

FB – Nr. 064 sb	Quality Management Form	SCHUNK 
Update status: 04	Questionnaire Special Chuck Jaws	Page 2 of 4

1. Workpiece											
☐ Raw part - Drawing No.					☐ Finished part - Drawing No.						
Roundness precision [mm]:			True running:			Should symmetries be taken in account?:					
Please note: Mark the clamping areas, workpiece locating surface and the contact surface colored											
☐ Sample workpiece will be sent in					Material: (Draw in the workpiece machining!)						
☐ Drawings as IGES, TIFF, Pro-E, STEP, DWG or DXF file available (Please sent it to the customer)											
2. Workpiece machining											
☐ turning ☐ grinding ☐ Rear-sided machining (indicate measurements for the clearance zones) ☐ milling, drilling, reaming ☐ driven tools (Interfering edges - Please indicate clearance zone for the tools) ☐ Positioning required											
Cutting speed:		m/min		V-constant:		☐ yes ☐ no		Feeding rate: mm/U		Cutting depth: mm	
3. Jaw version											
1. Set up		☐ external clamping				☐ internal clamping					
Clamping design		☐ hard		☐ soft							
		☐ round		Clamping-Ø: mm		☐ eccentric		Eccentricity: mm			
		☐ square		Edge length 1: mm		Edge length 2: mm		☐ adjustable			
		☐ other workpiece geometries									
Clamping contour		☐ Claw jaws (i.e. SZA/SZKA)		☐ Diamond serration (less clamping marks)		☐ Clamping inserts type HM, HS or UGE					
		☐ special clamping insert		Option: ☐ adjustable							
Back stop		Clamping depth: mm									
		☐ directly in the jaws		☐ with workpiece stop (type AB)							
		☐ separate workpiece stop (e.g. Radial support, workpiece stop)									
Description:											
2. Set up		☐ external clamping				☐ internal clamping					
Clamping design		☐ hard		☐ soft							
		☐ round		Clamping-Ø: mm		☐ eccentric		Eccentricity: mm			
		☐ other workpiece geometries									
Clamp. contour		☐ smooth		☐ Quentes		☐ Diamond serration					
Back stop		Clamping depth: mm									
		☐ directly in the jaws		☐ with workpiece stop (type AB)							
		☐ separate workpiece stop (e.g. Radial support, workpiece stop)						☐ air control			
Accuracy		☐ Slot and serration milled		☐ Slot and serration ground							
		☐ Clamping-Ø and workpiece stop pre-turned for finish turning on the matching chuck at the customer (recommended for the required true running accuracy of <0,03mm on the chuck)									
		☐ Clamping-Ø and workpiece stop turned on a SCHUNK-device, true and planned running accuracy of 0,03 mm (without taking into account the run-out of the chuck)									
Description:											

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4. Pendulum jaws (thin-walled, noncircular or conical workpieces)			
☐ 6-point clamping		☐ radial	☐ axially
☐ 12-point clamping		☐ radial	☐ axially and radial
5. Lathe chuck: (Note: In case of a special chuck enclose a drawing!)			
Manufacturer:		Type and Size:	Number of Jaws:
Jaw interface:	☐ Slot and serration	Width of slot: mm	Serration: ☐ Tongue and groove
	Special serration:		
6. Machine			
Machine manufacturer:		Machine type:	Machine number:
Max. swing-Ø:	mm		
Machine direction:	☐ horizontal ☐ vertical		
Loading:	☐ manual ☐ automatic (indicate disturbing edges for the handling device)		
7. Design			
☐ SCHUNK title block & frame		☐ Customer title block & frame	
☐ Documentation as:		Marking of the jaws:	
8. Balancing			
☐ dynamically balanced together with the workpiece Please note: In case of an order, please send in a workpiece sample!			
☐ CAD balanced Please note: In case of an order it is imperative to send a 3D body of the workpiece!			

Top-projects - technically outstanding/elevated duplication potential			
Application			
Customer benefits			
Function			
Application domains			
Reference customer	☐ Publishing (secret customer)	☐ Publishing (public customer)	☐ Testimonial ☐ Field report
Photo	☐ Complete mounting	☐ Single component	☐ Permission Drawing

	Bearbeitungsbegleitbogen Sonder-Spannbacken Anlage FB064 sb		AC:	Wunschtermin:	Lieferversprechen:
			Auftrags-Nr. AS 400:		Auftrags-Nr. SAP:
			Datum AE:	Ende KO/G-Zg.:	Ende AV:
Angebots-Nr.:	Kundennummer:	Konstruktionsaufwand: h			
Positionen:	Lfz.-Konstruktion:	Wochen	Kundenname:		
Ähnlich wie:	Lfz.-Herstellung:	Wochen	Bearbeiter:		
Vertrieb / Auftragsabwicklung		Konstruktion	Arbeitsvorbereitung		
Name Vertragspr.:	Name:		Name:		
Datum:	☐ Rücksprache mit TV vor Konstruktionsbeginn Erl. Datum:		☐ Rücksprache mit KON vor AV- beginn		
Funktionskontrolle	Format		ggf. abweich. Termin: KW		
☐ NEIN JA, ☐ mittels ProE (CAD) ☐ vorhanden ☐ angefordert am: ☐ mittels Werkstück ☐ vorhanden ☐ angefordert am:	☐ Rücksprache mit AV nach Erstellung erster Pos. (bei mehreren ähnlichen Konstruktionen) G – Zeichnung ☐ JA ☐ NEIN z. Hd. v. ☐ Herr / ☐ Frau E-Mail: Ausgang am: Eingang am: Außendienst in Kopie (auszufüllen vom TV): ☐ JA ☐ NEIN Name AD:		Erl. Datum: Material Bestellt am:		
☐ TV-Sachbearbeiter hinzuziehen	☐ Bestelltextänderung nach Genehmigung:				
Ausführung/G-Zeichn. prüfen im TV	Terminverschieb. nach G-Zeichn.?		Auswärtsbearbeitung		
☐ JA ☐ NEIN Name: Datum: Prüfung nach FB 554:	☐ NEIN ☐ JA - interne Ursache ☐ JA - Verzug durch Kunde		Anfrage am:		
Bemerkungen					
(z. B. Zwischenbescheid, G-Zeichnungsformat, Dokumentationen, Verpackung, Wuchten,...)					