

FLATHONING ON DLM 705



Process specification

Machine	DLM 705
Working wheel	D126
Tx μ/min.	104 - 224
Pieces per load	48
Cycle time without handling	2'30"
Rinsing agent	Oil

Parts specification

Material	16MnCrS5
Previous operation	feingestantzt
Dimensions	50,9x5,35 mm

Application Drilling machine

Premachined condition

Base size	5,35 mm
Surface	feingestantzt
mit Stanzgrat	bis 5,56 mm

Results

Tolerance in dim.	5,0 +0,08 / 0 mm
Cpk	1.33
Ra	0.6 μ
Flatness	1 μ
Parallelism	2 μ
Surface optical:	crosshatch