



**Moore Nanotech® 250UPL**  
With Shear Damped Air Isolation System

**Objective:** To quantify “champion” surface finish and form accuracy obtainable in electroless nickel plating using the Nanotech 250UPL.

## Application Report

### Electroless Nickel (EINi) (Plated on Steel Substrate)



#### Process:

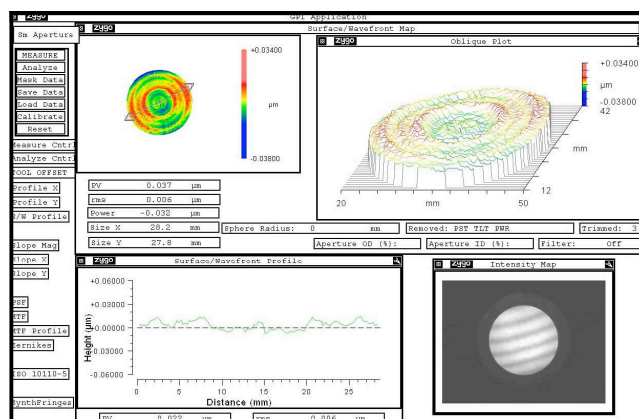
- 3-Axis Tool Normal Diamond Turning (XZB)

#### Advanced Optional Accessory:

- Shear Damped Air Isolation System

#### Part Configuration:

- **Material:** Electroless Nickel
- **Diameter:** 30 mm
- **Radius:** 30 mm



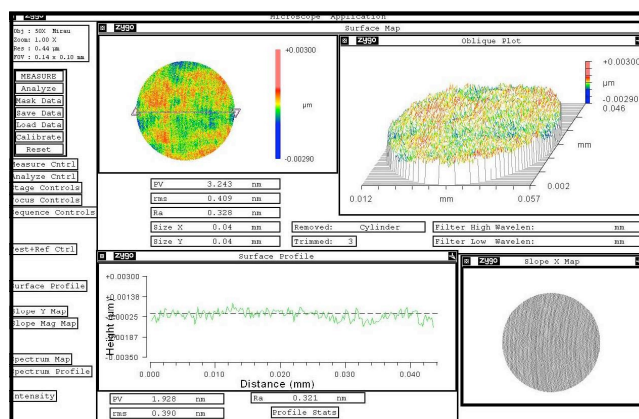
**Form Accuracy:** PV = 0.037 µm

#### Machining Parameters:

- **Spindle RPM:** 1550
- **Finish Feedrate:** 1.0 mm/min
- **Finish Depth of Cut:** 3 µm
- **Coolant:** Odorless Mineral Spirits

#### Tool Configuration:

- **Radius:** 0.76 mm
- **Top Rake:** 0 Degree



**Surface Finish:** Ra = 0.328 nm  
PV = 3.243 nm