

FLATHONING ON DLM 700



Process specification

Machine	DLM 700
Working wheel	D 25 / D125
Stock removal	500 μ /min.
Pieces per load	35
Cycle time without handling	8'
Rinsing agent	honing oil

Parts specification

Material	steel / bronze
Previous operation	turned
Dimensions	\varnothing 80x6 mm

Premachined condition

Base size	6.3 mm
Surface	turned
Flatness	0.5 mm
Parallelism	0.7 mm

Results

Tolerance in dimension	$\pm 5 \mu$
Cpk	1.33
Ra bronze / steel	0.2 μ / 0.7 μ
Rz	2.0 μ / 6 μ
Flatness	2 μ
Parallelism	3 μ
Surface optical:	
crosshatch finish	