

A close-up, low-angle photograph of a metal part with a knurled surface. The lighting is dramatic, highlighting the texture of the knurling and the smooth surface of the part. The background is dark, making the metallic surfaces stand out.

zeus
Cut knurling
tools



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THE TOOLING SPECIALISTS FOR PRECISION COMPONENT MACHINING

Cut knurling tools RF1

Perfect efficiency due to modular design, convincing process reliability due to sturdy construction



Series 231



Tool holder Designation 231-10 M 150408-VS-A

- Product series: 231
- Shank size 10 x 10 mm: 10
- Modular: M
- Design for knurling wheels 15 x 4 x 8 (Ø x width x bore): 150408
- State of development: VS
- Solid shank: A

Knurling profiles on DIN 82 workpiece:
Feed knurling



Selection of knurling wheels:

1 x BR30° (right-hand use)	1 x AA (left-hand use)	1 x AA (right-hand use)
1 x BL30° (left-hand use)		

Product features:

- Scaling and positioning aids
- Adjusting spindle for fine adjustment of the knurl profile
- Set screws in shank for clearance angle correction
- Coated carbide bearing bushes for improved antifrictional property
- Modular shank design: Shank size 10 x 10 mm optionally adaptable

TOOL VERSIONS:

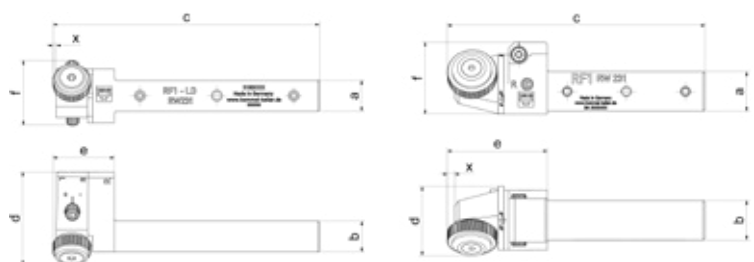
Order no.	Tool holder Designation	Working area Ø [mm]	Dimension [mm]						Knurling wheels (Ø x w x b) [mm]
			a	b	c	d	e	f	
31002739	231-10M150408-VS-A	3-50	10	10	103.9	36.2	23.9	25.3	15 x 4 x 8
31002740	231-12M150408-VS-A	3-50	12	12	103.9	36.2	23.9	25.3	15 x 4 x 8
31002741	231-16M150408-VS-A	3-50	16	16	103.9	36.2	23.9	26.8	15 x 4 x 8

Order no.	Tool holder Designation	Working area Ø [mm]	Dimension [mm]						Knurling wheels (Ø x w x b) [mm]
			a	b	c	d	e	f	
31002652	231-20M250608-B	10-300	20	20	130.8	35	50.8	36.5	25 x 6 x 8
31002445	231-25M250608-B	10-300	25	25	130.8	35	50.8	40	25 x 6 x 8

Other variants available on request

ADAPTER BRACKET FOR BASE SHANK 10 x 10 mm:

Order no.	Shank size [mm]
21BHR1653	12 x 12
21BHR1654	16 x 16



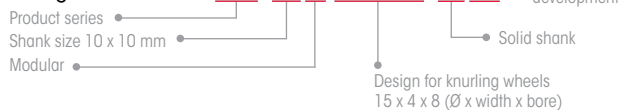
Cut knurling tools RF2

Excellent for stringent requirements –
convincing stability in harsh continuous use

Series 241



Tool holder
Designation



Knurling profiles on DIN 82 workpiece:

Feed knurling



RGE30° | RGE45°

Selection of knurling wheels:

2 x AA | 1 x BL15° / 1 x BR15°

Product features:

- Modular design: Tool can be used as right-hand and left-hand version. Retooling by simply turning the cut knurling head
- Conversion to alternative full shank dimensions is possible
- Modular shank design: Shank size 10 x 10 mm optionally adaptable
- Fine adjustment of centre height of the cut knurling head
- Fine adjustment of the clearance angle by means of synchronous adjustment spindle
- Coated carbide bearing bushes for improved antifrictional property
- Vertical height adjustment for use of shank size 20 mm on 25 mm (version 241-20M250608-A1)

TOOL VERSIONS:

