

Coolant Application Worksheet

Date:	Contact Name:
Customer Name:	Customer Location:

Process Input Parameters	Work Material
Machine:	Machine Type:
Workholding:	Wheel specification:
Grinding width (in):	Max. and min wheel diameter (in):
Wheelspeed (sfpm):	Work dimensions (in):
Stock removed/pass (in):	Total stock removed (in):
Infeed Rate (in/min)	Depth of cut per pass (in)

Sketch grind profile, m/c layout, current nozzle and position and indicate burn position

Process Output Parameters	Spec. Removal Rate (in ³ /min.in)
Wheel motor power rating (Hp):	Max. percentage load during grind (%):
Max. power during grind (Hp):	What quality issue exists?

Existing Coolant System	Nozzle aperture (in x in)
Number of bends and restrictions:	Coolant type:
Pump pressure (psi or ft head):	Nom. pump flowrate (GPM):
Feed pipe diameter (in):	Length of pipe after pump (ft):
Pump motor (Hp and RPM):	Pump spec. or model:

<p>New Coolant System, with sketches</p> <p>Required flowrate (GPM):</p> <p>Pressure to match wheel speed (psi):</p> <p>Width of nozzle (in):</p> <p>Jet thickness (in):</p> <p>Feed pipe diameter (in):</p> <p>Would a coherent jet help?</p> <p>Could nozzle be referenced off of part?</p> <p>Can nozzle combine multiple jets?</p>	<p style="text-align: center;">Suggested Layout</p>
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