**Goal:**
To demonstrate the surface finish and form accuracy results achievable using the Nanoform® X with HS150 work holding spindle on a steep slope aluminum asphere.

**Process:**
2 Axis diamond turning (X, Z)

**Part Details:**
- Outer diameter: 8 mm
- Spherical radius: 2.5 mm
- Maximum slope: 52 degrees
- Material: Aluminum

**Process Details:**
- Tool radius: 0.5 mm
- Spindle speed: 2,000 rpm
- Feed rate: 5 mm/minute
- Depth of cut: 2 µm
- Coolant: Odorless mineral spirits

**Measurement methods:**
- **Finish:** Instrument: Taylor Hobson CCI
  Sample area: 150 µm x 150 µm
- **Form:** Instrument: Form Talysurf

**Results:**
- Surface finish: 1.43 nm Sa
- Form accuracy: 0.058 µm PV
  0.013 µm RMS