

FLATHONING ON ZL 501



Process specification

Machine	ZL 501
Working wheel	B91
Stock removal	67 μ /min.
Pieces per load	80
Cycle time without handling	3'
Rinsing agent	Oil

Parts specification

Material	steel
Previous operation	turned on a lathe
Dimensions	\varnothing 21 x 12.25 mm

Premachined condition

Base size	12.45 mm
Surface	turned on lathe

Results

Tolerance in dim.	\pm 5 μ
Cpk	1.33
Ra	0.11 μ
Flatness	0.75 μ
Parallelism	<1 μ
Surface optical:	crosshatch