

Polishing Process
CEMENTED CARBIDES V1

Step	Support	Abrasive	Lubricant	Plate Speed (Rpm)	Head Speed (Rpm)	Direction Rotation	ForceN/spe. Ø30mm	Time (Min)
1	XTOP	54μ	Water	300	150	Same	30	2
2	XTOP	18μ	Water	300	150	Same	30	2
3	XMID	XP35 9μ	XL20	180	150	Same	35	5
4	X500	XP35 3μ	XL20	180	150	Same	30	5
5	X100	XA05	(Water)	150	150	Contrary	15	2

Note:

- . Step 1: Grinding time, 2 minutes or more depending quality of the mounting.
- . This process is for specimen Ø30mm. If specimen Ø40mm, increase grinding and polishing time by 1 minute.