

F1-M

QUICK FORM KNURLING TOOLS

The F1-M is suitable for all conventional and CNC lathes. High efficiency and easy handling are the main features of this tool. The knurling profile may start at any position of the workpiece, all knurling profiles are possible.



EXAMPLE:

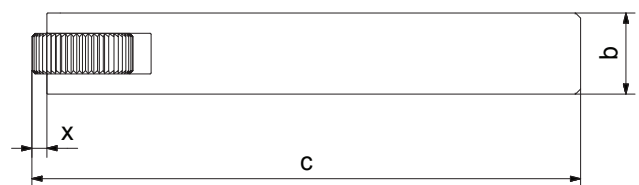
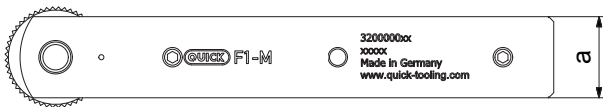
Model No. **F1-M 08 U 260 / 265**

Product series **F1-M** Article no. for knurling wheels
Shank size 8 x 8 mm **08** 15 x 4 x 4 (Ø x width x bore)
Right- and left- hand use **U** Article no. for knurling wheels
260 / 265 10 x 4 x 4 (Ø x width x bore)

MODEL	PROD.-NO.	WORKPIECE Ø	KNURLING WHEEL mm (Ø x width x bore)
F1-M08U260 / 265	P100-0200	3 - 20	10 / 15 x 4 x 4*
F1-M08U261 / 266	P100-0201	3 - 20	10 / 15 x 6 x 4*
F1-M10U260 / 265	P100-0202	3 - 20	10 / 15 x 4 x 4*
F1-M10U261 / 266	P100-0203	3 - 20	10 / 15 x 6 x 4*
F1-M10U290 / 296	P100-0204	15 - 200	20 / 25 x 8 x 6*
F1-M12U260 / 265	P100-0205	3 - 20	10 / 15 x 4 x 4*
F1-M12U291 / 295	P100-0206	15 - 200	20 / 25 x 6 x 6*
F1-M12U290 / 296	P100-0207	15 - 200	20 / 25 x 8 x 6*
F1-M14U261 / 266	P100-0208	3 - 20	10 / 15 x 6 x 4*
F1-M14U291 / 295	P100-0209	15 - 200	20 / 25 x 6 x 6*
F1-M16U290 / 296	P100-0210	15 - 200	20 / 25 x 8 x 6*
F1-M20U292 / 297	P100-0211	15 - 200	20 / 25 x 10 x 6*
F1-M20U293 / 298	P100-0212	15 - 200	20 / 25 x 15 x 6*

a	b	c	x
8	8	99*	4*
8	8	99*	4*
10	10	99*	4*
10	10	99*	4*
10	10	110,5*	5,5*
12	12	99*	4*
12	12	110,5*	5,5*
12	12	110,5*	5,5*
14	14	99*	4*
14	14	110,5*	5,5*
16	16	110,5*	5,5*
20	20	110,5*	5,5*
20	25	110,5*	5,5*

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



TOOL SHOWN «RIGHT-/LEFT-HAND USE»
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