

**Polishing Process**  
**TITANIUM (Standard process)**

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	XP35 9μ	XL20	180	100	Same	15	4
6	X100	XA15	—	150	100	Contrary	15	3

**Note:**

- . Step 1: Grinding time, 2 minutes or more depending quality of the mounting.
- . Step 6: 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.