

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: <input type="checkbox"/> Blind <input type="checkbox"/> Through <input type="checkbox"/> Pre-Drilled <input type="checkbox"/> Interrupted <input type="checkbox"/> Cast Hole Actual Size: _____ Hole Depth: _____		
<input type="checkbox"/> Single Pass <input type="checkbox"/> Multiple Pass <input type="checkbox"/> Reamed Hole <input type="checkbox"/> Threaded Hole	Sketch:	Chip Form:

Machine Data

Drilling Info.: _____	Tool Holder: _____	Spindle RPM Range: _____
Drilling Angle: _____	Coolant Available (Yes or No): _____	<input type="checkbox"/> Through Spindle <input type="checkbox"/> External
Coolant Pressure: _____	Coolant Flow: _____	Compressed Air: _____
Type of Coolant: <input type="checkbox"/> Soluble Oil <input type="checkbox"/> Cutting Oil <input type="checkbox"/> Synthetic	Type of Tool Holder: _____	Bushing (Yes or No): _____
Distance to Workpiece: _____	Current Type of Cutting Tool in Use: <input type="checkbox"/> HSS <input type="checkbox"/> Inserted <input type="checkbox"/> Carbide <input type="checkbox"/> Other: _____	
Flute Style: <input type="checkbox"/> Fast <input type="checkbox"/> Standard <input type="checkbox"/> Slow <input type="checkbox"/> 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

<input type="checkbox"/> Increase Holes Per Tool	<input type="checkbox"/> Shorten Process Time	<input type="checkbox"/> Improve Hold Finish	<input type="checkbox"/> Eliminate 2nd Operation
<input type="checkbox"/> Combine Drilling/Deburring	<input type="checkbox"/> Cut Multi-Diameter Holes in One Pass	<input type="checkbox"/> Other: _____	

Explanation:
