

# Questionnaire-Roll Grinding

CUSTOMER	CONTACT PERSON	DEPARTMENT

## MACHINE

MANUFACTUER/CUST.M/C NO.		YEAR OF CONSTRUCTION
M/C SPINDLE DRIVE POWER (KW)	CNC <input type="checkbox"/> MANUAL <input type="checkbox"/>	MAX.WHEEL SPEED (m/s)

## WORKPIECE

TYPE OF MILL	HRM <input type="checkbox"/>	CRM <input type="checkbox"/>	WORK ROLL <input type="checkbox"/>	INTERMEDIATE ROLL <input type="checkbox"/>	BACK-UP ROLL <input type="checkbox"/>
ROLL DIMENSION				MATERIAL ALLOWANCE (mm/φ)	
TYPE OF ROLL	CYLINDRICAL <input type="checkbox"/>	CAMBER/CROWING <input type="checkbox"/>		CVC <input type="checkbox"/>	
MATERIAL SPEC.				PERCENTAGE OF CHROMIUM	
ROLL HARDNESS (SHORE c, HRc, HV, EQUOTIP)			REQUIRED SURFACE ROUGHNESS (Ra, Rz)		
OTHER APPLICATION INFORMATION					
FIXTURE	BETWEEN CENTRES <input type="checkbox"/>			BEARING PILLOW <input type="checkbox"/>	

## GRINDING WHEEL

WHEEL DIMENSION (D x T x H-P x F/G)      (DRAWING NO)	WHEEL TYPE:	1 <input type="checkbox"/>	5 <input type="checkbox"/>	7 <input type="checkbox"/>	OTHER
CURRENT SUPPLIER	CURRENT SPEC.				

## OPERATING PARAMETERS

WHEEL SPEED (m/s)		ROLL SPEED (rpm)	
END INFEED (mm)		CONTINOUS INFEED (mm/min)	
TRAVERSE FEED (mm/min)		NUMBER OF GRINDING SEQUENCES	
SPEED RATIOS (q <sub>s</sub> )	OVERLAP RATIOS (U <sub>d</sub> )	REMOVAL RATES (Q' <sub>w</sub> )	
G-RATIO (dm <sup>3</sup> /dm <sup>3</sup> )	CYCLE TIME	WHEEL CONSUMPTION/YEAR	

## DRESSING

DRESSING TOOL	DRESSING INFEED (mm)	DRESSING SPEED (mm/min)
DRESSING SPEED RATIO (q <sub>d</sub> )	INFEED OF DIAMOND ROLL (a <sub>d</sub> )	NO: OF DWELL REVOLUTIONS

## TEST TARGET/ PROBLEMS

DATE	FILLED IN BY
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