
		Starting in centre of workpiece/after plunge cut	●	●	●	●
20 / 25	20	Starting in centre of workpiece/without plunge cut	●	●	●	●
		Up to a shoulder	–	–	–	–
		Starting at workpiece beginning up to the collar	–	–	–	–
10 / 12	15	Workpiece centre/without plunge cut (radial)	●	●	●	●
		Starting at workpiece beginning	●	●	●	●
		Starting in centre of workpiece/after plunge cut	●	●	●	●
20 / 25	20	Starting in centre of workpiece/without plunge cut	●	●	●	●
		Up to a shoulder	●	●	●	●
		Starting at workpiece beginning up to the collar	●	●	●	●
12	10	Workpiece centre/without plunge cut (radial)	●	●	●	●
		Starting at workpiece beginning	●	●	●	●
		Starting in centre of workpiece/after plunge cut	●	●	●	●
		Starting in centre of workpiece/without plunge cut	●	●	●	●
	15	Up to a shoulder	–	–	–	–
		Starting at workpiece beginning up to the collar	–	–	–	–
20 / 25	20 / 25	Workpiece centre/without plunge cut (radial)	●	●	●	●
		Starting at workpiece beginning	●	●	●	●
		Starting in centre of workpiece/after plunge cut	●	●	●	●
		Starting in centre of workpiece/without plunge cut	●	●	●	●
		Up to a shoulder	–	–	–	–
		Starting at workpiece beginning up to the collar	–	–	–	–
Ø15 Ø20 Ø25	10	Workpiece centre/without plunge cut (radial)	–	–	–	–
		Starting at workpiece beginning	●	●	●	●
		Starting in centre of workpiece/after plunge cut	–	–	–	–
		Starting in centre of workpiece/without plunge cut	–	–	–	–
	15	Up to a shoulder	–	–	–	–
		Starting at workpiece beginning up to the collar	–	–	–	–
Ø15 Ø20 Ø25	15	Workpiece centre/without plunge cut (radial)	–	–	–	–
		Starting at workpiece beginning	●	●	●	●
		Starting in centre of workpiece/after plunge cut	–	–	–	–
		Starting in centre of workpiece/without plunge cut	–	–	–	–
		Up to a shoulder	–	–	–	–
		Starting at workpiece beginning up to the collar	●	●	●	●

FORM KNURLING TOOL F711



ADDED VALUES

- All common knurl profiles can be produced
- Single plus double roller system for maximum flexibility
- Firmly defined centre height
- Adjustment of alignment is possible


