

FORMING CAPABILITIES:
Flat Knuckling

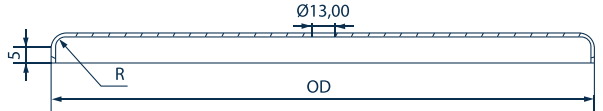
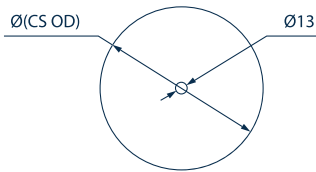


Your Complete Manufacturing Solution

FLAT KNUCKLING

Knuckling is done with an **Ø13 mm** hole in the centre of the part. We currently offer 3 knuckling radii: **R6 mm, R20 mm and R25 mm**. Knuckling can be done on plate thicknesses **from 2 mm to 6 mm**.

The flat development of a knuckled part is a round disk, with a cut size (CS OD) and ID (Ø13). The cut size OD is calculated as follows: **CUT SIZE = OD (Final Size) + Knuckling Allowance**



Mild Steel							
Plate Thickness	2	2.5	3	4	4.5	5	6
R6	✓	✓	x	x	x	x	x
R20	x	x	✓	✓	✓	x	x
R25	x	x	✓	✓	✓	✓	✓

Stainless Steel & 3CR12							
Plate Thickness	2	2.5	3	4	4.5	6	
R6	✓	✓	x	x	x	x	
R20	x	x	✓	✓	✓	x	
R25	x	x	✓	✓	✓	✓	

Knuckling Allowance			
Radius	R6	R20	R25
KA (mm)	23	30	35

Knuckling Size Limit	
R6	R20 & R25
Ø250 – Ø1000	Ø1000 – Ø3500

Please ensure that there are no cut-outs close to the outside of the part, as the cut-out can influence the forming of the knuckle or deform itself.

Cut-outs can be added accurately to the knuckled part after forming by the laser machine.

Important Notice:

Please note that this information is for guidance only and final information must be confirmed by a Fabrinox Sales Technician to include all possible variances.