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: ______

Sketch: ____________ Chip Form: ______

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: __________________________