

FLATHONING ON FLM 755



Process specification

Machine	FLM 755
Working wheel	D14
Stock removal	110 μ
Pieces per load	540
Cycle time without handling	3:00 min.
Rinsing agent	Oil

Parts description

Material	Fe Ni DIN 1.7405
Previous operation	pressure casting
Dimensions	\varnothing 7.55 x 15.30 mm

Area of application

ignition system gas-range

Premachined condition

Base size	9.66 mm
Surface	raw, vibratory grinding

Results

Tolerance in dim.	9.55 mm, + 180 / - 50 μ
Cpk	1.33
Ra	0.05 μ
Flatness	< 1 μ
Parallelism	3 μ
Surface optical:	cross hatch

FLATHONING ON FLM 755



Process specification

Machine	FLM 755
Working wheel	D16
Stock removal	50 μ
Pieces per load	1140
Cycle time without handling	7:00 min.
Rinsing agent	Oil

Parts description

Material Fe Ni DIN 1.7405

Previous operation precision blanking

Dimensions $\varnothing 8 \times 1.95$ mm

Area of application

ignition-system gas-range

Premachined condition

Base size 2.0 mm

Surface precision blanking

Results

Tolerance in dim. 1.95 mm, ± 50 μ

Cpk 1.33

Ra 0.05 – 0.08 μ

Flatness < 0.6 μ

Parallelism 1 μ

Surface optical: cross hatch