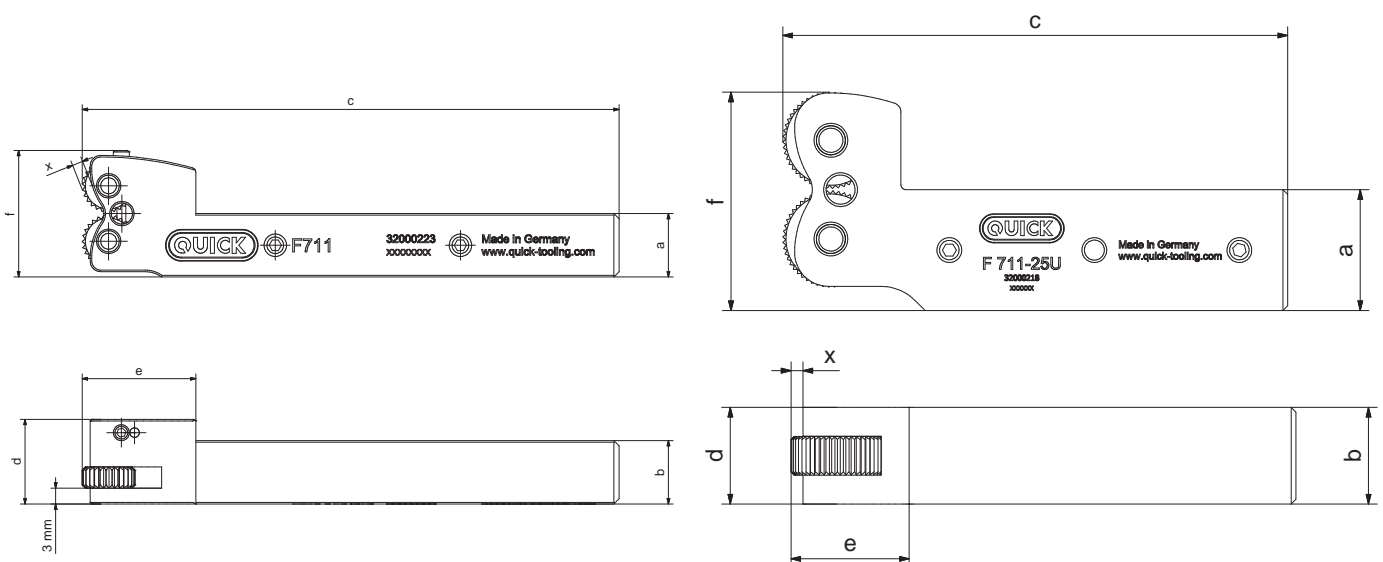
Order no.	Model	Workpiece \varnothing [mm]	Knurling wheel ($\varnothing \times w \times b$) [mm]	Dimensions [mm]						
				a	b	c	d	e	f	x
32000226	F711-10R	2.5 – 24	10 x 4 x 4	10	10	101.5	16.5	21.5	24	2
32000223	F711-12R	2.5 – 24	10 x 4 x 4	12	12	101.5	16.5	21.5	24	2
32000217	F711-20U	7 – 120	20 x 8 x 6	20	20	104.5	20	24.5	40.4	2.5
32000218	F711-25U	7 – 120	20 x 8 x 6	25	20	104.5	20	24.5	45.2	2.5

Left-hand version of shank dimensions 10 and 12 mm available on request.

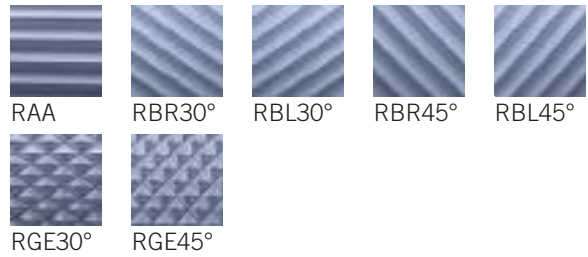
For the **single-wheel** use of this tool (shank size 10 or 12 mm) you may insert a knurling wheel measuring 15 x 4 x 4 mm. The maximum workpiece \varnothing is then extended to 50 mm.

SPARE PART

Order no.	Knurling wheel ($\varnothing \times w \times b$) [mm]
06TER1036	10 x 4 x 4
06TER0965	20 x 8 x 6

