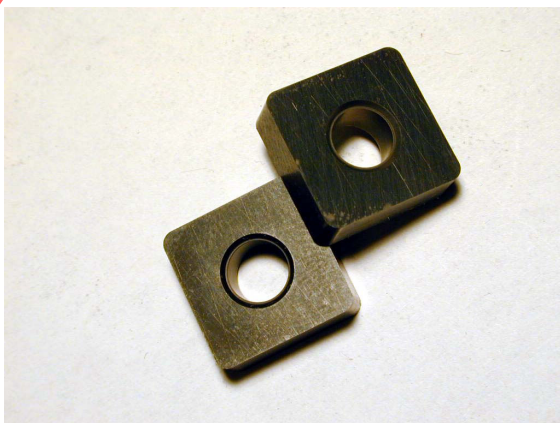


FLATHONING ON DLM 700



Process specification

Machine	DLM 700
Working wheel	D 25
Stock removal	250 μ /min.
Cycle time without handling	2.5'
Rinsing agent	honing oil

Parts specification

Material	carbide
	Rx 622
Previous operation	sintered
Dimensions	12x12 mm

Premachined condition

Base size	3.0 mm
Surface	sintered
Flatness	0.1 mm

Results

Tolerance in dimension	$\pm 2.5 \mu$
Cpk	1.33
Ra	0.2 μ
Rz	2 μ
Flatness	1 μ
Surface optical:	
crosshatch	