

F1-L

QUICK FORM KNURLING TOOLS

The modular design for conversion to alternative shank sizes offers a cost-efficient application of this tool on conventional and CNC lathes. The knurling profile may start at any position of the workpiece. All knurling profiles are producible *. The F1-L can optionally be equipped with the new QUICK-CHANGE-SYSTEM which makes the change of the knurling wheels even faster and easier.

EXAMPLE:

Model No. **F1-L 08 R 260/265 QC**

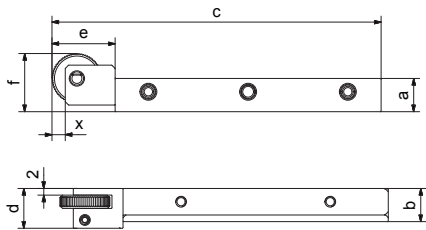
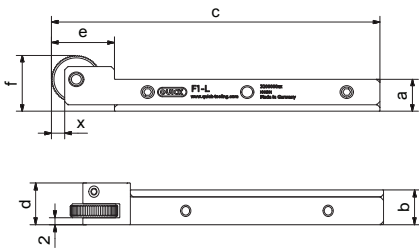
Product series
Shank size 8 x 8 mm
Right-hand use
Quick Change
Article no. for knurling wheels
15 x 4 x 4 (Ø x width x bore)
Article no. for knurling wheels
10 x 4 x 4 (Ø x width x bore)



MODEL	PROD.-NO.	WORKPIECE Ø	KNURLING WHEEL mm (Ø x width x bore)
F1-L08L260 / 265	P112-0200	3 - 50	10 / 15 x 4 x 4*
F1-L08R260 / 265	P112-0201	3 - 50	10 / 15 x 4 x 4*
F1-L10L260 / 265	P112-0202	3 - 50	10 / 15 x 4 x 4*
F1-L10R260 / 265	P112-0203	3 - 50	10 / 15 x 4 x 4*
F1-L12L260 / 265	P112-0204	3 - 50	10 / 15 x 4 x 4*
F1-L12R260 / 265	P112-0205	3 - 50	10 / 15 x 4 x 4*
F1-L16L260 / 265	P112-0206	3 - 50	10 / 15 x 4 x 4*
F1-L16R260 / 265	P112-0207	3 - 50	10 / 15 x 4 x 4*
F1-L08L260 / 265QC	P112-0208	3 - 50	10 / 15 x 4 x 4*
F1-L08R260 / 265QC	P112-0209	3 - 50	10 / 15 x 4 x 4*
F1-L10L260 / 265QC	P112-0210	3 - 50	10 / 15 x 4 x 4*
F1-L10R260 / 265QC	P112-0211	3 - 50	10 / 15 x 4 x 4*
F1-L12L260 / 265QC	P112-0212	3 - 50	10 / 15 x 4 x 4*
F1-L12R260 / 265QC	P112-0213	3 - 50	10 / 15 x 4 x 4*
F1-L16L260 / 265QC	P112-0214	3 - 50	10 / 15 x 4 x 4*
F1-L16R260 / 265QC	P112-0215	3 - 50	10 / 15 x 4 x 4*

a	b	c*	d	e*	f*	x*
8	8	99	12	19	15,5	4
8	8	99	12	19	15,5	4
10	10	99	12	19	17,5	4
10	10	99	12	19	17,5	4
12	12	99	12	19	19,5	4
12	12	99	12	19	19,5	4
16	16	99	12	19	23,5	4
16	16	99	12	19	23,5	4
8	8	99	12	19	15,5	4
8	8	99	12	19	15,5	4
10	10	99	12	19	17,5	4
10	10	99	12	19	17,5	4
12	12	99	12	19	19,5	4
12	12	99	12	19	19,5	4
16	16	99	12	19	23,5	4
16	16	99	12	19	23,5	4

*DETAILS ABOUT KNURLING WHEELS (WHEEL PITCHES, TOOTH ANGLE ETC.) ARE LISTED ON PAGE 40/41.



RIGHT-HAND TOOL SHOWN
CUTTING SPEED AND FEED RATE INFORMATION, PAGE 43:

RAA (Straight):

1 knurling wheel (forming) 90° (AA)

RGE45° (Cross):

1 knurling wheel (forming) 45° GV

RGE30° (Diamond):

1 knurling wheel (forming) 30° GV

RBR 30° / 45° (Spiral):

1 knurling wheel (forming) 30° / 45° L

RBL 30° / 45° (Spiral):

1 knurling wheel (forming) 30° / 45° R

* Plunge knurling:
Feed knurling:

suitable for all knurling profiles
suitable for RAA, RBL, RBR