FORM KNURLING TOOL F712



ADDED VALUES


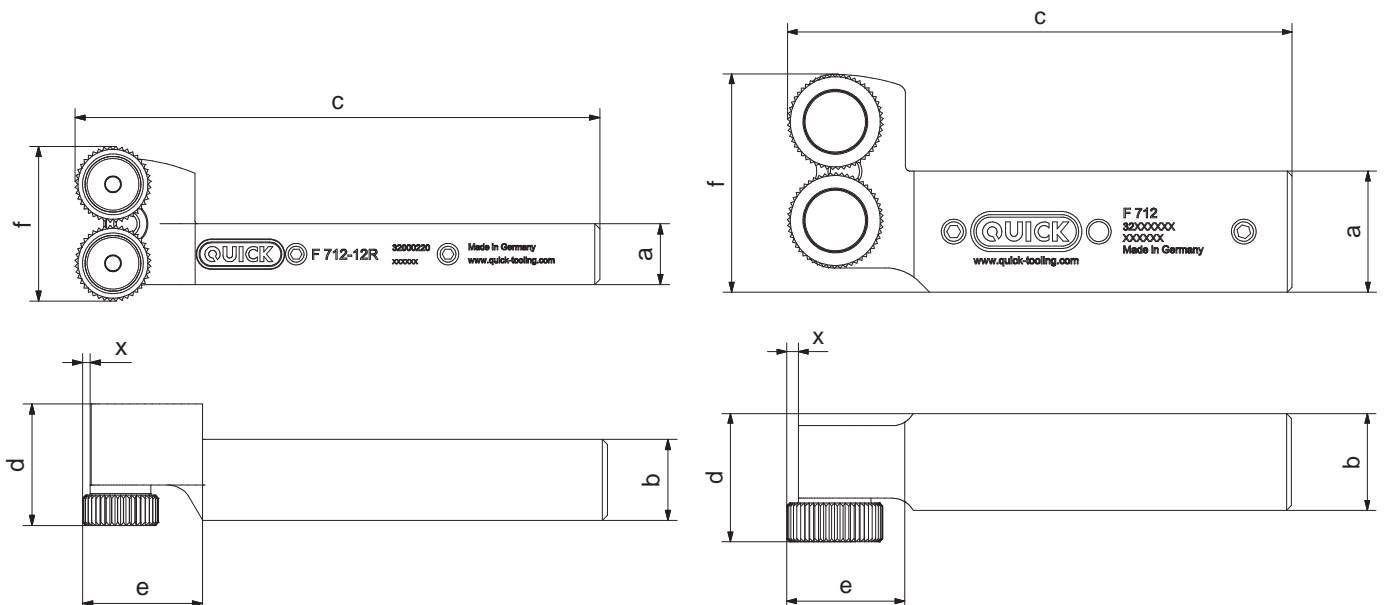
- Knurling up to a shoulder
- All common knurl profiles can be produced
- Single plus double roller system for maximum flexibility
- Firmly defined centre height
- Adjustment of alignment is possible

Order no.	Model	Workpiece \varnothing [mm]	Knurling wheel (\varnothing x w x b) [mm]	Dimensions [mm]						
				a	b	c	d	e	f	x
32000219	F712-10R	3.5 – 50	15 x 6 x 6A11	10	16	104.5	24	23,7	30.6	1.5
32000220	F712-12R	3.5 – 50	15 x 6 x 6A11	12	16	104.5	24	23,7	30.6	1.5
32000209	F712-20U	7 – 120	20 x 8 x 6A13	20	20	104.5	26.5	24.5	40.4	2.5
32000210	F712-25U	7 – 120	20 x 8 x 6A13	25	20	104.5	26.5	24.5	45.2	2.5

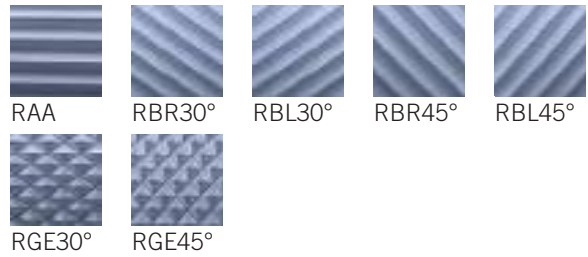
Left-hand version of shank dimensions 10 and 12 mm available on request.

E-KIT

Order no.	Knurling wheel (\varnothing x w x b) [mm]
22BHR0548	15 x 6 x 6A11
22BHR0538	20 x 8 x 6A13

