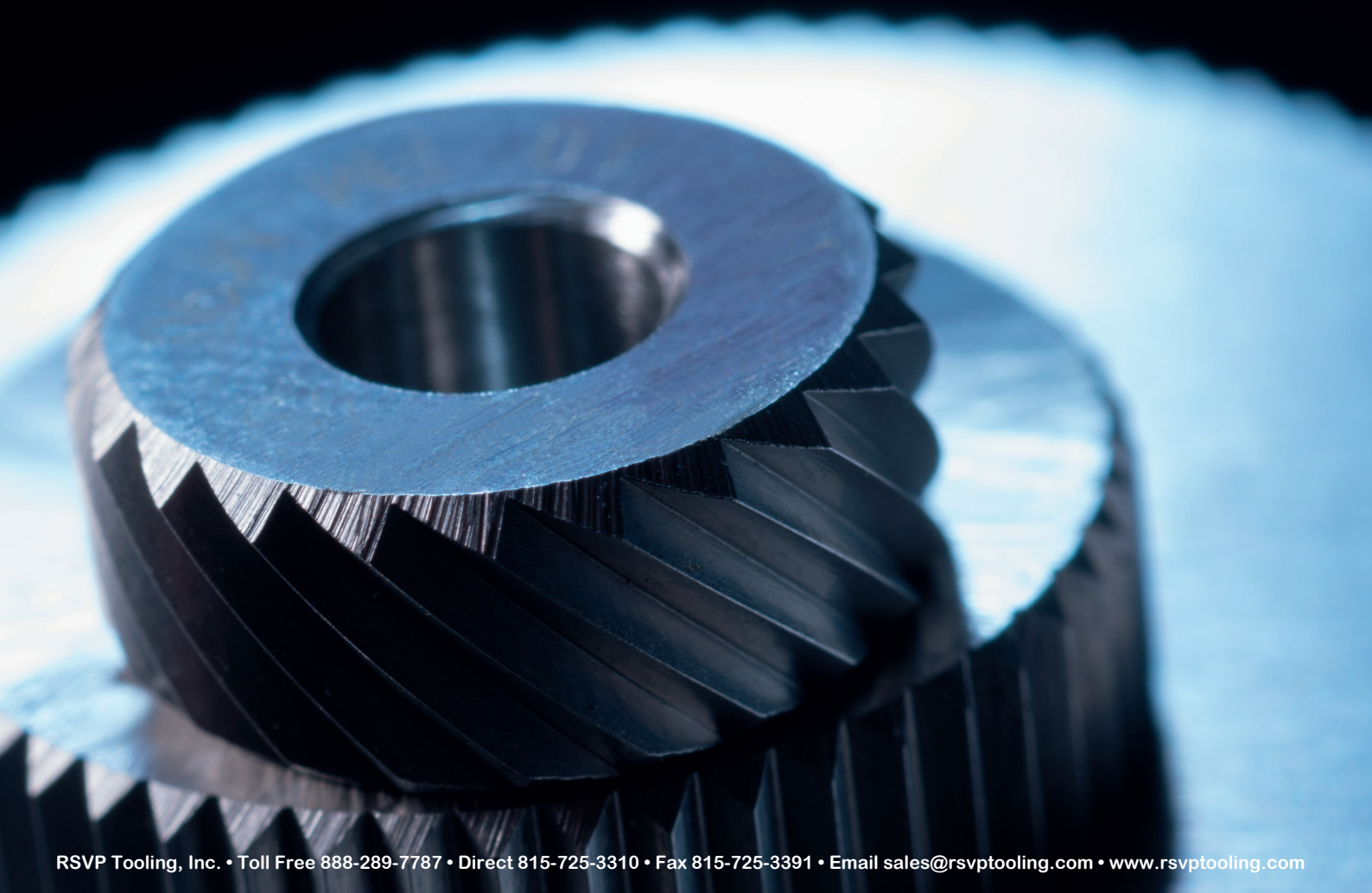




zeusECO

Knurling wheels | Form knurling tools

Cut knurling tools



Knurling wheels



Form knurling



Knurling wheels, milled, with chamfer 45° – HSS

Standard variants	Profile		Dimensions [mm]			Pitch [mm]
			Ø	Width	Bore	
Nr. 08	AA		10	4	4	○
Nr. 08			15	4	4	○
Nr. 08			15	6	4	●
Nr. 08			20	8	6	●
Nr. 08	BL	30°	15	4	4	○
Nr. 08			20	8	6	●
Nr. 08	BR	30°	15	4	4	○
Nr. 08			20	8	6	●
Nr. 08	BL	45°	10	4	4	○
Nr. 08			15	6	4	○
Nr. 08	BR	45°	10	4	4	○
Nr. 08			15	6	4	○