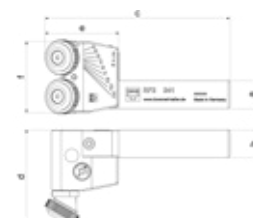
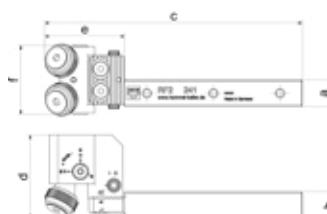
Order no.	Tool holder Designation	Working area Ø [mm]	Dimension [mm]						Knurling wheels (Ø x w x b) [mm]
			a	b	c	d	e	f	
31001926	241-10M150408-VS-A	3-50	10	10	116	36.7	36	31	15 x 4 x 8
31001901	241-12M150408-VS-A	3-50	12	12	116	37.7	36	31	15 x 4 x 8
31001945	241-16M150408-VS-A	3-50	16	16	116	39.7	36	31	15 x 4 x 8

Other variants available on request

Order no.	Tool holder Designation	Working area Ø [mm]	Dimension [mm]						Knurling wheels (Ø x w x b) [mm]
			a	b	c	d	e	f	
31000804	241-20M150408-A	3-50	20	20	116	44.7	36	35.6	15 x 4 x 8
31000666	241-20M250608-A1	10-250	20	20	133.3	68	53.3	53	25 x 6 x 8
31001899	241-25M250608-A1	10-250	25	20	133.3	68	53.3	53	25 x 6 x 8

ADAPTER BRACKET FOR BASE SHANK 10 x 10 mm:

Order no.	Shank size [mm]
21BHR1653	12 x 12
21BHR1654	16 x 16



Cut knurling tool RF3

Maximum stability for exact precision – ideal for thin-walled workpieces



Series 291



Knurling profiles on DIN 82 workpiece:
Feed knurling

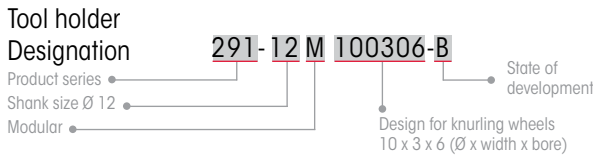


Selection of knurling wheels:

3 x AA | 1 x BL15° / 2 x BR15° or
1 x BR15° / 2 x BL15°

Product features:

- Easy and precise fine adjustment
- Modular exchangeable knurl holder jaws for conversion to a form knurling tool 191 / 192 (knurling up to a shoulder)
- Coated carbide bearing bushes for improved antifrictional property



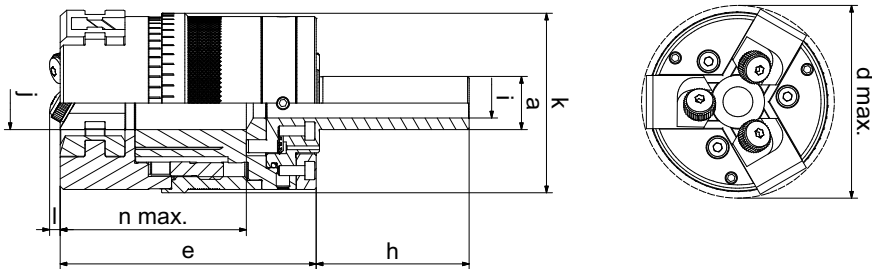
TOOL VERSIONS:

Order no.	Tool holder Designation	Working area Ø [mm]	Dimension [mm]										Knurling wheels (Ø x w x b) [mm]
			a Ø	d max. Ø	e	h	i Ø	j Ø	k Ø	l	n max.	x Ø	
31001946	291-12M100306-B	3.5-13.5	12	57	78	45	9	16	54	3	56	1	10 x 3 x 6

Other variants available on request

d = for max. workpiece Ø

n = max. workpiece length (with Ø)



JAWS:

Order no. Form knurling	Order no. Cut knurling up to a shoulder
21BHR1096	21BHR1128



Cut knurling tools SETS

Best efficiency in combination –
the perfect standard equipment

Set 200-12



SET consisting of:

- 1 x tool: 231
- 6 x knurling wheel:
15 x 4 x 8 mm
- 3 x profile: BL30°
- 3 x profile: BR30°
- Pitches: 0.5/0.6/0.8 mm



- 1 x tool: 241
- 6 x knurling wheel:
15 x 4 x 8 mm
- 6 x profile: AA
- Pitches: 0.5/0.6/0.8 mm

Knurling profiles on DIN 82 workpiece for tool 231:

Feed knurling



Selection of knurling wheels:

1 x BR30° (right-hand use)	1 x AA (left-hand use)	1 x AA (right-hand use)
1 x BL30° (left-hand use)		

