

Cut knurling – cutting process



Knurling wheels, milled, without chamfer – PM

Standard variants	Profile		Dimension [mm]			Pitches [mm]
			Ø	Width	Bore	
No. 16	AA		8.9	2.5	4	○
No. 16			10	3	6	○
No. 16			14.5	3	5	■
No. 16			15	4	8	○
No. 16			21.5	5	8	■
No. 16			25	6	8	■
No. 16	BL	15°	10	3	6	◆
No. 16			15	4	8	□
No. 16			21.5	5	8	□
No. 16	BL	30°	25	6	8	■
No. 16			10	3	6	◆
No. 16			14.5	3	5	◆
No. 16			15	4	8	○
No. 16	BR	15°	21.5	5	8	□
No. 16			25	6	8	■
No. 16			10	3	6	◆
No. 16	BR	30°	15	4	8	□
No. 16			14.5	3	5	◆
No. 16			15	4	8	○
No. 16			21.5	5	8	□
No. 16			25	6	8	■

Standard pitches/profile angle 90°

- 0.3/0.4/0.5/0.6/0.7/0.8/1.0/1.2/1.5/1.6/2.0
- 0.3/0.4/0.5/0.6/0.7/0.8/1.0/1.2/1.5
- 0.5/0.6/0.7/0.8/1.0/1.2/1.5/2.0
- 0.5/0.6/0.8/1.0/1.2/1.5
- ◆ 0.5/0.6/0.8/1.0
- ☑ On request

Other variants available on request

Variants

Knurling wheel variants (PM)

N°	Version
18	milled, with 10° chamfer
35	ground, without chamfer
37	ground with 10° chamfer

Knurling wheel variants (HSS)

N°	Version
15	milled, without chamfer
17	milled, with 10° chamfer

Knurling wheel variants (HM)

N°	Version
55	ground, without chamfer
57	ground with 10° chamfer

Form knurling – with 10° chamfer

When cutting knurling profiles with a larger pitch in the axial machining direction it can be advantageous to apply a 10° chamfer to the knurling wheel.

For wheel geometries, see "Technology" on page 44