

# Questionnaire gear grinding

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

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



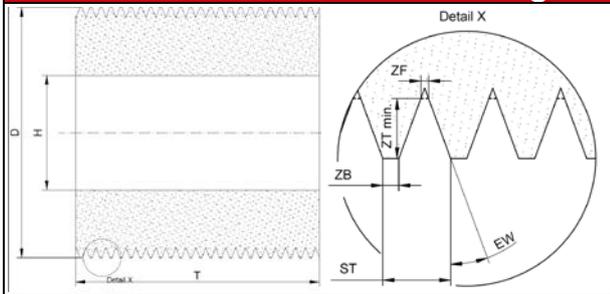
## grinding procedure

gear grinding  single flank 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 power: kw year of construction: \_\_\_\_\_

## grinding wheel



dimension (D[±0,2] x T[±0,2] x H[H8]): \_\_\_\_\_ mm  
 type:  contoured  non-contoured  
 normal modul: \_\_\_\_\_ angle of action (EW) [+0/-2,5°]: \_\_\_\_\_ °  
 number of starts:  clockwise  counterclockwise  
 face width (ZB) [±0,1] \_\_\_\_\_ mm  
 OPTIONAL: face depth (ZT) min.: \_\_\_\_\_ mm  
 OPTIONAL: face feet (ZF): \_\_\_\_\_ mm  
 OPTIONAL: pitch (ST)[±0,1]: \_\_\_\_\_ mm number of starts: \_\_\_\_\_

competitor: \_\_\_\_\_ quality: \_\_\_\_\_  sample  drawing enclosed

## workpiece

designation:  toothes gear  shaft material / standard designation.: \_\_\_\_\_ hardness/strength: \_\_\_\_\_  
 dimensions: normal modul: \_\_\_\_\_ number of teeth: \_\_\_\_\_ angle of action: \_\_\_\_\_ hand of helix: \_\_\_\_\_  
 tipdiameter: \_\_\_\_\_ root diameter: \_\_\_\_\_ pitchdiameter: \_\_\_\_\_  
 stock: \_\_\_\_\_ mm  radial  per flank state: \_\_\_\_\_  
 surface roughness: Rz: \_\_\_\_\_ Ra: \_\_\_\_\_ face feet grinding:  Ja  Nein

## grinding prozess

rough grinding				finish grinding			
revolutions: _____	1/min	revolution speed grinding wheel: _____	m/s	revolutions: _____	1/min	revolution speed grinding wheel: _____	m/s
number of passes: _____	infeed per pass: _____	mm	<input type="checkbox"/> radial <input type="checkbox"/> per flank	number of passes: _____	infeed per pass: _____	mm	<input type="checkbox"/> radial <input type="checkbox"/> per flank
axial feed-rate: _____	mm	tangential feed-rate: _____	mm	axial feed-rate: _____	mm	tangential feed-rate: _____	mm
power consumption: _____	kw/Ampere/%			power consumption: _____	kw/Ampere/%		
material removal rate (QW <sub>max</sub> ): _____	mm	grinding time: _____	s	material removal rate (QW <sub>max</sub> ): _____	mm	grinding time: _____	s
dressing after workpieces / teeth: _____	revolutions	dressing tool: _____	1/m	dressing after workpieces / teeth: _____	revolutions	dressing tool: _____	1/m
dressing amount: _____	mm	<input type="checkbox"/> radial <input type="checkbox"/> per flank <input type="checkbox"/> synchr. <input type="checkbox"/> asynchr.		dressing amount: _____	mm	<input type="checkbox"/> radial <input type="checkbox"/> per flank <input type="checkbox"/> synchr. <input type="checkbox"/> asynchr.	
number of dressing passes: _____	dressing lead: _____	mm		number of dressing passes: _____	dressing lead: _____	mm	
dressing ratio: _____	dressing volume: _____	m <sup>3</sup>	dressing time: _____	s	dressing ratio: _____	dressing volume: _____	m <sup>3</sup>
			dressing time: _____	s			

## further details

testing purpose: \_\_\_\_\_  
 annual requirements: \_\_\_\_\_  
 customer satisfaction Theleico: \_\_\_\_\_  
 notes: \_\_\_\_\_  
 drawing: \_\_\_\_\_  
 THELEICO draft proposal: \_\_\_\_\_

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

