

FORM

Single Process – Hole Machining

For internal use only!

Please send the completed form to your responsible CSC!

Created by: **Date:**

1 Customer

Customer no.:	End customer:
Enquiry no.:	Date of visit:
Address quote to:	Technical contact:
Telephone:	Telephone:
E-Mail:	E-Mail:
Department:	

Please offer:

2 Quotation

Customer's price expectation

Guide price/Piece: €

Quantity:

Quote deadline:

Quantity/scale:

Drawing proposal

yes no

Quote submission deadline:

Delivery date for tools:

3 Workpiece and machining tasks

Workpiece designation:

Material designation:

Tensile strength:

Machining task:

Threading	Turning		
Pre-machining	Finishing	Boring	Reaming
Solid drilling	Intermediate machining	Milling	Others

Allowance (mm/radius): Offset (mm):

Workpiece drawing is required

Drawing number:

Hardness:

Interrupted cutting: yes no

4 Machine data

Make/type:

Year of construction: **Number of spindles:**

Machining method: horizontal vertical

Power: P_A (kW)

Speed: n_{min} **Speed levels:** Infinitely adjustable
 n_{max}

 rotating stationary

Feed drive: NC Hydraulic

Spindle holders:
 (e.g. HSK, SK)

Radial run-out accuracy of
 the spindle:

Coolant: Central through spindle dry MQL 1-channel MQL 2-channel

Coolant pressure: bar Manufacturer:

Make and concentration:

5 Tools:

	Indexable insert tools	Solid carbide tools PCD/CBN	Reaming tools	Threading
Type of shank/interface:			
Cutting material/ indexable insert:			
Max. tool weight:			kg
Max. tool width:			mm
Max. tool length:			mm
Tool change:	Automatic	manual		
Tool setting:	Inside the machine	Outside the machine		
Holder for data storage medium:			
Type:			

5a Additional data for reaming

Diameter and tolerance:
 (according to component drawing)

Pre-machining diameter:

Type of pre-machining:

Hole length:

Boring:



Length of the interrupted cut:

Machine base: yes no

Surface quality Ra/Rz:

Permissible circularity defects:

5b Additional data for threads:

BGF

MGF

Solid carbide thread former

Solid carbide Taps

MKG

HSS thread former

HSS Taps

Tomill

HML

Core hole diameter:

Depth:

Thread size:

Thread depth: mm

Blind hole

Through hole

Countersink: yes no

Countersinking angle: degree

5c Other tools

6 Machining suggestions/sketches/equipment/interference