

# TECHNICAL QUESTIONNAIRE

## THREAD CUTTING AND THREAD FORMING

Enquiry

Test result

Complaint

Agency : \_\_\_\_\_  
Customer : \_\_\_\_\_  
Phone or fax : \_\_\_\_\_

Contact : \_\_\_\_\_  
E-mail : \_\_\_\_\_  
Date : \_\_\_\_\_

1. Tool type : \_\_\_\_\_ Thread size : \_\_\_\_\_  
Particularity : \_\_\_\_\_ Class of tolerance : \_\_\_\_\_

2. Material group : \_\_\_\_\_  
Material N° : \_\_\_\_\_ Hardness : \_\_\_\_\_ N/mm<sup>2</sup> /HB/HRC  
Norm : \_\_\_\_\_ Elongation : \_\_\_\_\_ %

3. Thread :  blind hole  through hole Threaded length : \_\_\_\_\_ mm  
Core hole Ø : \_\_\_\_\_ Depth : \_\_\_\_\_ mm  
Counter-bore Ø : \_\_\_\_\_ Depth : \_\_\_\_\_ mm

4. Cutting speed (V<sub>c</sub>) : \_\_\_\_\_ m/min \_\_\_\_\_ 1/min  
Feed (f) : \_\_\_\_\_ %

5. Machine : \_\_\_\_\_  internal coolant  
Working position :  horizontal  vertical  
Rigid Tapping :  "Soft Rigid Tapping"  
 collet  Weldon  hot / cold shrunk  
Tapping spindle :  axial compensation  
 de-clutching  
 reversible  
 sliding clutch

6. Lubricant :  emulsion  oil  air  mist  
Product : \_\_\_\_\_

7. Tool change reason :  tool wear  tool breakage  
 thread not correct (checked with thread plug gauge)  tooth breakage in the chamfer lead  
 machine error  tooth breakage in the guiding thread

### 8. Efficiency comparison

Tool under test : \_\_\_\_\_  
Performance and observations : \_\_\_\_\_

Remarks : \_\_\_\_\_  
\_\_\_\_\_

