

FLATHONING ON DLM 705



Process specification

Machine	DLM 705
Working wheel	D126
Stock removal	170 μ
Pieces per load	48
Cycle time without handling	1:30 min.
Rinsing agent	Oil

Parts specification

Material	16MnCr5
Premachining	fine blanked
Dimensions	\varnothing 50.9 x 5.35 mm
<u>Application</u>	drilling machine

Premachined condition

Base size	5.500 mm
Surface	fine blanked
w. blanking burr	up to 5.56 mm

Results

Dim. tolerance	5.0 mm, + 10 μ
Cpk	1.33
Ra	0.6 μ
Flatness	1 μ
Parallelism	2 μ
Surface optical	crosshatch