

Polishing Process
Steels Hard and Treated

Step	Support	Abrasive	Lubricant	Ø300mm Plate Speed (Rpm)	Head Speed (Rpm)	Force N/spe. Ø30mm	Time (Min)
1	XTOP	54	Water	300	100	25	1
2	XMID	XM25 9µ	XL20	150	100	25	3
3	X500	XM25 3µ	XL20	150	100	20	3
4	X220	XM25 1µ	XL20	150	100	15	1

Note:

- . Step 1: Grinding time, 1minute or more depending quality of the mounting.
- . For steps 2, 3 and 4, if steel is water sensitive, use our alcohol base suspensions **XMAL** and **XL50** lubricant.
- . This process is for specimen Ø30mm. If specimen Ø40mm, increase grinding and polishing time by 1 minute, and Force by 5 to 10N.