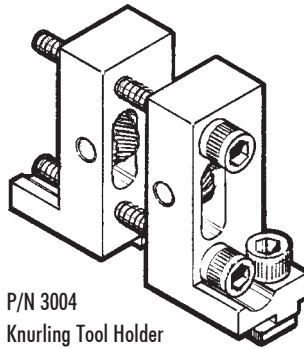


P/N 2275
Bump Knurl Tool Holder



P/N 3004
Knurling Tool Holder

SHERLINE
PRODUCTS
INCORPORATED 1974

Comparison between Knurl Holders P/N 2275 and P/N 3004

A Comparison between Sherline's Knurling Tool Holders

1. The P/N 2275 bump knurl tool holder can be used for CNC or manual knurling operations. The P/N 3004 is for manual knurling only.
2. The P/N 2275 bump knurl tool holder is held in position using the 3/8" Insert Holder Tool Post (P/N 7600, not included). The P/N 3004 is mounted directly to the lathe crossslide using T-nuts and socket head cap screws.
3. The knurling process exerts a lot of force on the part. When using the P/N 2275 all of that force is exerted on the part and on the machine. When using the P/N 3004 that same force is exerted on the part; however, that force is absorbed by the knurl holder. Because the P/N 3004 has opposing knurls that are closing on the part from opposite directions, the force that is exerted during the knurling process is contained between the two knurls and the adjusting screws. There isn't any side load on the part or the headstock.
4. Because of the side load that is exerted on the part by the P/N 2275 holder, you are limited to finer knurls (40 TPI and higher). The force exerted by larger knurls will be too much.
5. Because there isn't any side load when you use the P/N 3004, you can cut larger knurls. You can also cut very clean diamond knurls by using two opposing spiral knurls cutting in opposite directions for a crisscross pattern.
6. The P/N 2275 holder offers a little more versatility when you are using it manually. You can cut knurls at angles, on corners, and on rounded surfaces. See the video (<https://www.sherline.com/product/2275-knurl-tool-holder/#video>).
7. For detailed instructions for either knurling holder, go to the following links:
 - A. **P/N 2275** (<https://sherline.com/wp-content/uploads/2019/03/2275inst.pdf>)
 - B. **P/N 3004** (<https://sherline.com/wp-content/uploads/2015/01/3004inst.pdf>)

Thank you,
Sherline Products Inc.