Standard pitches / profile angle 90°

- 0,6/0,8/1,0/1,2/1,5
- 0,6/0,8/1,0

Cut knurling



Knurling wheels, milled, without chamfer – HSS

Standard variants	Profile		Dimensions [mm]			Pitch [mm]
			Ø	Width	Bore	
Nr. 09	AA		15	4	8	□
Nr. 09			25	6	8	■
Nr. 09	BL	30°	15	4	8	□
Nr. 09			25	6	8	■
Nr. 09	BR	30°	15	4	8	□
Nr. 09			25	6	8	■

Standard pitches / profile angle 90°

- 0,8/1,0/1,5
- 0,8/1,0

Form knurling tools

Convincing efficiency for conventional autolathes

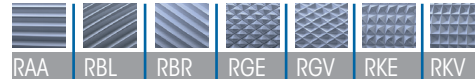


Series 830



Knurling profile on DIN 82 workpiece:

Plunge knurling



Selection of knurling wheels:



Feed knurling



Selection of knurling wheels:

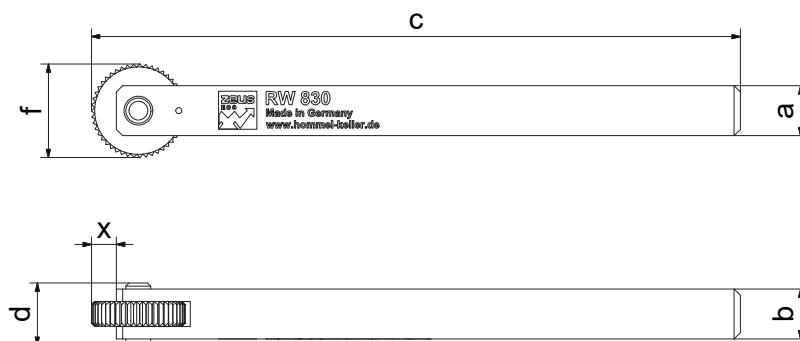


Product features:

- Centre height adjustable
- Pin hardened and ground

TOOL VERSIONS:

Order no.	Tool holder Designation	Working area Ø [mm]	Dimensions [mm]						Knurling wheels (Ø x b x b) [mm]
			a	b	c	d	f	x	
31000684	830-08U150404	3-50	8	8	104	10	15	4	15 x 4 x 4
31000550	830-16U250806	8-200	16	16	130,5	18	20 / 25	5,5	20 / 25 x 8 x 6



Form knurling tools

Double the rigidity,
easy to use



Series 841



Knurling profile on DIN 82 workpiece:

Plunge / Feed knurling



Selection of knurling wheels:

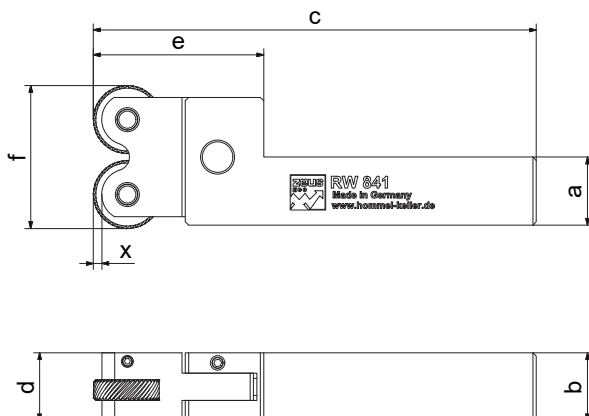
2 x AA	2 x BR	2 x BL	1 x BL30°/ 1 x BR30°	1 x BL45°/ 1 x BR45°
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Product features:

- Modular design: Tool can be used as right-hand and left-hand version
- Knurling head with flexible centring
- Pin hardened and ground
- Pins and pivot bolts with flat – for fast retooling of the knurling wheels / of the knurling head

TOOL VERSIONS:

Order no.	Tool holder Designation	Working area Ø [mm]	Dimensions [mm]							Knurling wheels (Ø x b x b) [mm]
			a	b	c	d	e	f	x	
31000678	841-20M200806	10-110	20	20	130	20	50	42	2,5	20 x 8 x 6



