



Karl Roll GmbH & Co. KG • Reinigungssysteme
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Management Handbuch

FO 7.1.3E Produktrealisierung
 Fragebogen zur Angebotserstellung Extern

Autor: Hr. T. Oberauer
 Datum: 24.04.2012
 Status: Freigegeben
 Revision: 04

Company:

Contact person:

Address:

Phone/-fax:

Zip code / place:

E-Mail:

Problem description:

Material:	steel	steel galvanized	stainless steel	aluminium
	brass	al- diecasting	zinc diecasting	grey cast iron
	steel diecasting	hard metal	glass	opt.-glass
	copper	plastics		

Work piece geometry:

Please attach drawings and / or photos if possible!

Type of work piece:	bulk material	scooping parts	sensitive surfaces	individually placed parts
Dimensions of the parts (LxWxH [mm]):	min:		max:	avrg.
Weight of the parts [kg]:	min:		max:	avrg.

Kind of contamination:

oil	emulsion	honing oil	swarf	drawing agent	lapping paste
separating agent	grinding swarf	epoxy resin	resin	polishing paste	zinc stearate
adhesive substance	rust	varnish	hardening salts	soldering flux	oil carbon

Please indicate quantities:

Transport inside the cleaning machine:

Baskets / racks available? yes no

Baskets / rack dimension (LxWxH [mm]):

Basket / rack weight incl. work pieces [kg]:

Throughput / Capacity:

Number of baskets or work pieces per hour:

Shifts per day:	1	2	3	á 7h	á 8h	á	hours/shift
Working days / week:	5	6	7				

Operating cycle subsequent to cleaning:

inspection	packing	assembly	storage	hardening	electropolating
coating	soldering	quench & temper	welding	electro-beam welding	
bonding	annealing				



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Condition of the work pieces when leaving the cleaning plant:

dry	moist	wet	drying by sensible heat	
primary cleaning	free from grease	free from swarf	spotless	preserved

Special requirement concerning residual contamination ?

Please attach details on the procedure and residual contamination specification.

gravimetric	mg/cm ²	particle max.	µm		
Test procedure:	rinsing without pressure	rinsing	bar	ultrasonics	W/ltr

Required temperature of parts when leaving the cleaning plant [°C] :

Cleaning procedure:	current procedure:	aqueous	per-/	trichloroethylene	hydrocarbon / modified alcohol
	requested procedure:	aqueous	perchloroethylene		hydrocarbon / modified alcohol

Bath sequence and time:

(e.g. 180 sec cleaning – 60 sec rinsing 1 –
60 sec rinsing 2 – 180 sec hot air)

Loading / Unloading:	manual	fully automatic	interlinked with other machines
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Available space for the cleaning plant (L x W x H [mm]):

Please attach shop floor layout if possible!

carrying force of crane [kg]:	admissible floor pressure [kg/m ²):	door / doorway dims. (L x W x H [mm]):
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Electric connection:	connected load [V / Hz]:	control voltage [V / Hz]:
	zero wire loadable	zero wire not loadable

Heating method:	electrical	process steam: pressure [bar]	hot water: at flow temp. [°C] / pressure [bar]
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Additional information for aqueous machines:

DI water:	available	to be offered	not required
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Sewage water plant:	available	to be offered	not required
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Tap water:	water hardness [°dH]		<i>Please attach water analysis!</i>
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Cooling water:	available	to be offered if necessary	Flow temperature [°C]:	Flow pressure [bar]:
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Schedule:	Cleaning trials:	Offer:	Commissioning:	Budget available:
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Notes / space for sketches: