

Polishing Process
TITANIUM

Step	Support	Abrasive	Lubricant	Plate Speed (Rpm)	Head Speed (Rpm)	Direction Rotation	ForceN/spe. Ø30mm	Time (Min)
1	XTOP	54	Water	300	150	Same	20	2
2	X500	XP35 9μ	XL20	180	100	Same	15	5
3	X100	XA15	—	150	100	Contrary	15	3

Note:

- . Step 1: Grinding time, 2 minutes or more depending quality of the mounting.
- . Step 3: Possible to add Oxygen Peroxide to increase power of **XA15**.
- . This process is for specimen Ø30mm. If specimen Ø40mm, increase grinding and polishing time by 1 minute.