



2019 Catalog

Version 10.19

TOOLING FOR SWISS-TYPE CNC MACHINES

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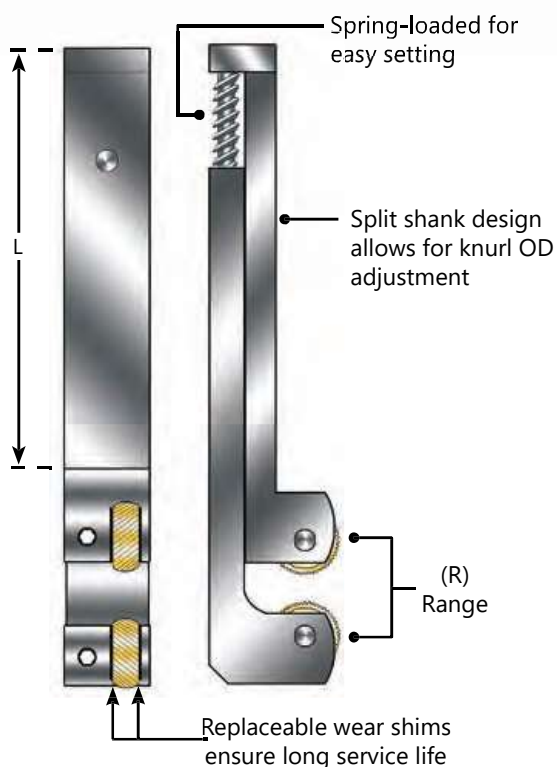


COMPACT STRADDLE KNURL HOLDERS for small parts

- Create perfect knurls
- Eliminates workpiece deflection
- Low interference

Specifically designed for Swiss-type machines; our low profile straddle knurl holders keep interference to a minimum within the tooling envelope of most machines while ensuring adjacent tool positions are available to maximize tooling capacity.

Item No.	Description	Shank	L	R	Wheel Dimensions
2040-000107	KHS-2BPR-375.1	.375in	2.7in	.0-.394in	5/16in x 1/8in x 5/32in
2040-000110	KHS-2EPR-500.3	.500in	3.24in	0-.750in	1/2in x 3/16in x 3/16in
2040-000111	KHS-2EPR-625.3	.625in	3.24in	0-.750in	1/2in x 3/16in x 3/16in



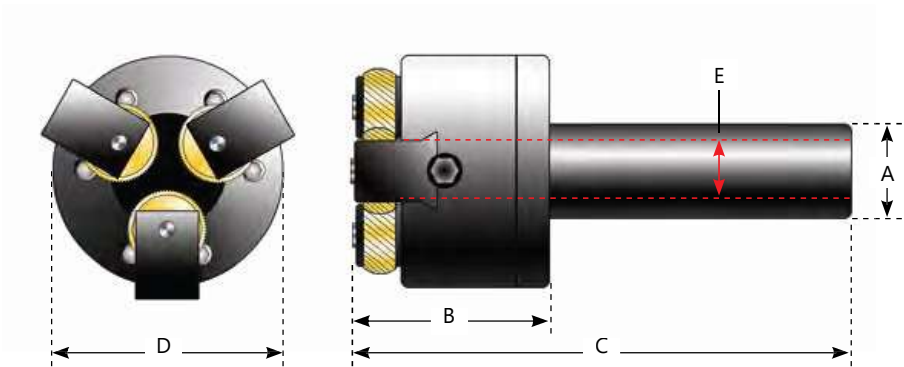
AXIAL FEED KNURL HOLDERS

- Ideal for long knurled parts
- Produce straight or diamond patterns
- Adjustable for a range of part diameters



Compact design makes it ideal for use on screw machines and CNC lathes when axial feed knurling from the turret. Parts are self supported and they can extend through the shank for long jobs. We recommend using CONVEX Knurl Dies with this style Knurl Holder. Can also be adapted for burnishing and internal knurling