FORM KNURLING TOOL F751




ADDED VALUES

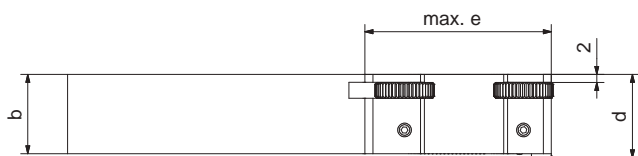
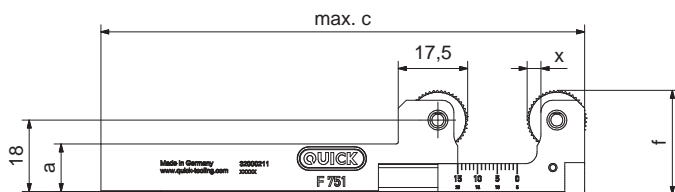
- High process stability due to tangential machining
- Special design for Swiss-type lathes
- Eliminates double workplace allocation in the slide unit
- User-friendly handling

Order no.	Model	Workpiece Ø [mm]	Knurling wheel (Ø x w x b) [mm]	Dimensions [mm]						
				a	b	c	d	e	f	x
32000211	F751-12R	5 – 20	10 x 4 x 4	12	20	max. 122	21	max. 47	26	1
		0 – 15	15 x 4 x 4							3.5

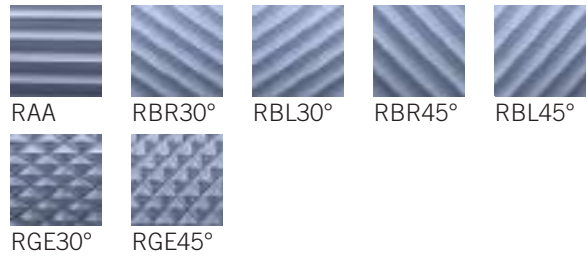
Left-hand version available on request.

SPARE PART

Order no.	
06TER0964	



FORM KNURLING TOOL F761



ADDED VALUES

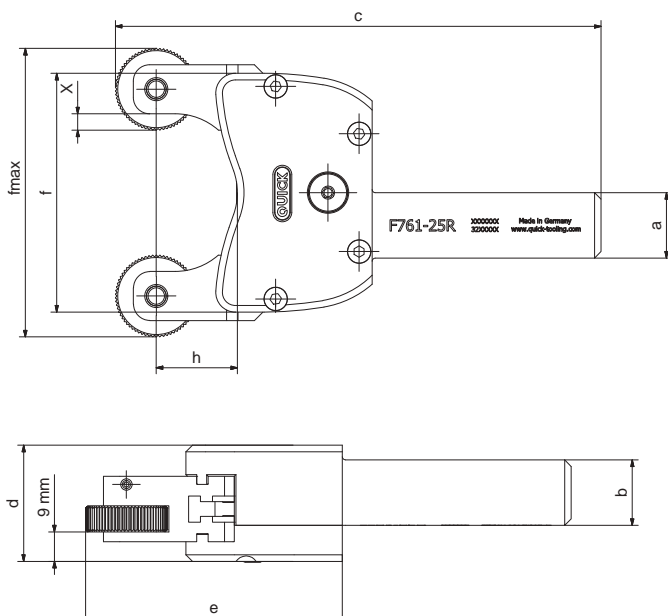
- High process stability due to tangential machining
- Knurl holders can be adjusted via synchronous spindle
- Force neutralisation due to tangential position

Order no.	Model	Workpiece Ø [mm]	Knurling wheel (Ø x w x b) [mm]	Dimensions [mm]								
				a	b	c	d	e	f	f max.	h	x
32000221	F761-20R	10 – 45	20 x 8 x 6	20	20	148.5	35.5	78.5	73	94	25	2.5
			25 x 8 x 6									5
32000225	F761-25R	10 – 45	20 x 8 x 6	25	25	148.5	35.5	78.5	73	94	25	2.5
			25 x 8 x 6									5

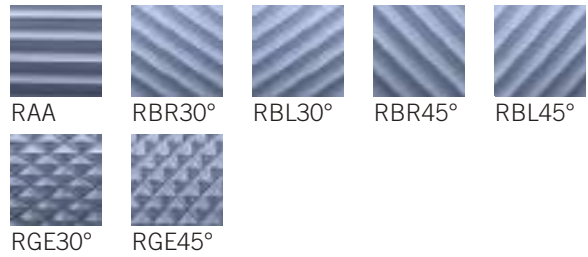
Left-hand version available on request.

