

Request form for PCD / PCBN tools

Customer number	New customer
Company name	
Street, n°	
City, ZIP-code, Country	
Date	

Order number									
Contact									
Telephone									
E-Mail									
Your contact at Guhring									

1. Tool

1.1 Cutting material	<input type="checkbox"/> PKD	<input type="checkbox"/> PCBN
1.2 Type	<input type="checkbox"/> stationary	<input type="checkbox"/> rotating
1.3 Tool type		
<input type="checkbox"/> Drill	<input type="checkbox"/> Reamer	<input type="checkbox"/> Counter sink
<input type="checkbox"/> Indexable insert		
<input type="checkbox"/> Milling cutter	<input type="checkbox"/> face milling	<input type="checkbox"/> circular
	<input type="checkbox"/> up-cut milling	<input type="checkbox"/> climb milling

1.4 Cutting edge type

Length cutting edge	
Cutting edge position	
Ø Tolerance	

1.5 Shank type

<input type="checkbox"/> HSK	<input type="checkbox"/> SK	<input type="checkbox"/> ABS
<input type="checkbox"/> Straight shank	<input type="checkbox"/> Alignment adapter	<input type="checkbox"/> BT
<input type="checkbox"/> to DIN		
<input type="checkbox"/> Size / form		

1.6 Tool type

<input type="checkbox"/> shrunk	<input type="checkbox"/> monolithic
<input type="checkbox"/> external cooling	<input type="checkbox"/> internal cooling
<input type="checkbox"/>	

1.7 Existing tool

Manufacturer		
Difficulties	<input type="checkbox"/> Vibrations	<input type="checkbox"/> Chip removal
	<input type="checkbox"/> Surface	<input type="checkbox"/> Form and position
Tool life	Target	actual

2. Workpiece

Description	
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2.1 Material

Material designation	
Hardness	
Particularities	

2.2 Available information

<input type="checkbox"/> Component drawing
<input type="checkbox"/> 3D-Model
<input type="checkbox"/> 2D drawing (AutoCAD)
<input type="checkbox"/> Raw part drawing

2.3 Preparations

<input type="checkbox"/> pre-drilled	<input type="checkbox"/> pre-castal
<input type="checkbox"/> oversize	<input type="checkbox"/> into solid material

2.4 Characteristics / Specifications

<input type="checkbox"/> interrupted cuts	<input type="checkbox"/> Cross bore
<input type="checkbox"/> inclined entrance	<input type="checkbox"/> inclined exit
<input type="checkbox"/> blind hole	<input type="checkbox"/> through hole
<input type="checkbox"/>	

2.5 Required quality

Surface finish quality	RZ	Ra
Roundness		
Straightness		
Cylindricity		
Concentricity		
Flatness		

3. Machine**3.1 Machine type**

<input type="checkbox"/> Machining centres	<input type="checkbox"/> Transfer line
Manufacturer / type / year	
Number spindles	
Position spindles	
total weight max.	
Power kW	
other spezifications	

3.2 Cutting data / Machining conditions

Cutting speed	
Speed min. / max.	
Feed min. / max.	
Particularities	

3.3 Cooling

<input type="checkbox"/> internal cooling	<input type="checkbox"/> Oil	Mixing ratio	
<input type="checkbox"/> external cooling	<input type="checkbox"/> MQL	<input type="checkbox"/> 1-channel	<input type="checkbox"/> 2-channel
<input type="checkbox"/> Air	<input type="checkbox"/> dry		
Coolant pressure	bar	Flat rate	l/min

3.4 Target tool life / Machining time (min)

Gühring KG

Sigmaringer Strasse 160
72458 AlbstadtTelephone 07431 17-0
Fax 07431 17-750info@guehring.de
www.guehring.de