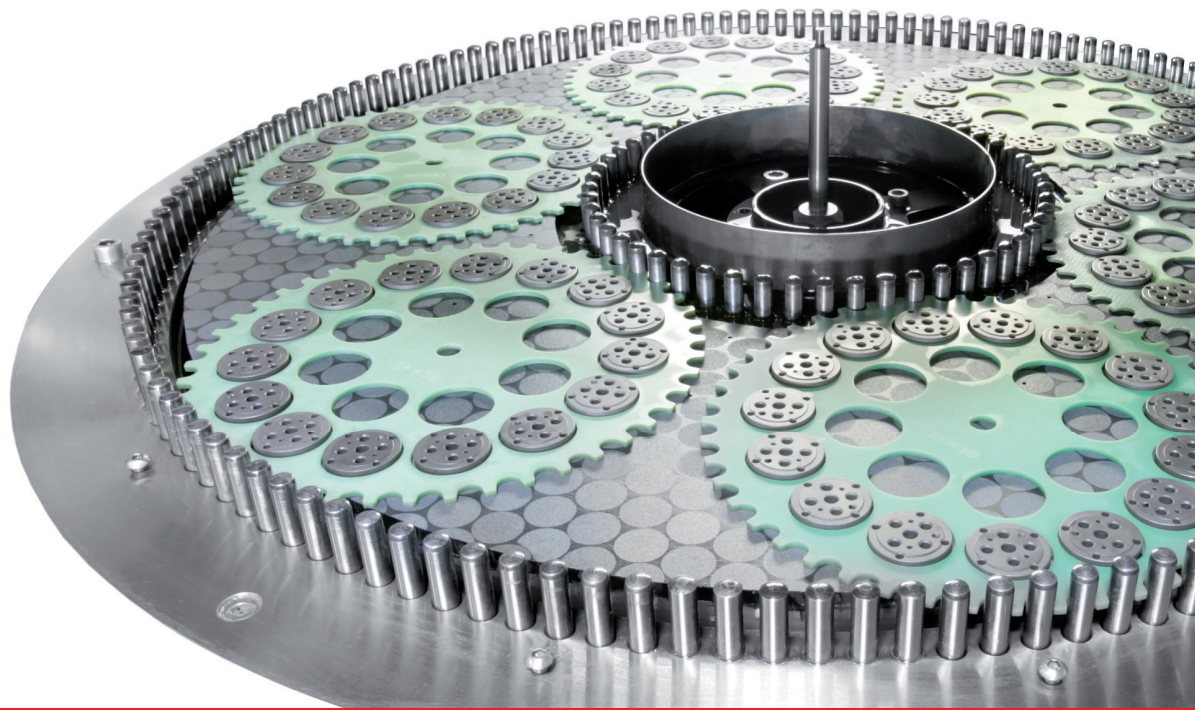


Stähli

Your partner for subcontracting

Flat Honing - Lapping - Polishing

Process Development - Measuring - Parts Cleaning



Stähli offers its customers worldwide state-of-the-art subcontract centers.

From individual parts to high volume quantities.
Achieve absolute precision at the utmost in efficiency.

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Flat Honing

Workpieces with as much as .8mm of stock to be removed from pre-machining, as ex. sintering, casting, moulding, stamping, fine blanking, sawing, milling, and grinding can be machined cost effectively.

[Link to Flat Honing »](#)

Thickness	from 0.3 – 110 mm
Diameter	from 4 – 330 mm
Flatness	< 1 µm
Parallelism	< 2 µm
Surface roughness	Ra < 0.1 µm

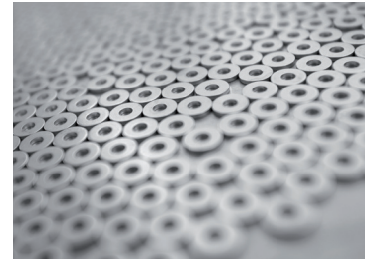


Lapping and polishing

Workpieces of all types and sizes. Of any material type. Can be precision lapped or polished to the desired quality level.

[Link to Lapping and Polishing »](#)

Thickness	from 0.08 – 500 mm
Diameter	from 1 – 1200 mm
Flatness	< 0.00013 mm
Parallelism	0.0005 mm
Surface roughness	Ra < 0.005 µm Rz < 0.05 µm

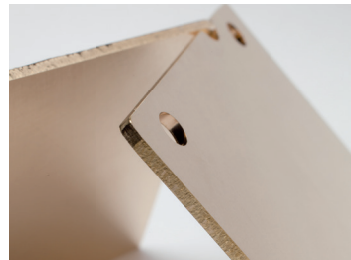


Parts cleaning

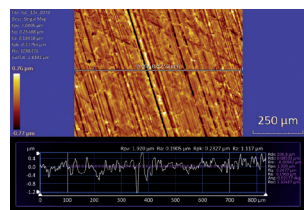
Workpieces of all types and sizes. Of any material type. All machining fluids, abrasive, and debris will be removed.

[Link to Lapping and Polishing »](#)

Parts dimensions	up to 220x280 mm
Weight	max. 10 kg
Work piece	clean, dry, greaseless

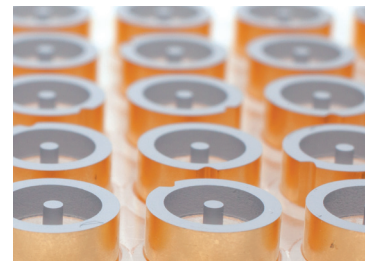


Surface Roughness Measuring in 2D and 3D



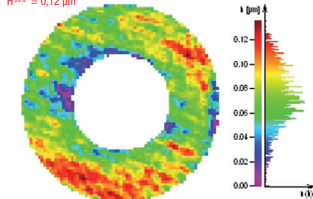
The use of advanced measuring equipment to ensure continuous quality.

← non-contact optical surface measurement of the surface roughness according to ISO 25178 in S and R standard.



Flatness Measurement

Referenzebenen minimaler Zone Datum: 19.07.2012
Uhrzeit: 15:16
FLT = 0,14 µm Prüfer:
H^{max} = 0,12 µm



Documentation and quality assurance allow constant monitoring and evaluation of all processes according to international standards.

← Non-contact flatness measuring with a laser interferometer.



The Stähli Group with its more than 40 years of experience in machine manufacturing is one of the world's leading suppliers for Lapping, Polishing and Flat Honing Machines.

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