Form knurling tools

Double the rigidity,
easy to use



Series 851



Knurling profile on DIN 82 workpiece:

Plunge / Feed knurling



Selection of knurling wheels:

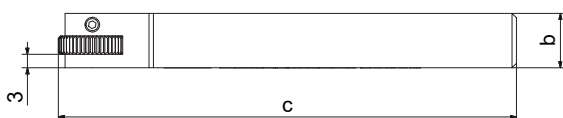
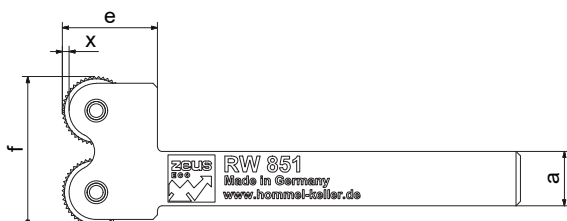
2 x AA	2 x BR	2 x BL	1 x BL30°/ 1 x BR30°	1 x BL45°/ 1 x BR45°
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Product features:

- Pin hardened and ground
- Pins with flat fixed by a screw - for fast retooling of the knurling wheels

TOOL VERSIONS:

Order no.	Tool holder Designation	Working area Ø [mm]	Dimensions [mm]						Knurling wheels (Ø x b x b) [mm]
			a	b	c	d	f	x	
31000680	851-12R150404	6-60	12	12	101	21	33	1,5	15 x 4 x 4



Form knurling tools

The perfect
basic equipment



Set 800-20

830-16U250806



SET consisting of:

- 1 x tool: 830-16U250806
- 1 x knurling wheel:
20 x 8 x 6 mm
- 1 x profile: AA
- Pitch: 0,8 mm

841-20M200806

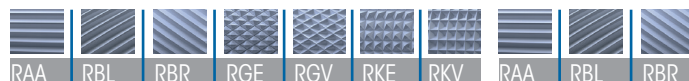


SET consisting of:

- 1 x tool: 841-20M200806
- 10 x knurling wheel:
20 x 8 x 6 mm
- 4 x profile: AA
- 3 x profile: BL30°
- 3 x profile: BR30°
- Pitches: 0,8 / 1,0 / 1,2 mm

Knurling profile on DIN 82 workpiece:

Plunge knurling



Feed knurling

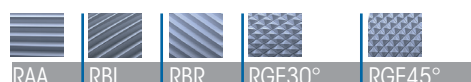


Selection of knurling wheels:



Knurling profile on DIN 82 workpiece:

Plunge / Feed knurling



Selection of knurling wheels:

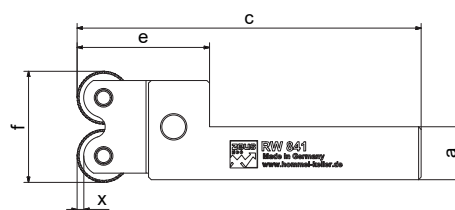
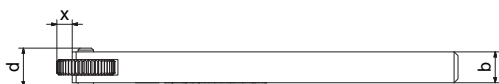
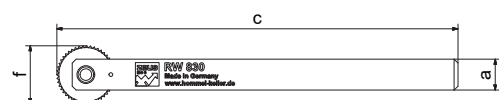


Product features:

- 3 spare part pins

TOOL VERSIONS:

Order no. Set	Order no.	Tool holder Designation	Working area Ø [mm]	Dimensions [mm]							Knurling wheels (Ø x b x b) [mm]
				a	b	c	d	e	f	x	
31000699	31000550	830-16U250806	8-200	16	16	130,5	18	-	-	5,5	20 x 8 x 6
	31000678	841-20M200806	10-110	20	20	130	20	50	42	2,5	20 x 8 x 6



Cut knurling tools

Ideal for first-class visual profiles with exceptional demands on surface quality



Series 931



Knurling profile on DIN 82 workpiece:
Feed knurling



Selection of knurling wheels:

