



RTC Rani Tool Corp.

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Date: _____

Project #: _____

Slsmn: _____

PCD check list for machining of non-ferrous materials

Determination of the correct PCD 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: _____ Silicon Content: _____

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: _____
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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: _____