Item No.	Description	Knurl Series	Knurl Range	A	B	C	D	E
2035-000100	KHE-3DBP-625	BP	.060 - .475	.625	1.25	3.855	1.75	.390
2035-000101	KHE-3DBP-750			.750	1.25	3.855	1.75	.475
2035-000105	KHE-3DEP-625	EP	.090 - .475	.625	1.25	3.855	1.75	.390
2035-000102	KHE-3DEP-750			.750	1.25	3.855	1.75	.475
2035-000104	KHE-3DGK-750	GK	.140 - .940	.750	1.60	4.90	3.00	.475
2035-000103	KHE-3DGK-1000			1.00	1.60	4.90	3.00	.718



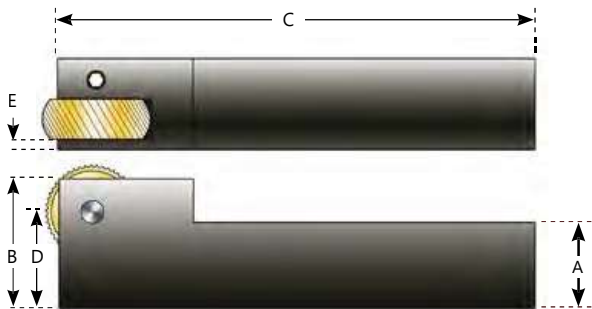
BUMP-STYLE KNURL HOLDERS

Conventional "bump" knurling is a cost effective way to produce knurled features on the outer diameter of parts.

- Carbide axles
- Ground shanks
- Left handed available
- Cost effective



Item No.	Description	Knurl Series	A	B	C	D	E
2025-000100	KHB-1BPR-312	BP	.312	.500	4.0	.312	.050
2025-000101	KHB-1BPR-375		.375	.562	4.0	.375	.050
2025-000103	KHB-1EPR-500	EP	.500	.750	3.5	.500	.090
2025-000105	KHB-1GKR-625	GK	.625	.937	4.0	.625	.090



DOUBLE-DIE BUMP-STYLE KNURL HOLDERS

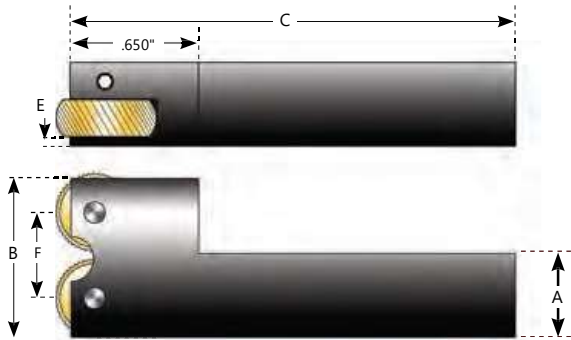
Cost effective solution for producing diamond pattern knurls on Swiss-type machines.

- Carbide axles
- Ground shanks
- Axial feed capability
- Cost effective



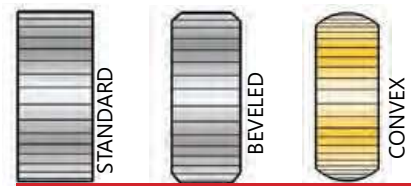
Compact Double-Die Bump-Style Knurl Holders

Item No.	Description	Knurl Series	A	B	C	E	F
2025-000106	KHB-2EPR-500	EP	.500	1.0	4.0	.075	.540
2025-000107	KHB-2EPR-625		.625	1.0	4.0	.075	.540



KNURLING WHEELS

Genevieve Swiss offers a full line of precision knurling tools for Swiss-type applications. Optional wheel geometries are available to suit your specific needs. More options are available in addition to what is listed below. Call for details or to discuss applications.



