

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]
Plane-parallel	Minimum	Maximum	Minimum thickness	Thickness		
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
Cylindrical	Minimum	Maximum	Maximum length	Ø Tolerance		
External cylindrical grinding	1	440	900	± 0.015	–	from 0.2
Internal cylindrical grinding	6	400	120	± 0.015	–	from 0.4
Cylindrical grinding	0.8	90	300	± 0.010	–	from 0.4
Outside polishing	2	80	170 < Ø 5: 70	± 0.010	–	from 0.05
Sph. radius machining	R 2	R 1000	–	–	–	from 0.5

Please contact us in the event of borderline values

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