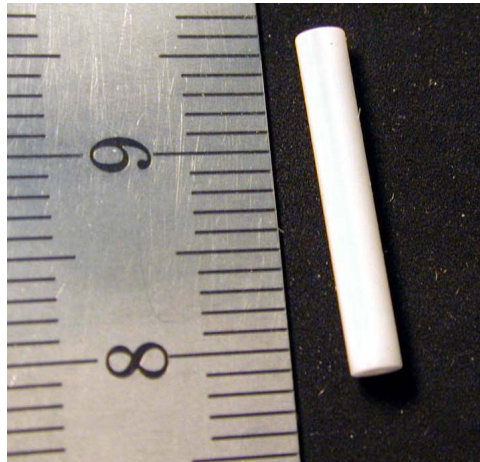


## CYLINDRICAL LAPPING



### Process specification

Machine	FLM 500-R
Working wheel	GG
Stock removal	2-5 $\mu$ /min.
Pieces per load	200
Cycle time without handling	5'
Lapping compound	AWS-RB

### Parts specification

Material	Al <sub>2</sub> O <sub>3</sub> ceramics
Previous operation	grinded
Dimensions	Ø 2.4 x 18 mm

### Premachined condition

Base size	2.4 mm
Surface	grinded
Flatness	0.002 mm
Parallelism	0.002 mm

### Results

Tolerance in dimension	$\pm 0.1 \mu$
Cpk	1.33
Ra	0.05 $\mu$
Rz	0.02 $\mu$
Flatness	0.01 $\mu$
Parallelism	0.05 $\mu$
Surface optical:	
crosshatch	