

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	Drawing proposal
Guide price/Piece: €	yes no
Quantity:	
Quote deadline:	Quote submission deadline:
Quantity/scale:	Delivery date for tools:

3 Workpiece and machining tasks

Workpiece designation:	<input checked="" type="checkbox"/> Workpiece drawing is required
Material designation:	Drawing number:
Tensile strength:	Hardness:

Machining task:

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

Allowance (mm/radius):	Offset (mm):	Interrupted cutting: yes no
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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