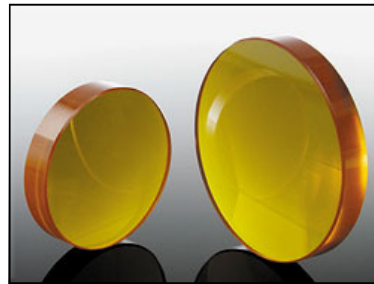




Moore Nanotech® 250UPL

Application Report

Zinc Selenide (ZnSe)



Objective: To quantify surface finish and form results obtainable on ZnSe using the Nanotech 250UPL.

Process:

- 2-Axis Single Point Diamond Turning

Part Configuration:

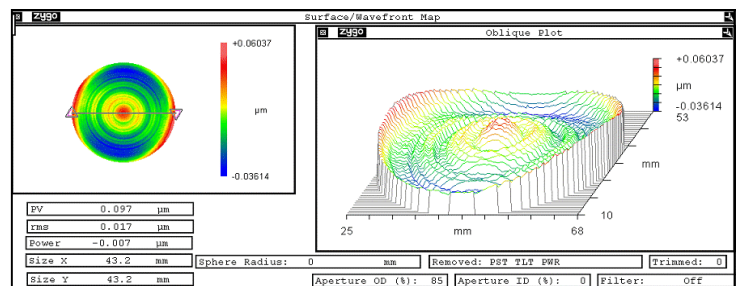
- **Material:** ZnSe
- **Diameter:** 50 mm
- **Radius:** 267 mm
- **Surface Type:** CX Sphere

Machining Parameters:

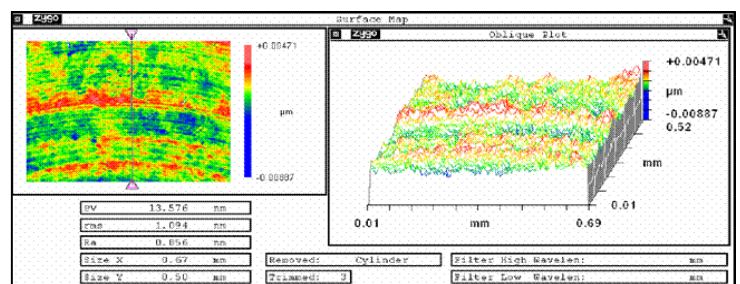
- **Spindle RPM:** 2500
- **Finish Feedrate:** 2 mm/min
- **Finish Depth of Cut:** 4 μm
- **Coolant:** Odorless Mineral Spirits

Tool Configuration:

- **Radius:** 0.635 mm
- **Top Rake:** - 25 degree



Form Accuracy: PV = 0.097 μm



Surface Finish: Ra = 0.856 nm