

## Polishing Process

(Soft & Medium) Steels with Soft Coating

Step	Support	Abrasive	Lubricant	Plate Speed (Rpm)	Head Speed (Rpm)	Direction Rotation	ForceN/spe. Ø30mm	Time (Min)
1	AP	180	Water	300	150	Same	20	2
2	AP	320	Water	300	150	Same	20	1,5
3	AP	600	Water	300	150	Same	20	1,5
4	AP	1200	Water	300	150	Same	20	1,5
5	X500	XM25 9 $\mu$	XL20	150	100	Same	15	4
6	X500	XM25 3 $\mu$	XL20	150	100	Same	15	3
7	X200	XM25 1 $\mu$	XL20	150	100	Same	15	1
8	X100	XA05	-	150	100	Same	10	1

### Note:

- . Step 1: Grinding time, 2 minutes or more depending quality of the mounting.
- . Step 5 & 6: Very important steps, it gives the flatness to the samples.
- . Step 8: 1 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.