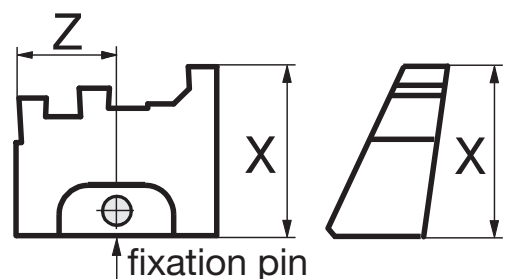
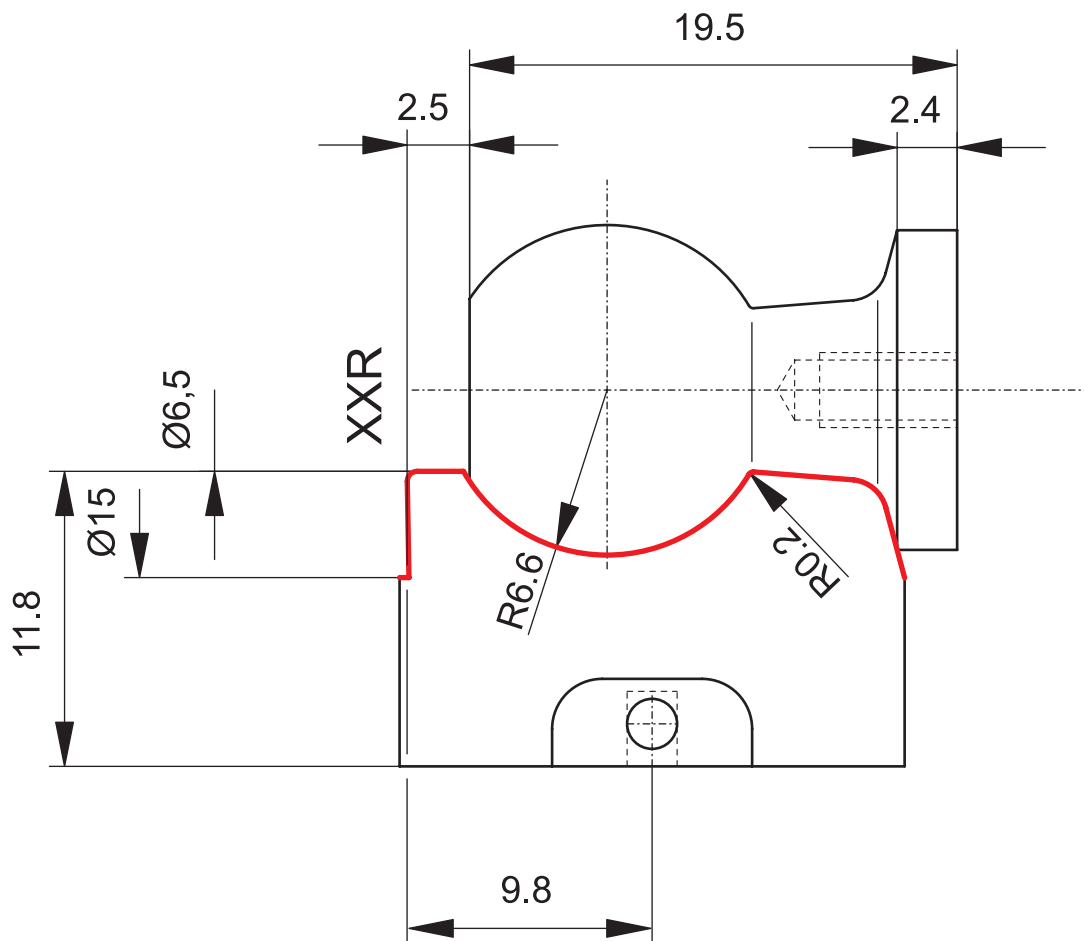


**Please define the desired tool in this data sheet
We manufacture according to your specifications.**

Workpiece data			
Drawing no. of the workpiece drawing			
What material is machined on the workpiece?			
What has to be machined? Please mark in red on the drawing.			
Sequence of machining			
<input type="checkbox"/> Internal form pre-grooving	<input type="checkbox"/> Internal form finish grooving		
<input type="checkbox"/> Radial pre-cutting of the form (external)	<input type="checkbox"/> Radial finish-cutting of the form (external)		
<input type="checkbox"/> Axial pre-cutting of the form (external)	<input type="checkbox"/> Axial finish-cutting of the form (external)		
<input type="checkbox"/> Tangential pre-peeling of the form (external)	<input type="checkbox"/> Tangential finish-peeling of the form (external)		
Machining and adjustment data			
Direction of rotation: <input type="checkbox"/> right, please mark the cut-off side with "XXR" on the drawing			
Direction of rotation: <input type="checkbox"/> left, please mark the cut-off side with "XXL" on the drawing			
Cut-off width: _____ mm		Tool positions:	
Setting/ positioning angle of the tool holder in the machine: _____ - degree			
Desired angle at the profile cutting edge			
rake angle - effective: _____ + degree		Face clearance angle: _____ + degree	
Side clearance angle: _____ + degree		Radial clearance angle: _____ + degree	
Choice of tool holders and Inserts (see catalog group 04)			
Fix-Profil holder type:			
Fix-Profil inserts type:			
Desired carbide grade:		Alternative cutting material:	
Desired tolerance		Desired surface quality Ra	
A	X _{max}	A	Z _{max}
<input type="checkbox"/> 0 = <	5 µm	<input type="checkbox"/> 0 = <	5 µm
<input type="checkbox"/> 1 = <	10 µm	<input type="checkbox"/> 1 = <	10 µm
<input type="checkbox"/> 2 = <	15 µm	<input type="checkbox"/> 2 = <	15 µm
<input type="checkbox"/> 3 = <	20 µm	<input type="checkbox"/> 3 = <	20 µm
<input type="checkbox"/> 0 = <	0.08 µm	<input type="checkbox"/> 0 = <	0.12 µm
<input type="checkbox"/> 1 = <	0.12 µm	<input type="checkbox"/> 1 = <	0.16 µm
<input type="checkbox"/> 2 = <	0.22 µm	<input type="checkbox"/> 2 = <	0.22 µm
<input type="checkbox"/> 3 = <	0.32 µm	<input type="checkbox"/> 3 = <	0.32 µm
Recommendations on profile			
Z:	mm	X:	mm
AL:	mm	GL:	mm
Designation:			
Fix-Profil holder:			
Fix-Profil inserts:			
Customer data			
KNR:		PNR:	
VKG:		Date:	
Handled and followed up by:			



Fix-Profil workpiece example



W3020 03 K10F
Direction of rotation: right
Cut-off 2.5 mm