Heule Tool Application Data Sheet
For Drilling

Company Name:_____   Date:_____

Contact Name:_____   Phone:_____

Address:_____   Fax:_____

City:_____State:_____ Zip:_____   Email:_____

Application Data

Part No.:_____ Description:_____ Workpiece Material:_____

Hardness:_____ Print (Yes or No):_____ Surface Quality of Workpiece:_____

Required Hole Surface Finish:_____ Hole Diameter Tolerance:_____ Position of Workpiece:_____

Hole Description: ☐ Blind ☐ Through ☐ Pre-Drilled ☐ Interrupted ☐ Cast Hole Actual Size:_____ Hole Depth:_____

☐ Single Pass
☐ Multiple Pass
☐ Reamed Hole
☐ Threaded Hole

Sketch:

Chip Form:

| 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 |

Machine Data

Drilling Info.:_____ Tool Holder:_____ Spindle RPM Range:_____

Drilling Angle:_____ Coolant Available (Yes or No):_____ ☐ Through Spindle ☐ External

Coolant Pressure:_____ Coolant Flow:_____ Compressed Air:_____

Type of Coolant: ☐ Soluble Oil ☐ Cutting Oil ☐ Synthetic Type of Tool Holder:_____ Bushing (Yes or No):_____

Distance to Workpiece:_____ Current Type of Cutting Tool in Use: ☐ HSS ☐ Inserted ☐ Carbide ☐ Other:_____

Flute Style: ☐ Fast ☐ Standard ☐ Slow ☐ Other:_____

Present Data

No. of Parts to be Machined (Month/Year):_____ No. of Holes Per Part:_____ Surface Footage (SFM):_____

Spindle Speed (RPM/SFM):_____ Feed (IPR/mm/u):_____ Feed (IPR/MPM):_____

Index Time:_____ Cut Time:_____ Tool Change Time:_____

No. of Holes Per Grind:_____ No. of Grinds Available Per Tool:_____ No. of Tools to Produce Job:_____

Objective

☐ Increase Holes Per Tool   ☐ Shorten Process Time   ☐ Improve Hold Finish   ☐ Eliminate 2nd Operation
☐ Combine Drilling/Deburring   ☐ Cut Multi-Diameter Holes in One Pass   ☐ Other:_____

Explanation:

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