

Machining Capability Matrix



Machining Process		Max. Component Dimensions*				
		Diameter		Length	Width	Height
5-axis Lathe/Milling		400 mm		1500 mm		
Turning	Horizontal	1600 mm (outer)		6000 mm		
	Vertical	2800 mm (outer)		1500 mm		
Milling max. tolerance: ± 0.01 mm				2000 mm	2000 mm	2000 mm
EDM	Die Sink			625 mm	400 mm	450 mm
	Wire conical up to $\pm 20^\circ$			400 m	800 mm	400 mm
Honing max. tolerance: ± 0.005 mm max. surface finish: Ra=0.1		min.	max.	400 mm		
		3 mm	350 mm			
Grinding max. tolerance: ± 0.005 mm	Surface Grinding max. surface finish: Ra=0.2			1000 mm	600 mm	
	Spherical Grinding max. surface finish: Ra=0.2	min.	max.			
		30 mm (Ball)	500 mm (Ball)			
	Profile Grinding max. surface finish: Ra=0.2	240 mm		200 mm	40 mm	
Cylindrical Grinding max. surface finish: Ra=0.4	850 mm (outer)	800 mm (inner)	3000 mm (outer)	800 mm (inner)		
Lapping max. tolerance: ± 0.005 mm max. surface finish: Ra=0.1	Round	200 mm		1000 mm		
	Superfinish	700 mm		2000 mm		
	Flat	350 mm				

* Dimensions for guidance only
machinable components might be bigger