

F2MPS-S

QUICK FORM KNURLING TOOLS

The F2MPS-S combines the estimated features of the F2MP-S with the possibility of knurling up to a shoulder. As well designed for conventional and CNC short turning and multispindle automatic lathes it is available as version for star turret on request. An extension of the working area up to 65 mm is possible by swapping the jaws and mounting them with crank outward. Further advantages: conversion on various shank sizes and the material protecting machining process with two knurl holders.



EXAMPLE:

Model No. **F2MPS-S 16 R 289 VS**

Product series: F2MPS-S
 Shank size 16 x 16 mm: 16
 Right-hand use: R
 Version Star Turret: VS
 Article no. for knurling wheels: 289 (20 x 8 x 6/13 (Ø x width x bore))

MODEL	PROD.-NO.	WORKPIECE Ø	KNURLING WHEEL mm (Ø x width x bore)
F2MPS-S16M289	P196-0200	3,5 - 65 mm	20 x 8 x 6/13*
F2MPS-S20M289	P196-0201	3,5 - 65 mm	20 x 8 x 6/13*
F2MPS-S25M289	P196-0202	3,5 - 65 mm	20 x 8 x 6/13*
F2MPS-S16R/L289VS	P196-0203	3,5 - 65 mm	20 x 8 x 6/13*
F2MPS-S20R/L289VS	P196-0204	3,5 - 65 mm	20 x 8 x 6/13*
F2MPS-S25R/L289VS	P196-0205	3,5 - 65 mm	20 x 8 x 6/13*

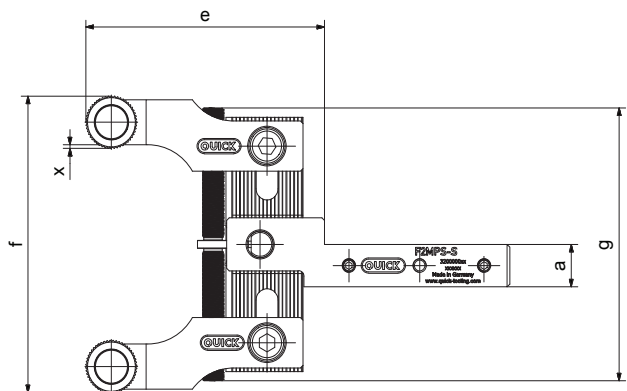
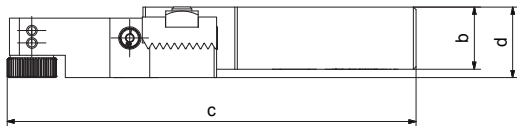
a	b	c	d	e	f	g	x
16	25	164,8	28,4	92,8	114	103	1,5
20	25	164,8	28,4	92,8	114	103	1,5
25	25	164,8	28,4	92,8	114	103	1,5
16	16	96,8	50,4	43,5	114	103	1,5
20	20	96,8	50,4	43,5	114	103	1,5
25	25	96,8	50,4	43,5	114	103	1,5

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

NEW


START TURRET VERSION (VS):

The start turret version (-VS) are to be ordered separately for right- or left-handed machines.




RIGHT-HAND TOOL SHOWN (usable as left-hand tool by turning the knurling head)
 CUTTING SPEED AND FEED RATE INFORMATION, PAGE 43:


RAA (Straight):

 2 knurling wheels (forming) 90° (AA)

RGE45° (Cross):

 1 knurling wheel (forming) 45°L
 1 knurling wheel (forming) 45°R

RGE30° (Diamond):

 1 knurling wheel (forming) 30°L
 1 knurling wheel (forming) 30°R

