

Specification CNC turning and milling - HONPE ProtoTec GmbH

Processable metals

Including aluminum, stainless steel, aluminum-steel, bronze, brass, steel, titanium, and carbon steel.

Processable Plastics

ABS, PC, PMMA, POM, PA, PP, PET, PVC, CPVC, PS, LDPE, HDPE, PSU, PPSU, Nylon, PEEK, PEI and Polycarbonates.

Tolerances

Our working methods are geared towards compliance with the ISO 2768 CNC machine standard. As a rule, the tolerances according to ISO 2768 (medium) and ISO 2768 (fine) are used. If tighter tolerances are required, a corresponding declaration in the drawings is necessary. Please contact us to discuss further options.

Component finishing

Anodising	Painting
Grinding and polishing	Chrome plating
Bead blasting + anodising	Electrophoresis
Water plating	Electropolishing
Steam polishing	Sandblasting
Passivation	Heat treatment
Hard oxidation	Brushing
Powder coating	Electroplating

Standards	Metal Part	Plastic Part
Max. Part Size	1430×1130×450 mm	1970×1470×250 mm
Min. Part Size	1×1 mm	2×2 mm
Min. Hole Size	∅ 0,30 mm	∅ 0,30 mm
Hole / Shaft Tolerance	H6/h6	H7/h7
Standard Tolerance	ISO 2768-f	ISO 2768-m
Min. Text CNC Engraving	Line Width 0,02 mm x Depth 0,3 mm	Line Width 0,02 mm x Depth 0,3 mm
Text Laser Engraving	Depth 0,05-0,1 mm	Depth 0,05-0,1 mm
Min. Milling Radius	Standard R 0,15 mm; Optional R 0,1 mm	Standard R 0,15 mm; Optional R 0,1 mm
Surface roughness Ra	-	PMMA Ra 0,04 - Ra 0,08; PC Ra 0,06 - Ra 1,0
Edge properties	The corners of the component will be removed in the form of a chamfer or radius, as shown in the drawing provided for the job. Specify the size of the resulting chamfer or radius.	