

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 Gühring

1. Tool

1.1 Cutting material PCD 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	R _z	R _a
Roundness		
Straightness		
Cylindricity		
Concentricity		
Flatness		

3. Machine

3.1 Machine type

Machining centres Transfer line

Manufacturer / type / year

Number spindles

Position spindles vertical horizontal

total weight max.

Power kW

other specifications

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)

Technical drawing

