



RTC Rani Tool Corp.

205 Kelsey St., Unit #103, Newington, CT 06111

Tel: (888) 554-RANI or (860) 665-7771 • Fax: (860) 665-7319
E-mail: sales@ranitool.com • www.ranitool.com

Date: _____

Project #: _____

Slsmn: _____

CBN check list for hard turning and machining of cast iron & steel materials

Determination of the correct CBN grade and the correct insert dimension according to your customer's requests

Company Name: _____

Address: _____

Contact Person: _____ Telephone Number: _____

Workpiece Designation: _____ Drawing Number: _____

Distributor: _____ Sales person: _____ Tel: _____

Application Information:

Material: _____ Hardness: _____ Depth: _____

Cutting speed Vc: _____ Cutting feed rate Rough: _____ Finish: _____

<input type="checkbox"/> O.D. Turn Dia.: _____ D.O.C ap: _____ L.O.C.: _____ No. of passes: _____	<input type="checkbox"/> I.D. Bore Dia.: _____ D.O.C. ap: _____ L.O.C.: _____ No. of passes: _____	<input type="checkbox"/> Face Dia.: _____ D.O.C. ap: _____ L.O.C.: _____ No. of passes: _____
---	--	---

Cutting Parameters:

Continuous cut: Yes No Surface finish required: _____

Slightly interrupted cut: Yes No Special requirements and criterias: _____

Heavily interrupted cut: Yes No _____

Insert currently being used (complete competitor designation): _____

Cost of insert being used: _____ Number of cutting edges: _____

Quantity of workpieces manufactured with one cutting edge without offset adjustment: _____

Reason for end of tool life (Wear, part tolerance, surface quality...): _____

Obtained quantity / tool life (including all offsets): _____

Coolant: Yes No if yes, coolant type: _____ / Air: Yes No

Machine make / model: _____

Max. spindle speed rpm (parts smaller than 1.00" or 25mm dia.): _____

Workpiece clamping: Stable Unstable

Customer requirements (in order of importance, 1-6):

Increase cutting speed Vc: Increase cutting depth ap:

Increase feed rate fz: Increase tool life / workpiece:

Improvement of part tolerance: Improved surface quality Ra; Rz:

Further demands and remarks: _____