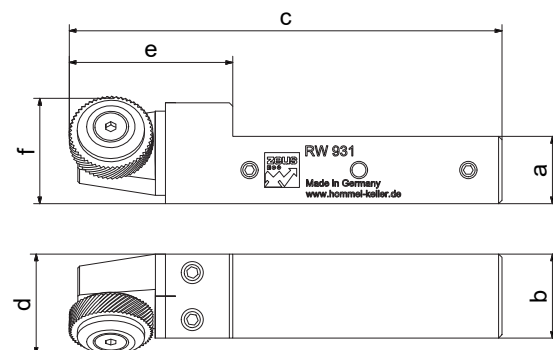
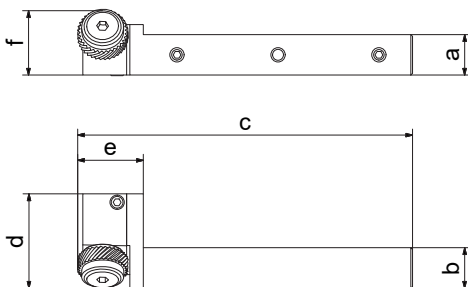
1 x BR30° (right-hand use) | 1 x AA (right-hand use)

Product features:

- Scaling and positioning aids (from shank size 20 mm)
- Adjusting spindle for fine adjustment of the knurl profile (from shank size 20 mm)
- Set screws in shank for clearance angle correction
- Coated carbide bearing bushes for improved antifrictional property

TOOL VERSIONS:

Order no.	Tool holder Designation	Working area Ø [mm]	Dimensions [mm]						Knurling wheels (Ø x b x b) [mm]
			a	b	c	d	f	x	
31000870	931-12R150408-A1	3-50	12	12	99,5	28	19,5	19,5	15 x 4 x 8
31000874	931-16R150408	3-50	16	16	99,5	28	19,5	24	15 x 4 x 8
31000871	931-20R250608-A1	10-300	20	25	129	30	49	32	25 x 6 x 8



Cut knurling tools

Perfect for knurling applications with exceptional demands



Series 941



Knurling profile on DIN 82 workpiece:

Feed knurling



RGE30° RGE45°

Selection of knurling wheels:

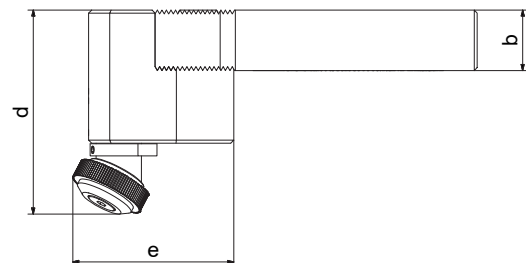
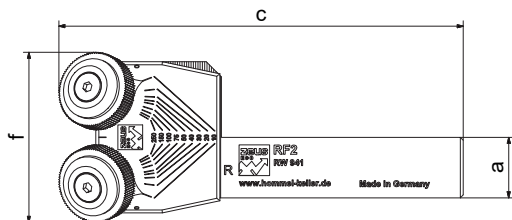
2 x AA 1 x BL15° / 1 x BR15°

Product features:

- Modular design: Tool can be used as right-hand and left-hand version. Retooling by simply turning the cut knurling head
- Scale to adjust the diameter
- Coated carbide bearing bushes for improved antifrictional property
- Vertical height adjustment for use of shank size 20 mm on 25 mm

TOOL VERSIONS:

Order no.	Tool holder Designation	Working area Ø [mm]	Dimensions [mm]						Knurling wheels (Ø x b x b) [mm]
			a	b	c	d	f	x	
31000687	941-20M250608-A1	10-250	20	20	134	68	54	58	25 x 6 x 8



Cut knurling tools

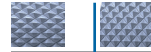
Perfect for knurling applications with exceptional demands



Series 951



Knurling profile on DIN 82 workpiece:
Feed knurling



RGE30° RGE45°

Selection of knurling wheels:

2 x AA 1 x BL15° / 1 x BR15°

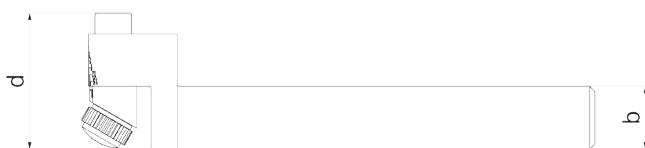
Product features:

- Scale to adjust the diameter
- Coated carbide bearing bushes for improved antifrictional property

TOOL VERSIONS:

Order no.	Tool holder Designation	Working area Ø [mm]	Dimensions [mm]						Knurling wheels (Ø x b x b) [mm]
			a	b	c	d	f	x	
31000873	951-12R100306	2-15	12	12	98,5	26	18,5	23	10 x 3 x 6**
31000682	951-12R150408	3-50	12	12	108	35	28	32	15 x 4 x 8
31000681	951-16R150408	3-50	16	16	108	35	28	32	15 x 4 x 8

