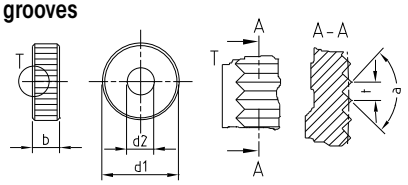
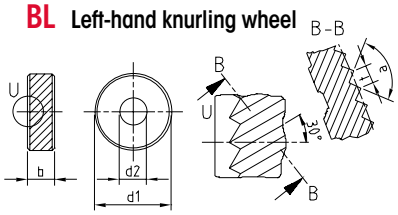
Profiles and knurling pitches

DIN 403 describes and specified the knurling profile on the knurling wheel. DIN 403 defines knurling forms AA, BL, BR, GE, GV, KE and KV. Knurling wheels that deviate from DIN 403 are considered special knurling tools and are custom manufactured by Hommel+Keller based on customer drawings.

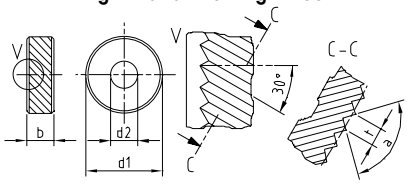
AA **Knurling wheel with axially parallel grooves**



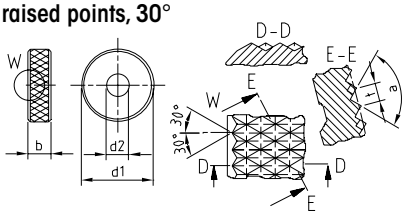
BL **Left-hand knurling wheel**



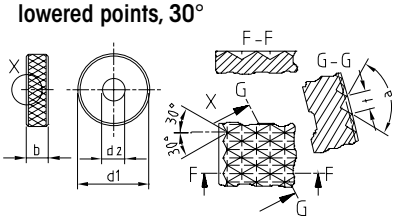
BR **Right-hand knurling wheel**



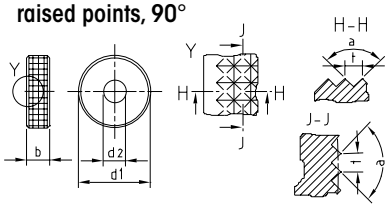
GE **Left/right-hand knurling wheel, raised points, 30°**



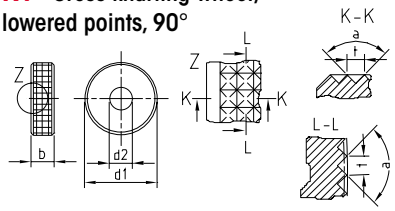
GV **Left/right-hand knurling wheel, lowered points, 30°**



KE **Cross knurling wheel, raised points, 90°**



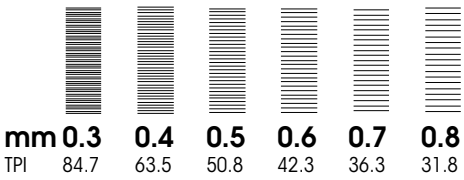
KV **Cross knurling wheel, lowered points, 90°**



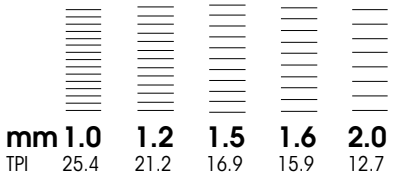
The knurling profile on the knurling wheel according to DIN 403 is based on the desired knurling profile on the workpiece (DIN 82) and the tool holder that is used.

The knurling pitch p refers to the distance between tooth crests. The pitches = 0.5/0.6/0.8/1.0/1.2/1.6 are standardised according to DIN 403. The Hommel+Keller product spectrum includes other pitches as well. They are listed below in mm and TPI. Other pitches are available as custom manufactured versions.

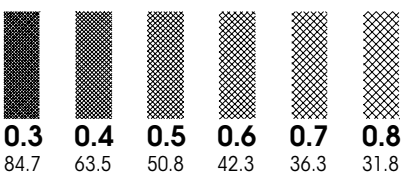
Standard pitches from Hommel+Keller



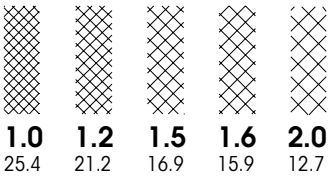
mm	0.3	0.4	0.5	0.6	0.7	0.8
TPI	84.7	63.5	50.8	42.3	36.3	31.8



mm	1.0	1.2	1.5	1.6	2.0
TPI	25.4	21.2	16.9	15.9	12.7



mm	0.3	0.4	0.5	0.6	0.7	0.8
TPI	84.7	63.5	50.8	42.3	36.3	31.8



mm	1.0	1.2	1.5	1.6	2.0
TPI	25.4	21.2	16.9	15.9	12.7