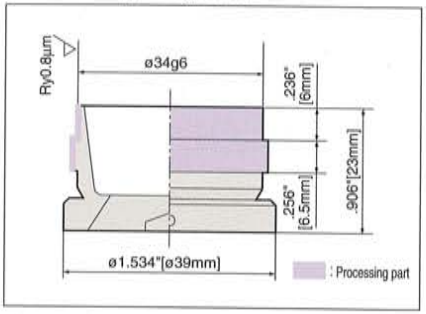
Processing Example

Cap Body

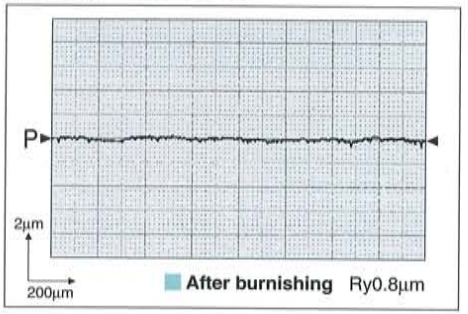
〔Machining Parameters〕

Model Number	DSR-1LA25TH					
Material	SUS316					
Surface Roughness	Ry μ Inch	Before	248.03	Ry μ m	Before	6.3
		After	31.50		After	0.8
Surface Footage	Inch/min		5.906	mm/min		150
Feed Rate	Inch/rev		.002	mm/rev		0.05
Tool Deflection Amount	Inch		.157	mm		4

〔Machining Diagram〕



〔Surface Roughness〕



Processing Parameters

〔Machining Parameters〕

Material	Surface Footage		Feed		Amount of Deflection		Load		Surface Roughness			
									Before bunishing		After bunishing	
	Inch/min	mm/min	Inch/min	mm/min	Inch/min	mm/min	Lbf	N	Ry μ Inch	Ry μ m	Ry μ Inch	Ry μ m
Carbon steel / Alloy steel	3.938~7.874	100~200	.003	0.08	.157	4	44.96	200	315.00~393.70	8~10	31.50	0.8
Stainless steel			.004	0.10								
Cast iron					.118	3	33.72	150			78.74	2.0
Aluminum / Cooper alloy					.019	0.5	5.62	25	125.99~315.00	3.2~8	31.50	0.8

Note 1.The deflection amount is equivalent to the spring pre-load which directly correlates to the adjustment setting on the tool.
2.Conditions such as pre-burnish tolerance, material and material hardness will affect the surface finish. Make adjustments accordingly.