

BURKA-KOSMOS Grinding Wheel Worksheet for Thread Grinding Machine

Customer: _____

Machine Type: _____

Machine Producer: _____

Date: _____

1. Workpiece Data:

Diameter = _____	Groove Width = _____ mm	Material = _____	Hardness _____ :
Length = _____	Groove Length = _____ mm	Groove Depth = _____ mm	Rough Depth _____
		Number of Grooves = _____	DIN-Qual.= _____

2. Details / Condition of Dressing Tool:

3. Dressing Data with Competitors Grinding Wheel :

Competitor: _____

Current Wheel Spec : _____

<u>Grinding Parameter:</u>											<u>Dressing Parameter:</u>					<u>Remarks:</u>			
Stroke Depth	Radial infeed per Flank (mm)						Strokes per Tooth	Feed mm / min	V= m/sec	Q'w	Grind Time min	Load Meter	Nr. Teeth	Amount mm	Speed mm/min	Speed Ratio	Dress Volume mm³	Over Lap	
	1.Stroke	2.Stroke	3.Stroke	4.Stroke	5.Stroke	7.Stroke													

4: Results of B-K Grinding Tests:

Wheel Size: _____

BK-Nr.: _____

BK-Spec.: _____

<u>Grinding Parameter:</u>											<u>Dressing Parameter:</u>					<u>Remarks:</u>			
Passes	Radial infeed per Flank (mm)						Strokes per Tooth	Feed mm / min	V= m/sec	Q'w	Grind Time min	Load Meter	Nr. Teeth	Amount mm	Speed mm/min	Speed Ratio	Dress Volume mm³	Over Lap	
	1.Stroke	2.Stroke	3.Stroke	4.Stroke	6.Stroke	7.Stroke													

Comments: (Inspection Diagram; Quality Achieved; Test for Burns; etc.)

Remarks: _____
