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Certified according to ISO 9001:2015

Questionnaire

Company: _____ Contact person: _____ Date: _____

Stationary dressing tools

Dressing tool: _____ Type: _____ Manufacturer: _____

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(for special tools, please enclose sketch or drawings)

Grinding process

Cylindrical grinding ID grinding Surface grinding Profile grinding Tool grinding Other

Machine

Machine: _____ Type: _____ Year of manufacture: _____

Grinding wheel *(for profile wheels, enclose sketch of profile if necessary)*

Shape Dim. Specifications: _____ Manufacturer: _____

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Coolant

Internal cooling Dry Fully synthetic metal-working fluid Emulsion Oil Other

Workpiece *(enclose sketch or drawing if necessary)*

Dimensions: _____ Material: _____ unhardened / hardened HRC: _____

Parameters

	During dressing	During grinding
Circumferential speed of wheel (Vc)	[m/s]	[m/s]
Wheel speed	[min. ⁻¹]	[min. ⁻¹]
Dressing feed rate (per revolution)	[mm/min.]	
	[mm/rev.]	
Dressing infeed (per revolution)	[mm]	
Dressing frequency	[number]	
Roughing infeed		[mm]
Finishing infeed		[mm]
Where should dressing take place?	<input type="checkbox"/> on the circumference	<input type="checkbox"/> laterally <input type="checkbox"/> on the shoulder <input type="checkbox"/>

Observations

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Problems

Chatter marks Grinding burn Workpiece surface Dresser life Diamond chipping
 Loss of profile Shape defect Grinding defect No cutting No material removal
 Dimensional accuracy