

## POLISHING ON CLM 500 AWS



### Process specification

Machine	CLM 500 AWS
Working cylinder	lapping cylinder
Pieces per load	2
Stock removal	1 $\mu\text{m}$
Cycle time without handling	15:00 min.

### Parts description

Material	$\text{Al}_2\text{O}_3$ ceramics
Previous operation	ground
Dimensions	$\varnothing 60 \times 150 \text{ mm}$

### Premachined condition

Base size	ground in tolerance
Surface Ra	0.3 $\mu\text{m}$
Rt	4.5 – 5.0 $\mu\text{m}$

### Results

Ra	< 0.1 $\mu\text{m}$
Rt	< 1.3 $\mu\text{m}$
—	< 1 $\mu\text{m}$
O	< 5 $\mu\text{m}$
/O/	< 5 $\mu\text{m}$