

Polishing Process

STEELS 600-800HV (?) 1 samples Ø37mm

Step	Support	Abrasive	Lubricant	Plate Speed (Rpm)	Head Speed (Rpm)	Force N/spe. Ø30	Time (Min)
1	XTOP	54	Eau	300	70	25	1
2	XMID	XM25 9μ	XL50	150	70	18	4
3	X500	XM25 3μ	XL50	150	70	18	3
4	X220	XM25 1μ	XL50	150	70	15	15seconds

Note: *For step 4, 15 seconds just to remove scratches from 3μ, and not more to avoid to remove and damage the inclusions.