

Polishing Process STEELS 600-800HV

Step	Support	Abrasive	Lubricant	Plate Speed (Rpm)	Head Speed (Rpm)	Force N/spe. Ø30	Time (Min)
1	XTOP	54	Eau	300	70	30	2
2	XMID	XM25 9μ	XL50	150	70	30	5
3	X500	XM25 3μ	XL50	150	70	30	4
4	X220	XM25 1μ	XL50	150	70	30	2
5	X100	XA05*	–	150	70	15	1+0,5

Note: