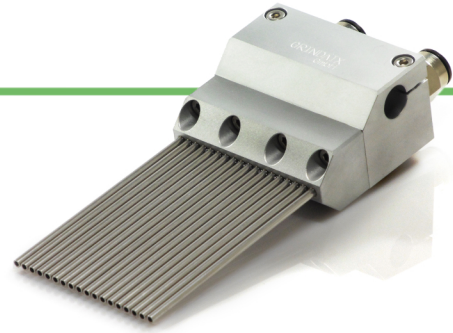


Optimisation of Coolant Supply - by Needle Nozzles



Description of actual state

Company:

Address:

Person in charge:

Phone number:

Fax number:

E-Mail:

I would like to receive a quote and a nozzle design for my process

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Questionnaire: for the respective process to be optimised

1) Which grinding procedure is applied at the considered process?

a) _____

(e.g. surface grinding, external cylindrical plunge grinding, centerless through feed grinding, ...)

2) Which type of grinding wheel and which grinding wheel speed are used?

a) conventional/superabrasive _____

b) grinding wheel speed [m/s] _____

3) What is the geometry of the grinding wheel?

- a) diameter [mm] _____
- b) width [mm] _____
- c) cylindrical or profiled _____
(if profiled please send a drawing)

4) What is the part geometry to be ground?

- a) Please send a drawing showing the grinding positions at the part and the ground part geometry.
- b) Are there thermal damages of the ground part (e.g. grinding burn)?
 Yes No
- c) Which grinding positions are especially critical regarding grinding burn?

5) Which type of coolant is used?

- a) oil or emulsion? _____
- b) if oil: viscosity [mm²/s] _____
- c) if emulsion: concentration _____ %

6) Which amount of coolant do you currently use for the process?

- a) flow rate [l/min] _____
- b) pump pressure [bar] _____

7) Wie leistungsfähig ist Ihre Zufuhrpumpe?

- a) max. Volumenstrom [l/min] _____
- b) max. Pumpendruck [bar] _____
- c) falls vorhanden, Volumenstrom in Abhängigkeit des Druckes _____
- d) falls vorhanden, genaue Pumpenbezeichnung (z.B. Grundfos CR 15-17)

8) Wie leistungsfähig ist Ihre Filtrationsanlage?

- a) Filterfeinheit [μm] _____
- b) Treten größere Späneklumpen oder Spänewolle auf, die wieder in die Zuführung zur Düse gelangen?
- Ja Nein

9) Gibt es besondere Einschränkungen hinsichtlich des Düseneinbaus bzw. des Bauraums?

- a) Falls ja, beschreiben Sie bitte den vorhandenen Bauraum

10) Gibt es besondere Anforderungen hinsichtlich der Aufnahme der Düse?

- a) Falls ja, beschreiben Sie diese

11) Are there any special requirements regarding the connection (connection thread) with the coolant supply pipe?

a) If yes, please describe the requirements
