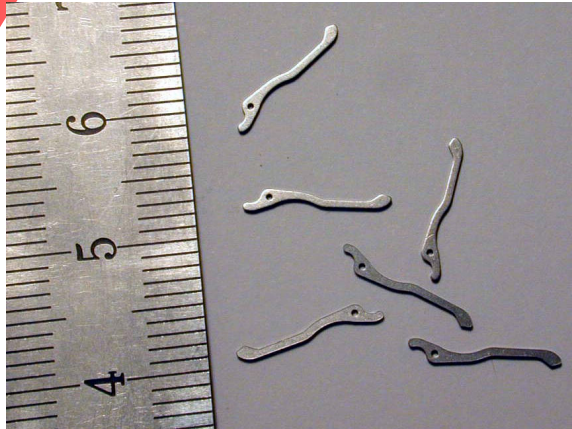


## LAPPING ON FLM 400



### Process specification

Machine	FLM 400
Working wheel	GG
Stock removal	50 $\mu$ /min.
Pieces per load	2'700
Cycle time without handling	30'
Lapping compound	AWS-SIC800

### Parts specification

Material	steel H1
Previous operation	stamped
Dimensions	1x12 mm

### Premachined condition

Base size	0.35 mm
Surface	stamped
Flatness	0.02 mm
Parallelism	0.03 mm

### Results

Tolerance in dimension	$\pm 5 \mu$
Cpk	1.33
Ra	0.02 $\mu$
Rz	0.5 $\mu$
Flatness	2 $\mu$
Parallelism	5 $\mu$
Surface optical:	dull, lapped