

## FLATHONING ON FLM 755



### Process specification

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

### Parts description

Material	FeNi DIN 1.7405
Premachining	pressure casting
Dimensions	$\varnothing$ 7.55 x 15.30 mm
<u>Application</u>	ignition system gas-range

### Premachined condition

Base size	9.66 mm
Surface	raw, vibratory grinding

### Results

Dim. tolerance	9.55 mm, + 180 / - 50 $\mu$
Cpk	1.33
Ra	0.05 $\mu$
Flatness	< 1 $\mu$
Parallelism	3 $\mu$
Surface optical	cross hatch