

# TECHNICAL QUESTIONNAIRE

# Thread milling and thread whirling

Enquiry <input type="radio"/>	Test result <input type="radio"/>	Complaint <input type="radio"/>
<b>Agency:</b> _____		<b>Contact:</b> _____
<b>Customer:</b> _____		<b>E-mail:</b> _____
<b>Phone or fax:</b> _____		<b>Date:</b> _____
<hr/>		
<b>1. Tool type:</b> _____		
<b>Tool Ø:</b> _____		<b>Pitch:</b> _____
<b>Serie:</b> _____		<b>Coating:</b> _____
<hr/>		
<b>2. Material group:</b> _____		
<b>Material N°:</b> _____		<b>Hardness:</b> _____ N/mm <sup>2</sup> / HB / HRC
<b>Norm:</b> _____		<b>Elongation:</b> _____ %
<hr/>		
<b>3. Thread:</b> <input type="radio"/> internal <input type="radio"/> external <b>Hole:</b> <input type="checkbox"/> blind hole <input type="checkbox"/> through hole		
Threaded length: _____ mm		
Core hole Ø: _____		Depth: _____ mm
Counter-bore Ø: _____		Depth: _____ mm
<hr/>		
<b>4. Cutting speed (V<sub>c</sub>):</b> _____ m/min                      _____ l/min		
<b>Feed (f):</b> _____ mm/rev.		<b>Feed (f<sub>z</sub>):</b> _____ mm/tooth
<hr/>		
<b>5. Machine:</b> _____ <input type="checkbox"/> internal coolant		
Working position: <input type="checkbox"/> horizontal                      Tool attachment: <input type="checkbox"/> collet <input type="checkbox"/> Weldon / Whistle Notch		
<input type="checkbox"/> vertical <input type="checkbox"/> hydraulic chuck <input type="checkbox"/> hot / cold shrunk		
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<b>6. Lubricant:</b> <input type="radio"/> emulsion <input type="radio"/> cutting oil <input type="radio"/> air <input type="radio"/> mist		
Product: _____		
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<b>7. Tool change reason:</b> <input type="checkbox"/> tool wear <input type="checkbox"/> tool breakage		
<input type="checkbox"/> incorrect threading (inspected with gauge) <input type="checkbox"/> programme error		
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<b>8. Efficiency comparison:</b>		
Tool under test: _____		
Performance and observations: _____		
_____		
_____		
<hr/>		
<b>Remarks:</b> _____		
_____		
_____		
_____		