

Request form for VSVG tools (Valve seat and valve guide tool)

Customer no.	New customer
Company	
Street, house no.	
Postcode, town, country	
Date	

Order number
Contact partner
Telephone
Email
Contact partner at Gühring

1. Tool		
1.1 Valve guide cutting material		
<input type="checkbox"/> Solid carbide	<input type="checkbox"/> PCD	
1.1.1 Valve seat cutting material		
<input type="checkbox"/> CBN	<input type="checkbox"/> Solid carbide	
1.2 Clamping system		
<input type="checkbox"/> GP100	<input type="checkbox"/> GP300	<input type="checkbox"/> GP400
1.3 Shank form		
<input type="checkbox"/> HSK	<input type="checkbox"/> SK	
<input type="checkbox"/> BT	<input type="checkbox"/> Alignment adapter	
1.4 Expansion chuck		
<input type="checkbox"/> Yes	<input type="checkbox"/> No	
1.5 Previous tool		
Manufacturer		
Problems		
<input type="checkbox"/> Vibrations	<input type="checkbox"/> Chip removal	
<input type="checkbox"/> Surface	<input type="checkbox"/> Shape and position	
Tool life		
Target	Actual	
2. Workpiece		
Description		
2.1 Material		
Material designation		
Hardness		
Special features		
2.1.1 Valve guide material		
<input type="checkbox"/> Sinter	<input type="checkbox"/> Brass	
Material designation		
2.1.2 Valve ring material		
Material designation		
2.2 Information available		
<input type="checkbox"/>	Component drawing available	
<input type="checkbox"/>	3D model	
<input type="checkbox"/>	2D drawing (AutoCAD)	
<input type="checkbox"/>	Drawing of raw part	

2.3 Acceptance required		
<input type="checkbox"/> Yes	<input type="checkbox"/> No	<input type="checkbox"/> Not known
2.4 CPK acceptance request		
<input type="checkbox"/> 1.33	<input type="checkbox"/> 1.67	<input type="checkbox"/> 2.0
2.5 Quality requirements		
Surface finish	R _z	R _a
Roundness		
Straightness		
Cylindricity		
Concentricity		
Flatness		
3. Machine		
3.1 Machine type		
<input type="checkbox"/> machining center	<input type="checkbox"/> Transfer line	
Manufacturer/Type/Year of production		
Number of spindles		
Spindle locations	<input type="checkbox"/> Vertical	<input type="checkbox"/> Horizontal
Max. tool weight		
Power kW		
Other specifications		
3.2 Cutting data / working conditions		
Cutting speed		
Min./max. speed		
Feed rate, min./max.		
Special features		
3.3 Cooling		
<input type="checkbox"/> Internal cooling	<input type="checkbox"/> Oil	Ratio
<input type="checkbox"/> External cooling	<input type="checkbox"/> MQL	<input type="checkbox"/> 1-channel <input type="checkbox"/> 2-channel
External cooling	bar	-Quantity l/min
3.4 Tool life specification / processing time (min)		

Tool drawing

