

FLATHONING ON DLM 700



Process specification

Machine	DLM 700
Working wheel	D76
Stock removal	420 μ /min.
Pieces per load	90
Cycle time without handling	2'
Rinsing agent	honing oil

Parts specification

Material	Al ₂ O ₃ ceramics
Previous operation	sintered
Dimensions	Ø 44x6 mm

Premachined condition

Base size	6.4 mm
Surface	raw
Flatness	0.2 mm
Parallelism	0.3 mm

Results

Tolerance in dimension	$\pm 5 \mu$
Cpk	1.33
Ra	0.4 μ
Rz	4 μ
Flatness	1 μ
Parallelism	2 μ
Surface optical:	
crosshatch	