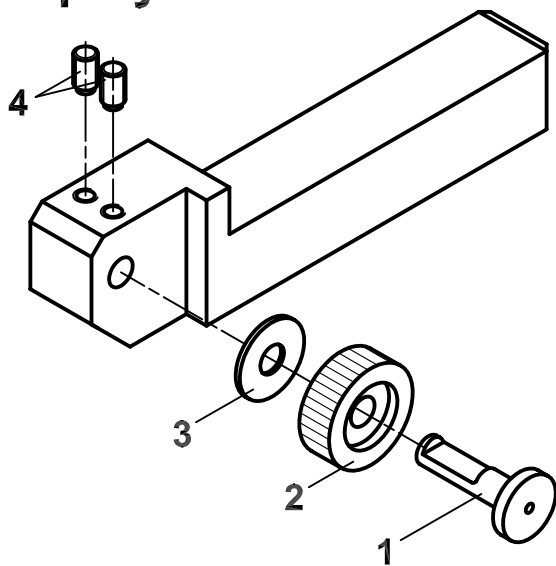


Assembly instruction for knurling tool series:

RW 132, RW 142, RW 162 and RW 311.

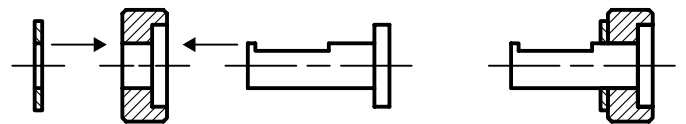
Assembly of knurling wheels and adjustment of the axial end-play.



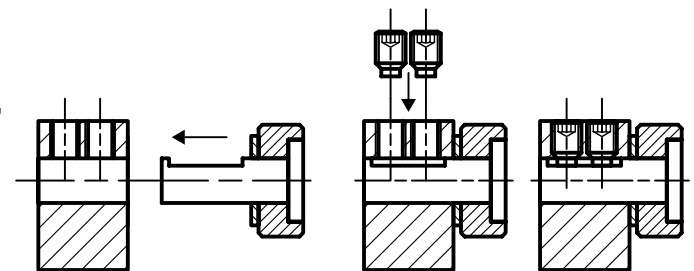
Description of the parts:

1. Bolt (pin) with plane face
2. Knurling wheel
3. Running disk
(Not part of all RW 311)
4. Pivot point set screw
(or set screw for RW 311 series)

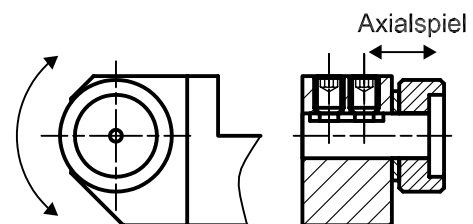
Link bolt, knurling wheel and running disk. Make sure to lubricate all running faces with lubricating grease.



Assemble part 1,2 and 3 in the tool holder, so that the plane face of the bolt faces the thread. Screw in and tighten the pivot point screw (4) carefully.



Press the bolt against the tool holder, so that the axial end-play between knurling wheel and tool holder is minimal, but the knurling wheel can still be turned manually.



Tighten the pivot point screws (set screws) (4). In order to increase tool life of knurling wheel and bolt during the knurling process, ensure a sufficient supply of cooling and lubrication.

