PLEASE ENCLOSE WITH THE CONSIGNMENT

REGRINDING ORDER ACCOMPANYING DOCUMENT

GENERAL INFORMATION

CUSTOMER (SENDER)

COMPANY	DEPARTMENT
STREET, NO.	
ZIP CODE	CITY
TELEPHONE	E-MAIL
CONTACT PERSON	

DATE OF THE ORDER	
CUSTOMER NUMBER AT THE DISTRIBUTOR	

The dispatch to the H&V regrinding service can take place via your H&V distributor or directly from you to our headquarters. The reconditioned tools are also returned via your H&V distributor or, if requested, directly to you.

Communication and invoicing are handled **exclusively** by your H&V distributor.

Please note our **regrinding information**.

H&V DISTRIBUTION PARTNER

COMPANY	
STREET, NO.	
ZIP CODE	CITY

DISPATCH

☐ via H&V distributor ☐ directly to H&V headquarters in Steinkirchen

RETURN

☐ via H&V distributor ☐ directly to the customer

REGRINDING ORDER

☐ Process all tools in accordance with H&V factory / standard specifications (special requests will extend the delivery time)

Total number of tools:

INDIVIDUAL RECORDING

(ONLY NECESSARY FOR SPECIAL REQUESTS)

Article no.:	Designation:	Quantity:

☐ Add extra undercut with ____ mm insertion length (even if DIN 6535 is no longer met)

☐ H&V Original Coating ☐ Uncoated ☐ AlTiN (universal) – grey ☐ TAC (aluminium) – rainbow colour ☐ AlTiSiN (hardened steel) – copper colour	☐ Face grinding only ☐ Peripheral grinding only ☐ Cutting length < 1XD wanted / allowed ☐ Cutting diameter < 90% of original allowed / wanted

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GENERAL REGRINDING INFORMATION

- Regrinding orders can only be accepted if the regrinding order accompanying document provided by H&V is used for recording. Orders without this form cannot be processed.
- Tool reconditioning always includes regrinding and, depending on the case, edge preparation and subsequent coating.
- We regrind solid carbide milling cutters with a cutting diameter of 6 mm or more; drills are reground with a cutting diameter of 5 mm or more.
- If you require certain minimum dimensions for your tools, please inform us of these in writing when you submit your order. Certain tool shortenings are carried out automatically in accordance with the industry standard and the technical state of the art as soon as the respective wear marks are reached or the wear is so great that regrinding is otherwise no longer possible.
- The tools are ground in accordance with DIN 6535. If a tool has to be shortened during regrinding, the original insert length (undercut) is not restored by default.
- Tools that cannot be regrinded due to excessive wear or improper use/ modification will be returned in unprocessed condition and marked accordingly.
- All aluminium milling cutters – including the EXN1 series – generally receive a finish grind. Additional polishing is not provided and is not offered as a separate service.
- As standard, tools are reground to up to 90% of their original cutting diameter. Further reduction of the diameter is only possible upon special request.
- Tools are only reground if at least 1×D cutting length remains (except for tools that are originally designed with a shorter cutting length, e.g. face milling cutters). A further reduction in cutting length is only possible upon additional request.

TOOL-SPECIFIC REGRINDING INFORMATION

Blademaker (face torus cutter)	Can only be reground very slightly on the face side.
Chipmaker (trochoidal cutter)	The chipbreakers are only reground as soon as it is technically necessary. Until then, normal grinding of the circumference is carried out, as otherwise the tools would have to be reduced too much in diameter.
Slotmaker (roughing cutter)	Are not reground on the cord profile and circumference, but only in the chip space and on the circumferential chamfer. Are almost always shortened in the length of the main wear.
Rowmaker (full radius cutter)	Are not reground in diameter, but only on the radius.
Coremaker (spiral drill)	Are only reground on the face side and shortened to the end of the wear.

REGRINDING INFORMATION FOR THIRD-PARTY TOOLS

- Tools are coated with AlTiN as standard, unless otherwise requested.
- Only the three coating variants listed in the accompanying document are available.
- Uncoated tools will be returned uncoated unless otherwise requested.

DELIVERY TIME

without color layer	21 calender days
with color layer	28 calender days

Delivery area: We only offer the original regrinding within the EU.

All regrinding orders must be sent to our headquarters in Steinkirchen.

We are also happy to regrind other types of tools for you on request. Contact us for your customised offer.

HOFMANN & VRATNY OHG
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