grindaix
A QUAKER HOUGHTON COMPANY

Optimization of the cooling lubricant supply
- through Grindaix nozzles

Company information

Company:	
Street/ House no:	
ZIP code/ Location:	
Contact Person:	
Phone:	
Mobile:	
E-mail:	

☐ I would like a quotation and a nozzle proposal for my process!

Machine and grinding process

1) Machine specification

- Machine manufacturer/ -type:
- Year of manufacture of the machine:

2) Which grinding process is used in the process?

Grindaix GmbH ▪ Marie-Curie-Straße 8 ▪ 50170 Kerpen ▪ Tel.: 02273 - 95373 0 ▪ Fax: 02273 - 95373 5
Managing Director: Roman Stabauer M.Eng., Glen May B.Eng.
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Grinding wheel and component

3) Grinding wheel specifications

- Grinding wheel manufacturer/ -type: ☐
- please tick: ☐ conventional ☐ high hardness
- Grinding wheel binding: ☐ ceramic ☐ galvanic ☐ rubber bonded
  ☐ other binding: ☐
- Grinding wheel peripheral speed (min-max) [m/s]: ☐
- Grinding wheel diameter (min-max) [mm]: ☐
- Grinding wheel width [mm]: ☐
- Grinding wheel profile: ☐ cylindrical ☐ profiled
- Is a grinding wheel cleaning system available? ☐ Yes ☐ No
  If "No", is one desired? ☐ Yes ☐ No

4) What does the geometry to be ground look like on the component?

- Please send us a drawing (if possible a CAD STEP file) showing the following points:
  - Grinding position
  - Component geometry to be ground
  - Collision space
  - meshing conditions
  - Grinding wheel geometry

- Please send us a photo showing the following points:
  - Processing situation
  - Current coolant supply/nozzle

- Which areas on the component are particularly susceptible to abrasive fires?

☐

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5) **Are there any special restrictions with regard to the nozzle installation or the installation space (keyword collision, robot loading, etc...)?**

☐ Yes ☐ No

If "Yes", please describe the available installation space:

6) **Are there any special requirements regarding the mounting of the nozzle (interface to the machine)?**

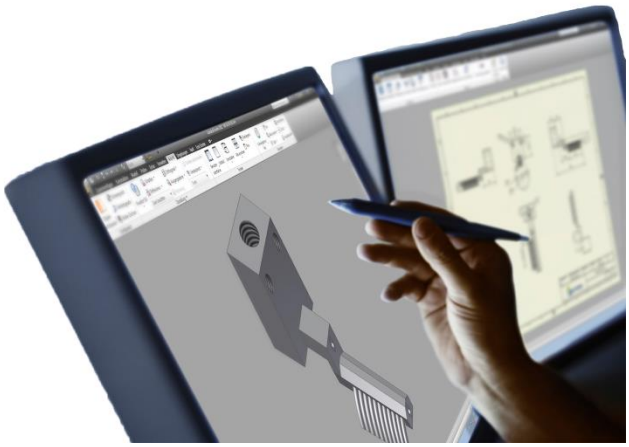
☐ Yes ☐ No

If "Yes", describe them:

7) **Are there any special requirements for the connection (connection thread) for the cooling lubricant supply line (e.g. metric, inch thread)?**

☐ Yes ☐ No

If "Yes", describe them:



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Cooling lubricant

8) Which cooling lubricant do you use?

- Oil:
  - ➢ Viscosity [mm^2/s]:
  - ➢ Density [kg/l]:
- Emulsion:
  - ➢ Concentration [%]:

❖ Please send us a coolant data sheet.

9) What quantity of cooling lubricant do you currently use to supply the grinding nozzle? (Information directly in front of the nozzle!)

- Volume flow [l/min]:
- Pump pressure nozzle [bar]:

10) How powerful is your feed pump?

- Pump manufacturer/ -type:
- max. volume flow [l/min]:
- max. pump pressure [bar]:

11) How efficient is your filtration system?

- Filter fineness [µm]:
- Do larger chip lumps or chip wool occur which get back into the feed to the nozzle?

☐ Yes ☐ No

- Residual dirt content of cooling lubricant [mg/l]:

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