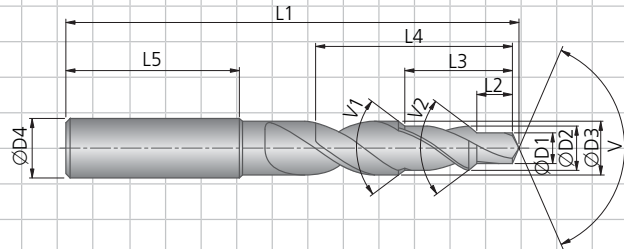


Fax to CountyLine Tool at 1-309-694-2445

Special tool quote request: Step drill

Company:	Contact:
Customer #:	Department:
Address:	Phone:
	Fax:
	E-Mail:

Workpiece sketch:



Tool: Step drill	Dimension	Tolerance
Ø D1		
Ø D2		
Ø D3		
Shank- D4		
L1		
L2		
L3		
L4		
Shank length L5		
Point angle V		
Chamfer angle V1		
Chamfer angle V2		
Number of cutting edges z	<input type="checkbox"/> 2	<input type="checkbox"/> 3
Tools required _____ pieces	Straight toothed <input type="checkbox"/>	
Workpiece _____ pieces / year	R.H. spiraled, spiral angle λ <input type="checkbox"/> $\lambda =$	
	L.H. spiraled, spiral angle λ <input type="checkbox"/> $\lambda =$	
Work material to be machined:	Cutting direction <input type="checkbox"/> Right <input type="checkbox"/> Left	
<input type="checkbox"/> Structural steel, good machining qualities	Coating <input type="checkbox"/> Yes <input type="checkbox"/> No	
<input type="checkbox"/> Tool steel	Internal coolant supply <input type="checkbox"/> Yes <input type="checkbox"/> No	
<input type="checkbox"/> Stainless steels	Straight shank <input type="checkbox"/> HA <input type="checkbox"/> HE <input type="checkbox"/> HB	
<input type="checkbox"/> Hardened steel	DIN 6535 <input type="checkbox"/> Other:	
<input type="checkbox"/> Malleable iron	Machine info	
<input type="checkbox"/> Spheroidal cast iron	Machine type	
<input type="checkbox"/> Non-ferrous metals (brittle)	Spindle type / size	
<input type="checkbox"/> Non-ferrous metals (ductile)	Spindle output (kW)	
<input type="checkbox"/> Other	Cutting speed v_c (m/min)	

Workpiece:

Tools required _____ pieces
Workpiece _____ pieces / year

Work material to be machined:

<input type="checkbox"/> Structural steel, good machining qualities	Material description
<input type="checkbox"/> Tool steel	Strength Rm (N/mm ²)
<input type="checkbox"/> Stainless steels	Hardness (HRC, HB, HV, ...)
<input type="checkbox"/> Hardened steel	
<input type="checkbox"/> Malleable iron	
<input type="checkbox"/> Spheroidal cast iron	
<input type="checkbox"/> Non-ferrous metals (brittle)	
<input type="checkbox"/> Non-ferrous metals (ductile)	
<input type="checkbox"/> Other	