SPECIAL APPLICATION ROTARY COOLANT GLAND ASSEMBLY QUESTIONNAIRE

For a custom adaptation to suit your machining center, please fill out this questionnaire & fax to (1-216-481-9966) or email to sales@coolantfedtooling.com.

We will respond promptly to your request for quotation.

COMPANY _____

ADDRESS _____

PHONE _____ *FAX* _____ *CONTACT* _____

INDICATE YOUR GEORGE WHALLEY DISTRIBUTOR OR CONTACT _____

MACHINE SPECIFICATIONS :

1. All possible data, including manufacturer's name, model name, model number, serial number and whether vertical or horizontal?

_____

_____

2. Machine horsepower? _____

MACHINE LIMITATIONS

1. For purposes of positioning the tool holder and coolant gland in proper relation to the machine spindle, advise what means of orientation is used?

A. Drive key _____

B. Drive slot _____

C. Other _____

2. What is the weight limitation of the holder?

A. With the cutting tool _____

B. Without the cutting tool _____

3. What is the maximum length clearance of the holder? _____

A. With the cutting tool _____

B. Witout the cutting tool _____

4. What is the centerline distance on the tool carousel for maximum tool diameter? _____

SPINDLE

1. What is the maximum R.P.M. of the machine spindle?

2. What is the R.P.M. requirement for the tool being used in this application?

_____

_____

3. What is the inside taper (bore) of the spindle (i.e. 30, 35, 40, 45, 50, 60 V-Flange or BT, etc.) _____

4. What is the bolt circle diameter on the face of the spindle? _____

_____

5. What is the thread size and spacing og the bolts in the spindle bolt circle?

_____

_____

HOLDER

1. What types of cutting tools will be used? (Indicate shank specifications for each.) _____

2. Specify type of holder required: _____

A. End Mill (Bore size) _____

B. Collet Chuck (Capacity) _____

C. Morse Taper _____

D. Other _____

POSITIVE SEAL ADJUSTMENT STOP SCREWS

IMPORTANT!
COLLET CHUCK USERS PLEASE READ

The introduction of The George Whalley Company's positive seal adjustment stop screws provides a solution to a major problem in coolant-fed machining operations. Coolant-fed cutting tools are able to deliver coolant to the cutting edge to assist cooling and chip ejection but this advantage can be seriously reduced when leakage at the stop screw decreases the coolant flow and pressure. The various standard adjustment stop screws generally in use in the machining industry for adjusting cutting tool length have basic disadvantages when used with coolant-fed tools. Steel stop screws have no sealing capability and are of little use in coolant-fed operations. Industry standard nylon capped steel stop screws provide a coolant seal where the tool shank meets the nylon cap but considerable leakage and loss of coolant pressure occurs around the screw threads. Solid nylon stop screws can provide a solution to this problem however they tend to be subject to wear when frequent tool adjustments are required. The George Whalley Company can provide all of the proceeding stop screws to interchange with industry standard holders. We strongly recommend our exclusive positive seal stop screw which will eliminate leakage and will handle necessary pressures to allow peak performance to the cutting tool. The George Whalley Company's positive seal adjustment stop screw also has the advantage of using fine screw threads for finer tool length adjustment. The illustrations and text which follow explain their use and capability.