

FLATHONING ON DLM 500



Process specification

Machine	DLM 500
Working wheel	CBN 46
Stock removal	110 μ /min.
Pieces per load	140
Cycle time without handling	3'
Rinsing agent	honing oil

Parts specification

Material	100 Cr ₆
Hardness	60 - 65 HRC
Previous operation	turned, hardened and tempered
Dimensions	\varnothing 21 x 11.2 mm

Premachined condition

Base size	11.310 \pm 0.035 mm
Surface	glide grinded
Flatness	0.03 mm
Parallelism	0.05 mm

Results

Tolerance in dimension	\pm 2 μ
Cpk	1.33
Ra	0.15 μ
Rz	1.5 μ
Flatness	1 μ
Parallelism	2 μ
Surface optical:	
crosshatch finish	