


End Knurling, Version 1.0


By R. G. Sparber

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Recently I had to put ridges on the face of a 5/8" nut. My CNC could do it but that was way too much work. Why not try knurling?

There would be a lot of axial force so I used my depth stop² with a flange nut on the end so the stop would not pass through the nut. My knurling tool was mounted in my modified lantern tool holder³.



With the lathe in back gear going very slowly and with plenty of cutting oil, I fed in the top knurl. The bottom knurl did not touch the jaws.



I was surprised how well it came out!

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² <http://rick.sparber.org/smsp.pdf>

³ I can't recall where I learned this trick, but I made a thick washer that goes under the tool. You can see part of it in the picture.