Optimization of the cooling lubricant supply
- through Grindaix nozzles

Company: _____

Address: _____

_____

Contact Person: _____

Phone number: _____

Fax no: _____

Email: _____

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

Questionnaire: for the respective process to be optimized

General

1) **Details of the machine**

   a) Machine manufacturer and type: _____

   b) Year of manufacture of the machine: _____

   c) Compressed air connection (6bar) available? Yes ☐   No☐

2) **Which grinding process is used in the process under consideration? used?**

   _____

   _____

Grinding wheel and component

3) Details of the grinding wheel

a) Grinding wheel manufacturer and type: _____

b) please tick: conventional ☐   high hardness ☐

c) Grinding wheel specification: _____

d) Grinding wheel speed [ns=$\frac{1}{min}$]: _____

e) please tick, grinding wheel binding:

☐ ceramic electroplated ☐   rubber bonded ☐

other binding: _____

f) Grinding wheel peripheral speed (min-max) [m/s]:

_____

g) Diameter (min-max) [mm]: _____

h) Disc width [mm]:   _____

i) Cylindrical or profiled: _____

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

a) Please send us a drawing (CAD STEP file) showing the grinding positions or the component geometry to be ground (collision space, meshing conditions).

b) Please send us a photo of the processing situation.

c) Which areas on the component are particularly susceptible to abrasive fires? :

_____

_____

_____

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

a) If yes, please describe the available installation space:

_____

_____

_____

b) Are these features clearly visible in the CAD STEP file?

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

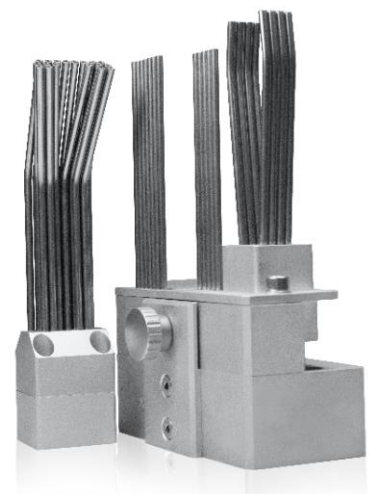a) If yes, describe them:

_____

_____

_____

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

a) If yes, describe them:

_____

_____

_____

Cooling lubricant

8) Which cooling lubricant do you use?

a) Oil: _____

    Viscosity [mm2/s]: _____

    Density: _____

b) Emulsion: _____

    Concentration: _____%

*Please send us a coolant data sheet.

9) What quantity of cooling lubricant do you currently use to supply the grinding nozzle?

a) Volume flow [l/min]: _____

b) Pump pressure nozzle [bar]: _____

10) How powerful is your feed pump?

a) max. volume flow [l/min]: _____

b) max. pump pressure (pump outlet) [bar]: _____

c) Pump manufacturer and type: _____

11) How efficient is your filtration system?

a) Filter fineness [μm]: _____

b) Do larger chip lumps or chip wool occur which get back into the feed to the nozzle?
the feed to the nozzle?

☐ Yes ☐ No

c) Residual contamination content of cooalant [mg/litre]: _____