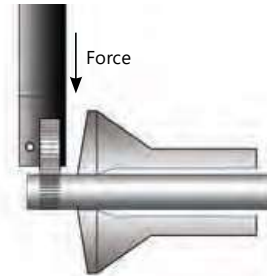
Standard Knurl Dies For Bump Knurling

Knurl Series	Wheel Dimensions	Straight Tooth	30° Right Hand	30° Left Hand	30° Male	30° Female	Available Pitch Teeth Per Inch (TPI)
OD x ID x Width							
BP	5/16 x 1/8 x 5/32	KDS-BPS0-	KDR-BPR0-	KDL-BPL0-	KDD-BPM0-	KDD-BPF0-	20, 25, 30, 35, 40, 50, 60, 70, 80, 90, 100
EP	1/2 x 3/16 x 3/16	KDS-EPS0-	KDR-EPR0-	KDL-EPL0-	KDD-EPM0-	KDD-EPF0-	16, 20, 25, 30, 32, 35, 40, 50, 80
GK	5/8 x 1/4 x 1/4	KDS-GKS0-	KDR-GKR0-	KDL-GKL0-	KDD-GKM0-	KDD-GKF0-	12, 16, 20, 25, 30, 32, 35, 40, 50, 80
KN	3/4 x 1/4 x 1/4	KDS-KNS0-	KDR-KNR0-	KDL-KNL0-	KDD-KNM0-	KDD-KNF0-	16, 20, 25, 30, 32, 35, 40, 50, 80
KP	3/4 x 3/8 x 1/4	KDS-KPS0-	KDR-KPR0-	KDS-KPL0-	KDD-KPM0-	KDD-KPF0-	8, 10, 12, 14, 16, 20, 21, 25, 30, 33, 35, 40, 50, 60, 70, 80, 100

All Wheels Also Available in DIAMETRICAL PITCH Configurations: 64DP, 96DP, 128DP, 160DP



- Precision lapped tooth forms provide superior knurled surfaces
- HSS vacuum hardened to approximately 63 Rockwell C
- Sides and Bore are Finish Ground to Maintain Close Tolerances
- Available Coated on Request



CONVEX Series Knurl Dies For Axial Feeding - Inch

Knurl Series	Wheel Dimensions	Straight Tooth	30° Right Hand	30° Left Hand	Available Pitch Teeth Per Inch (TPI)
OD x ID x Width					
EPV	1/2 x 3/16 x 3/16	KDS-EPSV-	KDR-EPRV-	KDL-EPLV-	16, 20, 25, 30, 32, 35, 40, 50, 80
GKV	5/8 x 1/4 x 1/4	KDS-GKSV-	KDR-GKRV-	KDL-GKLV-	12, 16, 20, 25, 30, 32, 35, 40, 50, 80
KNV	3/4 x 1/4 x 1/4	KDS-KNSV-	KDR-KNRV-	KDL-KNLV-	16, 20, 25, 30, 32, 35, 40, 50, 80
KPV	3/4 x 3/8 x 1/4	KDS-KPSV-	KDR-KPRV-	KDL-KPLV-	8, 10, 12, 14, 16, 20, 21, 25, 30, 32, 33, 35, 40, 50, 60, 80

All Wheels Also Available in DIAMETRICAL PITCH Configurations: 64DP, 96DP, 128DP, 160DP

CONVEX Series Knurl Dies For Axial Feeding - Metric

Knurl Series	Wheel Dimensions	Straight Tooth	30° Right Hand	30° Left Hand	45° Right Hand	45° Left Hand	Available Pitch Metric (mm)
OD x ID x Width							
MRV	20 x 6 x 6mm	KDS-MRSV-	KDR-MRRV-	KDL-MRLV-	KDR-MRCV-	KDL-MRDV	0.4, 0.5, 0.6, 0.7, 0.8, 1.0, 1.2, 1.5, 1.6, 2.0

Other Coatings Are Available



- Hi-Cobalt HSS treated with ferritic nitrocarburizing is standard on all CONVEX Knurls.
- Full-form convex relief spreads out forces providing smoother finish
- The ULTIMATE knurling die for Swiss-type straddle knurling

