

**Polishing Process**  
**Steels Medium Hardness**

Step	Support	Abrasive	Lubricant	Ø300mm Plate Speed (Rpm)	Head Speed (Rpm)	Force N/spe. Ø30mm	Time (Min)
1	<b>XTOP</b>	<b>54</b>	Water	300	100	25	1
2	<b>AP</b>	<b>P1200</b>	Water	300	100	15	2
3	<b>X500</b>	<b>XM25 3µ</b>	<b>XL20</b>	150	100	15	2
4	<b>X220</b>	<b>XM25 1µ</b>	<b>XL20</b>	150	100	15	1

**Note:**

- . Step 1: Grinding time, 1minute or more depending quality of the mounting.
- . Step 2: AP = Abrasive Paper
- . For step 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.