

questionnaire spring end grinding



company: _____
 address: _____

 contact: _____
 title/department: _____
 e-mail: _____
 telephone: _____
 sales representative: _____

quotation
 quantity: _____
 trial order
 quantity: _____
 date: _____

grinding procedure

double disc flat grinding: infeed grinding through-feed grinding one side flat grinding (swing process grinding)

grinding machine

manufacturer: _____ type: _____ totally enclosed machine
 maximum operating speed (V): release: m/s working speed: m/s wheel rotation speed (n): 1/min variable constant
 cooling medium: dry oil emulsion Suction output: m³/h power: kw year of construction: _____

grinding wheel

dimension: _____ mm type: _____ compliant with drawing
 screwing on: pitch circle 1 Ø: mm number of screw threads TK1: size of threads TK1:
 pitch circle 2 Ø: mm number of screw threads TK2: size of threads TK2:
 pitch circle 3 Ø: mm number of screw threads TK3: size of threads TK3:
 pitch circle 4 Ø: mm number of screw threads TK4: size of threads TK4:
 cementing on: fixing diameter: mm approach depth: mm
 clamping on with flanges:
 competitor: _____ quality: _____ sample drawing enclosed

workpiece

material grades, _____ sample-spring: yes no
if different, specify quality mainly used:
 Wire diameter from: _____ mm to _____ mm main focus at: _____
 External diameter of spring: _____ mm Colling ratio (n_t): _____ Spring rate: _____ N/mm
 Length of springs: L₁= _____ mm L₀= _____ mm strength (R_m): _____ N/mm² state: tempered non-tempered
 deviation of parallelism e2: _____ mm weight spring: non-grinded: _____ g grinded: _____ g
 spring axial deviation e1: _____ mm properties spring: unstable inflexible other:

grinding process

springs loading plate: _____ pcs. number of rows loading plate: _____ pcs. speed loading plate: _____ 1/min
 infeed increment: _____ mm/min infeed dressing: _____ mm
 dressing after: _____ loading plates _____ pcs. grinded springs _____ reason of dressing: _____
 grinding time / loading plate: _____ min output per hour: _____ pcs. assembly of loading plates: manual automatic

further details

testing purpose: _____
 annual requirements: _____
 customer satisfaction Theleico: _____
 notes: _____

 drawing: _____

 THELEICO draft proposal: _____

IMPORTANT: Please use Adobe Acrobat (Reader) to fill form!



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