

Polishing Process

STEELS 600-800HV (?) 4samples Ø30mm

Step	Support	Abrasive	Lubricant	Plate Speed (Rpm)	Head Speed (Rpm)	Force N/spe. Ø30	Time (Min)
1	XTOP	54	Eau	300	70	25	2
2	XMID	XM25 9μ	XL50	150	70	15	5
3	X500	XM25 3μ	XL50	150	70	15	4
4	X220	XM25 1μ	XL50	150	70	15	2
5	X100	XA05*	–	150	70	15	1,5

Note: *For step 5, 90 seconds with XA05 and about 15 seconds with water only.