

# MiM & MiM-Like

## Secondary operations

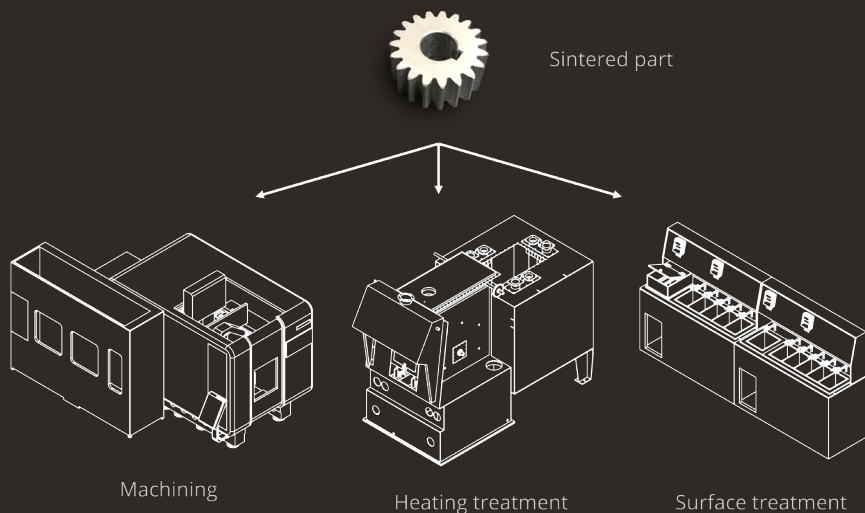
As all metal parts, MiM & MiM-Like parts can be subjected to secondary operations such as machining, grinding, surface finishing, etc.

Despite one of the aims of MiM & MiM-Like being to achieve net shape parts, secondary operations are still required. Moreover, the cost of secondary operations is a significant part of the total part cost.

This is only a preview of our material summary.  
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Dimension (mm)	Tolerance (mm)	Secondary operations
≤ 2	±0.06	
2 - 6	±0.07	
6 - 12	±0.08	
12 - 16	±0.10	
16 - 20	±0.12	Flatness 0,1 ± 0,3
20 - 25	±0.15	Alignment and concentricity Dimension < 5 mm : 1%
25 - 30	±0.18	Dimension 15 ± 30mm : 0.8%
30 - 50	±0.25	Dimension > 30 mm : 0.6%
≥ 50	±0.5%	Squareness ± 0.5%
		Wall thickness Minimum 0.5 mm

The golden rule is to try to avoid these secondary operations from the design phases, by optimizing the parts definition and avoiding over tolerancing.



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