



## Nanotech 250UPL<sup>v2</sup> Objective

To characterize tool normal (XZB) performance on electroless nickel plating (plated on steel substrate) in terms of both surface finish and form accuracy

## Process

3-Axis Tool Normal Diamond Turning (XZB)

## Optional Accessory Item

Shear Damped Air Isolation System



## Application Summary

### Part Configuration

Material: EINi  
 Diameter: 30 mm  
 Radius: 30 mm  
 Surface Type: CX Sphere

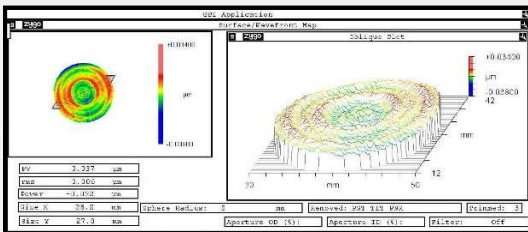
### Tool Configuration

Radius: 0.76mm  
 Top Rake: 0 Degree

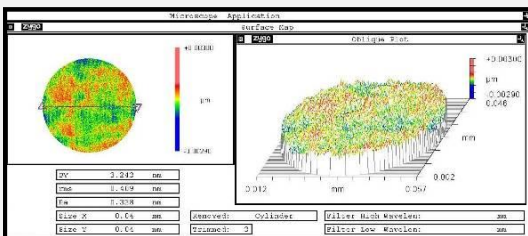
### Machining Parameters

Spindle RPM: 1550  
 Finish Feedrate: 1.0 mm/min  
 Finish Depth of Cut: 3 μm  
 Coolant: Odorless Mineral Spirits

## Metrology Results



**Form Accuracy:** PV = 0.037 μm



**Surface Finish:** Ra = 0.328 μm

