

## Request form for PCD / PCBN tools

Customer number	New customer
Company name	
Street, n°	
City, ZIP-code, Country	
Date	

Order number
Contact
Telephone
E-Mail
Your contact at Guhring

### 1. Tool

**1.1 Cutting material**  PKD  PCBN

**1.2 Type**  stationary  rotating

**1.3 Tool type**

Drill  Reamer  Counter sink

Indexable insert

Milling cutter  face milling  circular

up-cut milling  climb milling

### 1.4 Cutting edge type

Length cutting edge

Cutting edge position

Ø Tolerance

### 1.5 Shank type

HSK  SK  ABS

Straight shank  Alignment adapter  BT

to DIN

Size / form

### 1.6 Tool type

shrunk  monolithic

external cooling  internal cooling

### 1.7 Existing tool

Manufacturer

Difficulties  Vibrations  Chip removal

Surface  Form and position

Tool life Target actual

### 2. Workpiece

Description

#### 2.1 Material

Material designation

Hardness

Particularities

#### 2.2 Available information

Component drawing

3D-Model

2D drawing (AutoCAD)

Raw part drawing

### 2.3 Preparations

pre-drilled  pre-castal

oversize  into solid material

### 2.4 Characteristics / Specifications

interrupted cuts  Cross bore

inclined entrance  inclined exit

blind hole  through hole

### 2.5 Required quality

Surface finish quality	RZ	Ra
Roundness		
Straightness		
Cylindricity		
Concentricity		
Flatness		

### 3. Machine

#### 3.1 Machine type

Machining centres  Transfer line

Manufacturer / type / year

Number spindles

Position spindles

total weight max.

Power kW

other spezifikationen

#### 3.2 Cutting data / Machining conditions

Cutting speed

Speed min. / max.

Feed min. / max.

Particularities

#### 3.3 Cooling

internal cooling  Oil  Mixing ratio

external cooling  MQL  1-channel  2-channel

Air  dry

Coolant pressure bar Flat rate l/min

#### 3.4 Target tool life / Machining time (min)