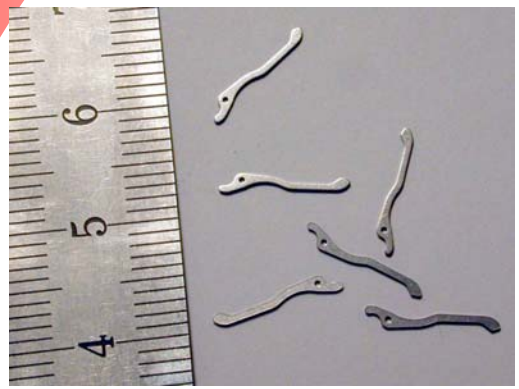
STÄHLI
FEELING FOR FINISHING

LAPPING ON FLM 400



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

Process specification

Machine FLM 400

Working wheel GG

Stock removal 50 µ

Pieces per load 2‘700

Cycle time without handling 30:00 min.

Lapping compound AWS-SIC800

Results

Tolerance in dimension ± 2 µ

Cpk 1.33

Ra 0.02 µ

Rz 0.5 µ

Flatness 2 µ

Parallelism 5 µ

Surface optical: mat, lapped

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POLISHING ON FLM 500

Parts specification

Material	155CrVMo121 (K110) hardened
Previous operation	ground
Dimensions	Ø 60 x 80 mm

Premachined condition

Surface	ground
Flatness	0.02 mm

Process specification

Machine	FLM 500
Working wheel	tin
Stock removal	20 µ/min.
Pieces per load	21
Cycle time without handling	20:00 min.
Lapping compound	AWS-1-2-PTG-RS

Results

Tolerance in dimension	± 5 µ
Cpk	1.33
Ra	0.002 µ
Flatness	0.3 µ
Parallelism	3 µ
Surface optical:	polished

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FLATHONING ON FLM 500

Process specification

Machine	FLM 500
Working wheel	cast iron slotted
Stock removal	30 µ
Pieces per load	240
Cycle time without handling	30:00 min.
Machining agent	Sic

Parts description

Material	Iridium / platinum
Previous operation	precision milling
Dimensions	16 x 14 x 0.3 mm

Premachined condition

Base size	0.325 mm
Surface	milled

Results

Tolerance in dim.	0.3 mm + 2 µ
CpK	1.33
Ra	0.050 µ
Flatness	0.002
Parallelism	0.001 µ
Surface optical:	crosshatch