



## ***KNURLING TOOL, HAND; 1/8" to 1-1/8"***

### **THE HAND KNURLING TOOL:**

The manual, or hand, knurling tool is intended for use on slightly worn shafts where a bearing "fit" has been lost due to wear or removal of a bearing. The knurling operation will raise sufficient material to restore the lost shaft diameter up to approximately .010".

### **THE TOOL SHOULD NOT BE USED ON HARDENED SURFACES.**

### **TO USE THE TOOL CORRECTLY:**

Screw the support handle into the fixed jaw side of the tool.

Open the jaws of the tool by turning the screw attached to the moveable jaw.

Position the knurling rollers over the worn shaft diameter, turn the adjustment screw so as to bring the moveable jaw and roller into contact with the work diameter, continue to turn the adjustment screw, this will bring the fixed jaw into contact with the work diameter.

When the three knurling rollers are in contact with the work diameter apply light pressure by turning the adjustment screw.

As pressure is applied it is best to rotate the knurling tool to observe the pattern and depth of knurling.

Measure the knurled diameter.

Continue to increase pressure, rotating the tool, until the desired diameter is obtained.

**Do not over tighten the adjustment screw**, this will cause undue stress on the thread and will "load" the knurling rollers.

### **MAINTENANCE:**

A light coating of grease on the moveable jaw slide, and a few drops of machine oil on the adjustment screw will keep the parts moving freely.