

Feed parameters and cutting speed for knurling

Feed parameters and cutting speed for knurling FOR CUTTING

Material	ø knurling					
	8,9/10 mm		14,5/15 mm		21,5 mm	
	Vc (m/min)	S (mm/giro)	Vc (m/min)	S (mm/giro)	Vc (m/min)	S (mm/giro)
Steel < 850 N/mm ²	35	0,05-0,08	40-45	0,07-0,09	55-60	0,07-0,14
Steel < 1000 N/mm ²	25	0,04-0,07	30-35	0,06-0,08	25-50	0,06-0,12
Steel < 1400 N/mm ²	25	0,04-0,07	30-35	0,06-0,08	40-50	0,06-0,12
Stainless steel	22	0,04-0,06	28-30	0,06-0,08	32-40	0,06-0,12
Alu < 8% Si	70	0,06-0,13	70-80	0,08-0,18	100-120	0,1-0,25
Cast iron	22	0,04-0,06	28-30	0,06-0,08	32-40	0,06-0,12
Copper Brass	50	0,05-0,09	50-60	0,06-0,1	60-80	0,06-0,12

Feed parameters and cutting speed for knurling FOR FORMING

Material	ø knurling					
	10 mm		15 mm		20 mm	
	Vc (m/min)	S (mm/giro)	Vc (m/min)	S (mm/giro)	Vc (m/min)	S (mm/giro)
Steel < 850 N/mm ²	15-45	0,04-0,08	20-50	0,04-0,08	25-55	0,05-0,1
Steel < 1000 N/mm ²	15-40	0,04-0,08	20-40	0,04-0,08	25-50	0,05-0,1
Steel < 1400 N/mm ²	15-35	0,04-0,08	20-40	0,04-0,08	25-40	0,05-0,1
Stainless steel	10-35	0,04-0,08	15-40	0,04-0,08	20-50	0,05-0,1
Alu < 8% Si	20-55	0,04-0,08	25-60	0,04-0,08	30-65	0,05-0,1
Copper Brass	25-60	0,04-0,08	25-70	0,04-0,08	30-85	0,05-0,1



Simple chipping knurling tool

Simple knurling tool for chipping knurling (mod. C601), support in hardened steel, can be used for longitudinal knurling according to DIN 82.

Easy adjustment of the tool head.

Type of machine: automatic and small lathes, CNC and conventional, designed for small diameter pieces.

Supplied without knurling tool.



CNC



Code	€	Working range ø (mm)	Stem (mm)	Stem length (mm)	Knurling tool size (mm)
A899290001	—	1,5-12	10x10	88	8,9x2,5x4

Code	€	Working range ø (mm)	Stem (mm)	Stem length (mm)	Knurling tool size (mm)
A899290003	—	1,5-12	12x12	88	8,9x2,5x4



Double chipping knurling tool

Double knurling device for chipping knurling (mod. C602 10R), support in hardened steel, can be used for longitudinal knurling according to DIN 82.

Easy adjustment of the tool head.

Machine type: automatic and small lathes, CNC and conventional, designed for small diameter pieces.

Supplied without knurling tool.



CNC



Code	€	Working range ø (mm)	Stem (mm)	Stem length (mm)	Knurling tool size (mm)
A899290005	—	1,5-12	10x10	76,6	8,9x2,5x4

Code	€	Working range ø (mm)	Stem (mm)	Stem length (mm)	Knurling tool size (mm)
A899290007	—	1,5-12	12x12	76,6	8,9x2,5x4