SPARE PART

Order no.	
06TER0965	



FORM KNURLING TOOL F791



ADDED VALUES

- Knurl holders individually adjustable
- Maximum process stability
- All knurling processes can be used by exchanging the knurl holder jaws
- Suitable for very small installation spaces due to compact design
- Force reduction due to three-point machining

Order no.	Model	Workpiece Ø [mm]	Knurling wheel (Ø x w x b) [mm]	Dimensions [mm]						
				d max.	e	j	k	l	n max.	x
32000072	F791	1.8 – 20	10 x 4 x 4	75	53	20	54	16	32	1
		2.6 – 20	15 x 4 x 4							3.5

SPARE PART

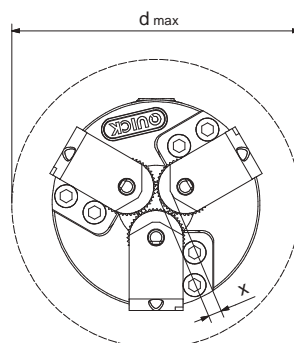
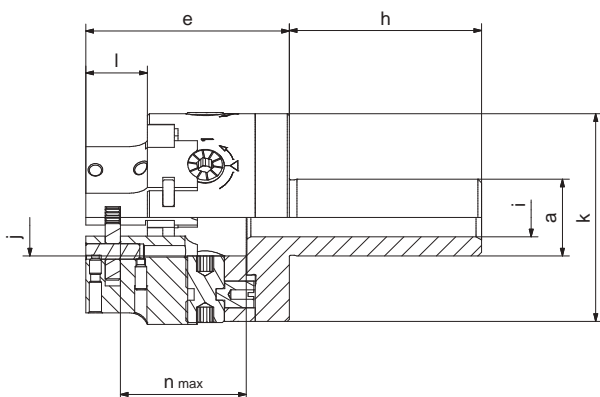
Order no.	
21BHR1306	

SHANK

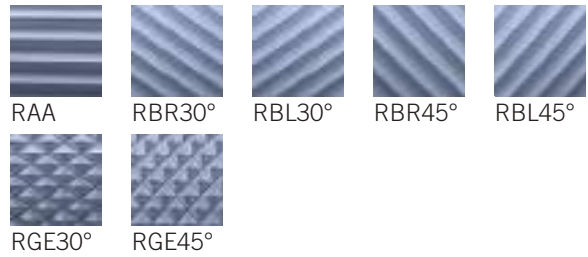
Order no.	Ø „a“ [mm]	Bore „i“ [mm]	Length „h“ [mm]	
22BHR0119	15	9	50	
22BHR0121	20	10	50	
22BHR0122	25	15	50	

JAWS

Order no.	Description	Tool	
22BHR0537	Form knurling up to a shoulder	F792	
22BHR0536	Cut knurling	C693	



FORM KNURLING TOOL F792




ADDED VALUES


- Knurl holders individually adjustable
- Maximum process stability
- All knurling processes can be used by exchanging the knurl holder jaws
- Suitable for very small installation spaces due to compact design
- Knurling up to a shoulder

Order no.	Model	Workpiece Ø [mm]	Knurling wheel (Ø x w x b) [mm]	Dimensions [mm]						
				d max.	e	j	k	l	n max.	x
32000206	F792	2.6 – 20	15 x 6 x 6A11	75	54	20	54	17	37	1.5


E-KIT

Order no.	
22BHR0548	

SHANK

Order no.	Ø „a“ [mm]	Bore „i“ [mm]	Length „h“ [mm]	
22BHR0119	15	9	50	
22BHR0121	20	10	50	
22BHR0122	25	15	50	

JAWS

Order no.	Description	Tool	
22BHR0490	Form knurling	F791	
22BHR0536	Cut knurling	C693	

