

POLISHING ON CLM 500 AWS



Process specification

Machine	CLM 500 AWS
Working cylinder	lapping cylinder
Pieces per load	2
Stock removal	1 μm
Cycle time without handling	15:00 min.

Parts description

Material	Al_2O_3 ceramics
Previous operation	ground
Dimensions	$\varnothing 60 \times 150 \text{ mm}$

Premachined condition

Base size	ground in tolerance	
Surface	Ra	0.3 μm
	Rt	4.5 – 5.0 μm

Results

Ra	< 0.1 μm
Rt	< 1.3 μm
—	< 1 μm
O	< 5 μm
/O/	< 5 μm