Knurling profiles on DIN 82 workpiece for tool 241:

Feed knurling



Selection of knurling wheels:

2 x AA

TOOL VERSIONS:

Order no. Set	Order no. Holder	Tool holder Designation	Working area Ø [mm]	Dimension [mm]						Knurling wheels (Ø x b x b) [mm]
				a	b	c	d	e	f	
31002697	31002740	231-12M150408-VS-A	3-50	12	12	103.9	36.2	23.9	25.3	15 x 4 x 8
	31001901	241-12M150408-VS-A	3-50	12	12	116	37.7	36	31	15 x 4 x 8

Set 200-16



SET consisting of:

- 1 x tool: 231
- 6 x knurling wheel:
15 x 4 x 8 mm
- 3 x profile: BL30°
- 3 x profile: BR30°
- Pitches: 0.6/0.8/1.0 mm



- 1 x tool: 241
- 6 x knurling wheel:
15 x 4 x 8 mm
- 6 x profile: AA
- Pitches: 0.6/0.8/1.0 mm

Knurling profiles on DIN 82 workpiece for tool 231:

Feed knurling



Selection of knurling wheels:

1 x BR30° (right-hand use)	1 x AA (left-hand use)	1 x AA (right-hand use)
1 x BL30° (left-hand use)		

Knurling profiles on DIN 82 workpiece for tool 241:

Feed knurling



Selection of knurling wheels:

2 x AA

TOOL VERSIONS:

Order no. Set	Order no. Holder	Tool holder Designation	Working area Ø [mm]	Dimension [mm]						Knurling wheels (Ø x b x b) [mm]
				a	b	c	d	e	f	
31002698	31002741	231-16M150408-VS-A	3-50	16	16	103.9	36.2	23.9	26.8	15 x 4 x 8
	31001945	241-16M150408-VS-A	3-50	16	16	116	39.7	36	31	15 x 4 x 8

Cut knurling tools SETS



Set 200-20



SET consisting of:

- 1 x tool: 231
- 6 x knurling wheel: 25 x 6 x 8 mm
- 3 x profile: BL30°
- 3 x profile: BR30°
- Pitches: 0.8/1.0/1.5 mm



- 1 x tool: 241
- 6 x knurling wheel: 25 x 6 x 8 mm
- 6 x profile: AA
- Pitches: 0.8/1.0/1.5 mm

TOOL VERSIONS:

Order no. Set	Order no. Holder	Tool holder Designation	Working area Ø [mm]	Dimension [mm]						Knurling wheels (Ø x b x b) [mm]
				a	b	c	d	e	f	
31002699	31002652	231-20M250608-B	10-300	20	20	130.8	35	50.8	36.5	25 x 6 x 8
	31000666	241-20M250608-A1	10-250	20	20	133.3	68	53.3	53	25 x 6 x 8

Knurling profiles on DIN 82 workpiece for tool 231:

Feed knurling



Selection of knurling wheels:

1 x BR30° (right-hand use)	1 x AA (left-hand use)	1 x AA (right-hand use)
1 x BL30° (left-hand use)		

Knurling profiles on DIN 82 workpiece for tool 241:

Feed knurling



Selection of knurling wheels:

2 x AA

Set 200-25



SET consisting of:

- 1 x tool: 231
- 6 x knurling wheel: 25 x 6 x 8 mm
- 3 x profile: BL30°
- 3 x profile: BR30°
- Pitches: 0.8/1.0/1.5 mm



- 1 x tool: 241
- 6 x knurling wheel: 25 x 6 x 8 mm
- 6 x profile: AA
- Pitches: 0.8/1.0/1.5 mm

Knurling profiles on DIN 82 workpiece for tool 231:

Feed knurling



Selection of knurling wheels:

1 x BR30° (right-hand use)	1 x AA (left-hand use)	1 x AA (right-hand use)
1 x BL30° (left-hand use)		

Knurling profiles on DIN 82 workpiece for tool 241:

Feed knurling



Selection of knurling wheels:

2 x AA

TOOL VERSIONS:

Order no. Set	Order no. Holder	Tool holder Designation	Working area Ø [mm]	Dimension [mm]						Knurling wheels (Ø x b x b) [mm]
				a	b	c	d	e	f	
31002700	31002445	231-25M250608-B	10-300	25	25	130.8	35	50.8	40	25 x 6 x 8
	31001899	241-25M250608-A1	10-250	25	20	133.3	68	53.3	53	25 x 6 x 8