

# questionnaire roll grinding



company: \_\_\_\_\_  
 address: \_\_\_\_\_  
 \_\_\_\_\_  
 contact: \_\_\_\_\_  
 title/department: \_\_\_\_\_  
 e-mail: \_\_\_\_\_  
 telephone: \_\_\_\_\_  
 sales representative: \_\_\_\_\_

quotation  
 quantity: \_\_\_\_\_  
 trial order  
 quantity: \_\_\_\_\_  
 date: \_\_\_\_\_

## grinding procedure

steel plant:  hot rolling  cold rolling  cluster mill rolls  work rolls  back up rolls  intermediate rolls  
 aluminium plant:  work rolls  back up rolls  
 paper plant:  work rolls  back up rolls  
 other grinding procedures:

## grinding machine

manufacturer: \_\_\_\_\_ type: \_\_\_\_\_ CNC:  yes  no  
 maximum operating speed (V): release: \_\_\_\_\_ m/s working speed: \_\_\_\_\_ m/s wheel rotation speed (n): \_\_\_\_\_ 1/min  variable  constant  
 cooling medium:  dry  oil  emulsion power: \_\_\_\_\_ kw year of construction: \_\_\_\_\_

## grinding wheel

dimension: \_\_\_\_\_ mm useable diameter: \_\_\_\_\_ mm type:  compliant with drawing  
 competitor: \_\_\_\_\_ quality: \_\_\_\_\_  sample  drawing enclosed  
 evaluation:  good  suboptimal  to hard  to soft  to coarse  to fine  other:  
 Grinding surface optical:  perfect  feed lines  scratchiness  ridge  scratches

## workpiece

designation: \_\_\_\_\_ material / standard designation: \_\_\_\_\_  
 dimension: \_\_\_\_\_ mm hardness/strength: \_\_\_\_\_ shore Hrc  
 barrel diameter: \_\_\_\_\_ mm barrel length: \_\_\_\_\_ mm crown: \_\_\_\_\_  
 Surface roughness: \_\_\_\_\_ µm Rz: \_\_\_\_\_ Ra: \_\_\_\_\_ Rmax: \_\_\_\_\_

## grinding process

results: process & settings:	Vs m/s	Vw 1/min	conti mm/min	feed mm/min	power % oder ampere	pass
rough grinding 1)						
rough grinding 2)						
finishing 1)						
finishing 2)						
finishing 3)						
superfinishing 1)						
superfinishing 2)						
spark out						
removal rate:	eff. grinding time:	roughness:	G-Ratio:	cutting rate:		

## 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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