

# F1-S

## QUICK FORM KNURLING TOOLS

The F1-S is designed for application on conventional and CNC short turning and multispindle automatic lathes. High efficiency and easy handling are the main features of this tool. The knurling profile can start at any position of the workpiece, all knurling profiles are possible\*. The F1-S may, as well as the F1-L, optionally be equipped with the QUICK-CHANGE-SYSTEM.

### EXAMPLE:

Model No. **F1-S 20 U 290 / 296 QC**

Product series **F1-S**  
Shank size 20 x 20 mm  
Right- and left- hand use **U**  
Article no. for knurling wheels 25 x 8 x 6 (Ø x width x bore)  
Article no. for knurling wheels 20 x 8 x 6 (Ø x width x bore)  
Quick Change **QC**

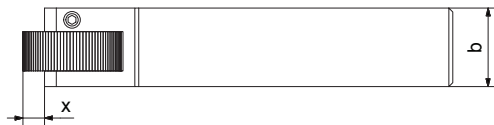
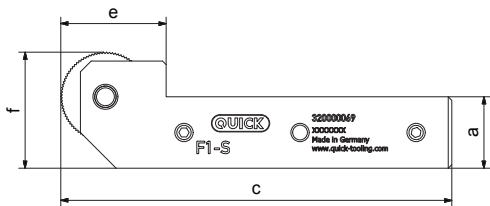


MODEL	PROD.-NO.	WORKPIECE Ø	KNURLING WHEEL mm (Ø x width x bore)
<b>F1-S20U290 / 296</b>	P124-0200	8 - 200 mm	20 / 25 x 8 x 6*
<b>F1-S25U290 / 296</b>	P124-0201	8 - 200 mm	20 / 25 x 8 x 6*
<b>F1-S20U290 / 296QC</b>	P124-0202	8 - 200 mm	20 / 25 x 8 x 6*
<b>F1-S25U290 / 296QC</b>	P124-0203	8 - 200 mm	20 / 25 x 8 x 6*

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

a	b	c*	d	e*	f*	x*
20	20	109,5	-	29,5	32,5	5,5
25	20	109,5	-	29,5	37,5	5,5
20	20	109,5	-	29,5	32,5	5,5
25	20	109,5	-	29,5	37,5	5,5

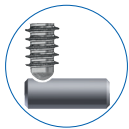
\*WITH KNURLING WHEEL DIAMETER 25 mm



TOOL SHOWN «RIGHT-/LEFT-HAND USE»  
CUTTING SPEED AND FEED RATE INFORMATION, PAGE 43:

**NEW**

### QUICK-CHANGE-SYSTEM:



For fast and safe change of the knurling wheel:

- No more break off through overtightening
- No more loosening through impact, hits or vibration
- Quick change and positioning of the knurling wheel

#### 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