** Knurling wheels 10 x 3 x 6 are available from the zeus product range



Cut knurling tools

The perfect
basic equipment



Set 900-20

931-20R 250608-A1



SET consisting of:

- 1 x tool: 931-20R250608-A1
- 2 x knurling wheel:
25 x 6 x 8 mm
- 2 x profile: BR30°
- Pitches: 0,8 / 1,0 mm

941-20/25M250608-A1



SET consisting of:

- 1 x tool:
941-20/25M250608-A1
- 4 x knurling wheel:
25 x 6 x 8 mm
- 4 x profile: AA
- Pitches: 0,8 / 1,0 mm

Knurling profile 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)		

Knurling profile on DIN 82 workpiece:

Feed knurling

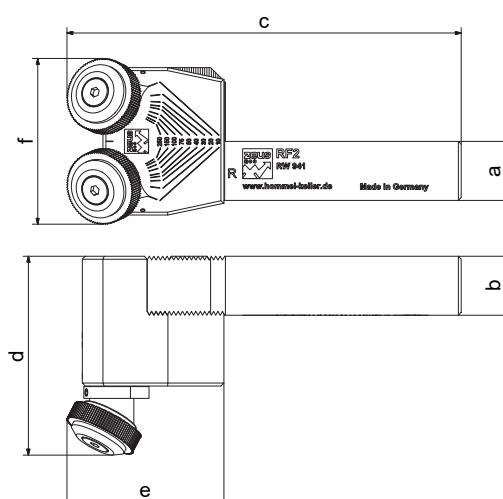
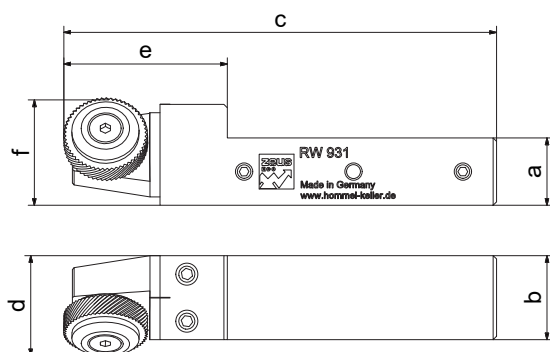


Selection of knurling wheels:

2 x AA	1 x BL15° / 1 x BR15°
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TOOL VERSIONS:

Order no. Set	Order no.	Tool holder Designation	Working area Ø [mm]	Dimensions [mm]						Knurling wheels (Ø x b x b) [mm]
				a	b	c	d	f	x	
31000701	31000871	931-20R250608-A1	10-300	20	25	129	30	49	32	25 x 6 x 8
	31000687	941-20/25M250608-A1	10-250	20	20	134	68	54	58	25 x 6 x 8



Spare parts



Series 830

Order no. Tool holder	Tool holder Designation	Pin
31000684	830-08U150404	06TER9537
31000550	830-16U250806	06TER0984

Pin

Series 841

Order no. Tool holder	Tool holder Designation	Pin
31000678	841-20M200806	21BHR0170

Pin with flat

Series 851

Order no. Tool holder	Tool holder Designation	Pin
31000680	851-12R150404	21BHR0172

Pin with flat

Series 931

Order no. Tool holder	Tool holder Designation	E-Kit
31000870	931-12R150408-A1	21BHR0505
31000874	931-16R150408	21BHR0505
31000871	931-20R250608-A1	21BHR0507

Bush, cover disc, screw

Series 941

Order no. Tool holder	Tool holder Designation	E-Kit
31000687	941-20M250608-A1	21BHR0506

Bush, cover disc, screw

Series 951

Order no. Tool holder	Tool holder Designation	E-Kit
31000873	951-12R100306	21BHR0889
31000682	951-12R150408	21BHR0504
31000681	951-16R150408	21BHR0504

Bush, special screw (31000873)

Bush, cover disc, screw
(31000682 / 31000681)



RSVP Tooling, Inc.

Toll Free: 888-289-7787 • Direct: 815-725-3310

Fax: 815-725-3391 • Email: sales@rsvptooling.com

www.rsvptooling.com

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PRÄZISIONSWERKZEUGE

Hommel+Keller

Präzisionswerkzeuge GmbH

78554 Aldingen · Germany

Tel. +49 7424 9705-0

info@zeus-tooling.de

www.zeus-tooling.de