

# Metal and Ceramics

## Finishing options offered by SCHWEIZER OFB GmbH

[mm]	Machinable dimensions			Feasible tolerances		Surface finish grade Ra
Finishing method	Diagonal or Ø		Height	Parameter achieved	Evenness/parallelism	from [µm]
<b>Plane-parallel</b>	<b>Minimum</b>	<b>Maximum</b>	<b>Minimum thickness</b>	<b>Thickness</b>		
Grinding (ceramics only)	2	200	1	± 0.01	from 0.01	from 0.4
Lapping	2	480	0.1 (> 4" min. 0.25) Ferrite 0.4	± 0.005	from 0.005 small parts from 0.01 large parts	from 0.4
Polishing	5	400	0.2 (> 4" min. 0.25)	± 0.005	from 0.001 small parts from 0.01 large parts	from 0.025
<b>Cylindrical</b>	<b>Minimum</b>	<b>Maximum</b>	<b>Maximum length</b>	<b>Ø Tolerance</b>		
External cylindrical grinding	1	440	900	± 0.005	–	from 0.2
Internal cylindrical grinding	6	400	120	± 0.005	–	from 0.4
Cylindrical grinding	0.8	90	300	± 0.005	–	from 0.4
Outside polishing	2	80	170 < Ø 5: 70	± 0.005	–	from 0.05
Honing	2.25	98	220	± 0.01	–	from 0.4
Sph. radius machining	R 2	R 1000	–	–	–	from 0.05

Please contact us in the event of borderline values

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