**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: ± 2 μ
- Cpk: 1.33
- Ra: 0.02 μ
- Rz: 0.5 μ
- Flatness: 2 μ
- Parallelism: 5 μ
- Surface optical: mat, lapped

**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
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
FLATHONING ON FLM 500

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

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

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