

## FLATHONING ON DLM 705



### Process specification

Machine	DLM 705
Working wheel	B54
Stock removal	350 $\mu$
Pieces per load	24
Cycle time without handling	2:30 min.
Rinsing agent	Oil

### Parts description

Material	20CrMoS5
Premachining	sintered
Dimensions	$\varnothing$ 86 mm
<u>Application</u>	hydraulic steering gear

### Premachined condition

Base size	34.6 mm
Surface	raw

### Results

Dim. tolerance	34.2 mm, $\pm 2 \mu$
Cpk	1.33
Ra	0.2 $\mu$
Flatness	2 $\mu$
Parallelism	2 $\mu$
Surface optical	crosshatch