

FLATHONING ON DLM 705



Process specification

Machine	DLM 705
Working wheel	CBN-K / dummy wheel
Stock removal	50 μ
Pieces per load	48
Cycle time without handling	5:00 min.
Rinsing agent	Oil

Parts description

Material	100Cr6
Premachining	turned on a lath
Dimensions	\varnothing 47 - \varnothing 62 x 15 mm
<u>Application</u>	ball bearing

Premachined condition

Base size	15.1 mm
Surface	turned on a lath

Results

Dim. tolerance	15 mm, + 0 / - 5 μ
Cpk	1.33
Ra	0.8 μ
Flatness	1 μ
Parallelism	2 μ
Surface optical	bright, crosshatch