



zeus® FORM KNURLING TOOL 132:
THE CLASSIC FOR KNURLING TO A SHOULDER –
CONVINCING FUNCTIONALITY!



- Machine type:** Conventional and CNC – suitable for:
- Automatic short-turning lathes, Universal lathes, Turning- / milling centre
 - Multispindle automatic lathes
- Application:** Form knurling (non-cutting forming)
- Knurling profile on work piece DIN 82:**
- | | | | | | | |
|-----|-----|-----|-----|-----|-----|-----|
| RAA | RBL | RBR | RGE | RGV | RKE | RKV |
| AA | BR | BL | GV | GE | KV | KE |
- Knurling wheels:**
- Tool direction:**
- Plunge knurling: Suitable for all knurling profiles, patterns and markings
 - Feed knurling: Suitable for RAA, RBL, RBR
- Product highlights:**
- Knurling to a shoulder – knurling wheel fixed by a shoulder
 - Fitting of the knurling wheel on the pin adjustable
 - Integrated set screws for easy adjustment of the clearance angle
 - Special surface hardening for increased wear resistance

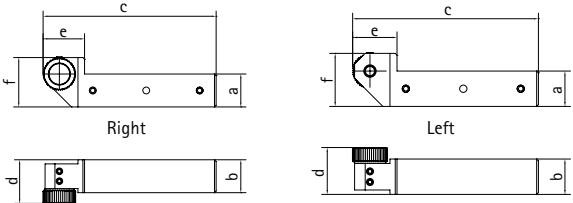
ORDER EXAMPLE:

Tool holder No. 132-20 U 200813-A
Product series 132-20 U
Shank size 20 x 20 mm
Right- / and left- hand use
For knurling wheels 20 x 8 x 6/13 (Ø x width x bore)

TOOL TYPES:

Tool holder No.	Working area Ø mm	a mm	b mm	c mm	d mm	e mm	f mm
132-20U200813-A	8-200	20	20	105,5	24	25,5	30
132-25U200813-A	8-200	25	20	105,5	24	25,5	35

Tool holder No.	Working area Ø mm	a inch	b mm	c mm	d mm	e mm	f mm
132-85U200813-A	8-200	3/4"	20	105,5	24	25,5	29
132-90U200813-A	8-200	1"	20	105,5	24	25,5	35,4



Knurling wheels mm (Ø x width x bore)	Spare part Shoulder pin	Spare part Run disc
20 x 8 x 6/13	06TER0445	21BHR0380
20 x 8 x 6/13	06TER0445	21BHR0380



The zeus® RD2 series is the first choice for producing RGE profiles in axial tool direction. Working axially, the knurl width can be chosen according to any size required. The tool series offers many add-ons, that simplify the tool handling. Due to its modular design, the RD2 is suitable for both right-hand and left-hand operations. For the swiss type autolathe versions the flexible shank system allows a conversion to different shank sizes.

APPLICATION ADVANTAGES:

EASY TOOL HANDLING:

- Easy appliance and tool handling
- Minimal work piece preparation
- Integrated set screws for easy adjustment of the clearance angle
- Pin with face – fixed by a screw – for a quick replacement of the knurling wheel
- Click-pin® versions for still faster and safer change of knurling wheels

HIGH WEAR RESISTANCE:

- Special surface hardening for increased tool life
- Carbide pins for higher speed rates, faster production, prolonged life

MODULAR PRODUCT DESIGN:

- Modular shank system for cost-effective use on all CNC- / and cam- controlled swiss type auto lathes
- Modular system: universal knurling tool for both right- / and left-hand orientation. Retooling through fast and easy turning of the knurling head

MODULAR PRODUCT DESIGN

For swiss type autolathe versions:



CLICK-PIN®-SYSTEM

For fast and safe change of the knurling wheel:

- > No more break off through overtightening
- > No more loosening through impact, hits or vibration
- > Quick change and positioning of the knurling wheel



KNURLING TO SHOULDER

Tool types for knurling to shoulder:



KNURLING TO A SHOULDER:

Suitable for knurling up to a shoulder



APPLICATION EXAMPLE:

Threaded bushing M5



APPLICATION:

Material: C35Pb
Knurling Profile/Pitch (DIN 82): RGE30° / P. 0.8
Machine: Tornos SAS 16DC
No. of pcs. produced/ knurling wheel: 120,000

APPLICATION PARAMETERS zeus® RD2:

Knurling tool: 141-16M150604
Knurling wheel: BL30° 15x6x4, P. 0.8
BR30° 15x6x4, P. 0.8
Cycle time: 0.8 sec/piece
Speed rate: 68 m/min
Feed rate: 0.2 mm/rev
Tool life knurling wheel: 1,600 min/knurling wheel
Performance: 19.2 m²/knurling wheel

