

## Coolant Application Worksheet

Date:	Contact Name:
Customer name:	Customer location:

<b>Process Input Parameters</b>	Work Material
Machine:	Machine Type:
Workholding:	Wheel specification:
Grinding width (mm):	Max. and min wheel diameter (mm):
Wheelspeed (m/s):	Work dimensions (mm):
Stock removed/pass (mm):	Total stock removed (mm):
Infeed Rate (mm/sec)	Depth of cut per pass (mm)

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

<b>Process Output Parameters</b>	Spec. Removal Rate ( $\text{mm}^3/\text{s}\cdot\text{mm}$ )
Wheel motor power rating (W):	Max. percentage load during grind (%):
Max. power using FIS (W):	What quality issue exists?

<b>Existing Coolant System</b>	Nozzle aperture (mm x mm)
Number of bends and restrictions:	Coolant type:
Pump pressure (bar or m):	Nom. pump flowrate (l/min or $\text{m}^3/\text{hr}$ ):
Feed pipe diameter (mm):	Length of pipe after pump (m):
Pump motor rating (KW):	Pump spec. or model:

<p><b>New Coolant System, with sketches (use Optimisation Chart)</b></p> <p>Required flowrate (l/min):</p> <p>Pressure to match wheel speed (bar):</p> <p>Width of nozzle (mm):</p> <p>Jet thickness (mm):</p> <p>Feed pipe diameter (mm):</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>Will plenum design be possible?</p> <p>Does batch size justify card-key nozzle?</p>	<p style="text-align: center;"><b>Suggested Layout</b></p>
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