

By YouTube ghostses

1 Divided by Pitch of knurl = Pitch Decimal

Pitch Decimal Divided by PI = Multiplier

Base Multipliers are 1, 2, 3, 4, 5, and so on

Base Multiplier Times Multiplier = Turning Diameter

Example:

Pitch of Knurl = 42

$1/42 = 0.023809$

$0.02389/3.141 = 0.00758$

$1 * 0.00758 = 0.00758$

$2 * 0.00758 = 0.01516$

$30 * 0.00758 = 0.2274$ Turning Diameter

$64 * 0.00758 = 0.485$ and I did test and get a good knurl!