

Adjustable Straddle Holders

Operating Instructions

General Instructions

These holders are designed to fit most medium to large size CNC machines, and to roll more difficult jobs. They are supplied as right-hand style, but may be reassembled as left-hand style. You can use one right-hand and one left-hand knurl to produce a diamond pattern. Straddle holders may also be traversed to produce long knurl patterns. Beveled knurls are recommended when traversing. Straddle knurling produces much less work deflection than bump knurling. This allows knurling on longer parts or smaller diameters.

Speeds & Feeds

The recommended speed for knurling is the same speed that you would turn the material being rolled using a high-speed steel turning tool. If the knurls get excessively hot, reduce the speed.

The feedrate should be from .005" to .015" / revolution. Too low a feedrate causes flaking of the work. Too high may cause excessive feed lines in work and premature knurl failure.

Knurl Adjustment

Adjust the two nuts on the eye bolt until the knurls just contact the work. Retract the holder from the work. Tighten the nut closest to the knurl a small amount, lock the other nut against it and make a test roll. Examine the knurl pattern and adjust again if necessary.

Changing Knurls

Loosen the set screws locking the knurl pins. Remove the knurl pins, then replace the knurls. Replace the pins and tighten the set screws.

Changing from right-hand to left-hand

Loosen the set screw on top of the mounting shank. Remove the mounting pin that attaches the holder to the shank. Re-install the pin from the opposite side. Insert into the mounting shank from the opposite side and tighten the screw.
