

Polishing Process

(Medium & Hard) Steels with Soft Coating

Step	Support	Abrasive	Lubricant	Plate Speed (Rpm)	Head Speed (Rpm)	Direction Rotation	ForceN/spe. Ø30mm	Time (Min)
1	XTOP	54	Water	300	150	Same	25	2
2	XTOP	18	Water	300	150	Same	25	2
3	X500	XM25 9μ	XL20	150	100	Same	15	5
4	X500	XM25 3μ	XL20	150	100	Same	15	3
5	X200	XM25 1μ	XL20	150	100	Same	15	1,5
6	X100	XA05	—	150	100	Same	10	1,5
7								
8								

Note:

- . Step 1: Grinding time, 2 minutes or more depending quality of the mounting.
- . Step 3 & 4: Very important steps: it gives the flatness to the sample.
- . Step 6: 1,5 minute for polishing, + 20 seconds with water only for cleaning.
- . This process is for specimen Ø30mm. If specimen Ø40mm, increase grinding and polishing time by 1 minute.