

LAPPING ON FLM 1000



Process specification

Machine FLM 1000
Working wheel cast iron
Stock removal 20 μ
Pieces per load 30
Cycle time without handling 20:00 min.
Lapping compound AWS-SIC500

Parts specification

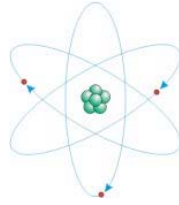
Material AlMgSi1Wa
Previous operation turned
Dimensions \varnothing 82 x 7.85 mm

Premachined condition

Base size 7.85 mm
Surface turned
Flatness 0.02 mm
Parallelism 0.03 mm

Results

Tolerance in dimension $\pm 2 \mu$
Cpk 1.33
Ra 0.08 μ
Rz 1 μ
Flatness 0.4 μ
Parallelism 1 μ
Surface optical: mat, lapped



LAPPING ON FLM 750



Process specification

Machine FLM 750
Working wheel Multi metal
Pieces per load 3
Cycle time without handling 6:00 min.
Rinsing agent Diamond 2-4

Parts specification

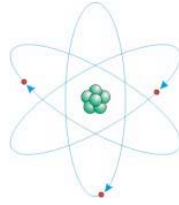
Material cast iron, coated
Previous operation ground
Dimensions \varnothing 150 mm

Premachined condition

used piece

Results

Ra 0.02 μ
Flatness 0.0003 μ
Surface optical: mat, lapped



LAPPING ON FLM 750



Process specification

Machine	FLM 750
Working wheel	Multi metal
Pieces per load	3
Cycle time without handling	2:00 min.
Rinsing agent	Diamond 2-4

Parts specification

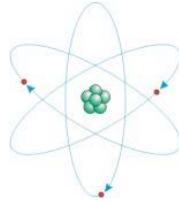
Material	cast iron, coated
Previous operation	grinded
Dimensions	Ø 120 mm

Premachined condition

used piece

Results

Ra	0.01 µ
Flatness	0.0003 µ
Surface optical:	mat, lapped



LAPPING ON FLM 750



Process specification

Machine	FLM 750
Working wheel	Multi metal
Pieces per load	9
Cycle time without handling	3:00 min.
Rinsing agent	Diamond 2-4

Parts specification

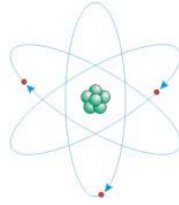
Material	cast iron
Previous operation	ground
Dimensions	Ø 80 mm

Premachined condition

used piece

Results

Ra	0.01- 0.02 µ
Flatness	0.0003 µ
Surface optical:	mat, lapped



LAPPING ON FLM 750



Process specification

Machine FLM 750
Working wheel Multi metal
Pieces per load 18
Cycle time without handling 3:00 min.
Rinsing agent Diamond 2-4

Parts specification

Material stainless steel
Previous operation ground
Dimensions \varnothing 60 mm

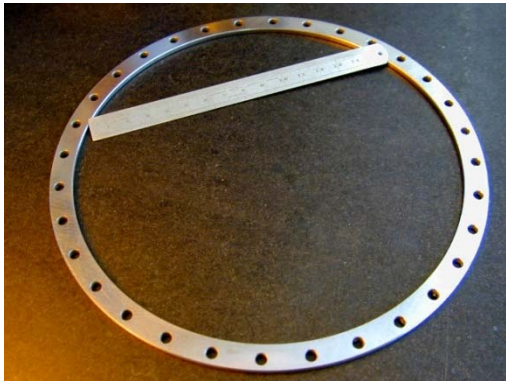
Premachined condition

used piece

Results

Ra 0.01- 0.02 μ
Flatness 0.0003 μ
Surface optical: mat, lapped

LAPPING ON FLM 1000



Process specification

Machine	FLM 1000
Working wheel	lapping wheel
Stock removal	-
Pieces per load	3
Cycle time without handling	-
Rinsing agent	-

Parts description

Material	stainless steel
Previous operation	-
Dimensions mm	Ø 210 x Ø 194 x 2.8

Premachined condition

Base size	-
Surface	-

Results

Tolerance in dim.	-
CpK	-
Ra	-
Flatness	0.0005 mm
Parallelism	-
Surface optical:	-

LAPPING ON FLM 1000



Process specification

Machine	FLM 1000
Working wheel	Cast iron, grooved
Pieces per load	72 pcs
Cycle time without handling	approx. 38:00 min.
Rinsing agent	Oil

Parts description

Material 31CrMoV9+QT

Dimensions D= 31,9 x L = 62,1 mm

Premachined condition

Base size 62,090 – 62,080

Surface turned on a lath

Results

Tolerance in dim.	- 150 μ
Cpk	>1.00
Ra	< 0,07 μ
Flatness	6 – 8 μ (convex)
Surface optical:	lapped and rectified

FLATHONING ON FLM 1000



Process specification

Machine	FLM 1000
Working wheel	D 46
Stock removal	100 μ
Pieces per load	24
Cycle time without handling	4:00 min.
Rinsing agent	Oil

Parts description

Material	sintered metall
Previous operation	turned on a lath
Dimensions	\varnothing 125 x 22 mm

Premachined condition

Base size	22.1 mm
Surface	turned on a lath

Results

Tolerance in dim.	2.5 mm, \pm 40 μ
Cpk	1.33
Ra	0.4 μ
Flatness	10 μ
Parallelism	30 μ
Surface optical:	bright, cross hatch