

## STAINLESS STEEL

### Polishing Process: SS.V2

Cutting: NX10 or NX20

Mounting: All mounting resins

Step	Support	Abrasive	Lubricant	Plate Speed (Rpm)	Head Speed (Rpm)	Direction Rotation	Force N/ spe.Ø30mm	Time (Min)
1	<b>XTOP</b>	<b>54</b>	Water	300	150	Same	25	2
2	<b>XTOP</b>	<b>18</b>	Water	300	150	Same	25	2
3	<b>AP</b>	<b>P1200</b>	Water	300	150	Same	20	2
4	<b>X500</b>	<b>XM25 6μ</b>	<b>XL50</b>	150	150	Same	20	4
5	<b>X300</b>	<b>XM25 3μ</b>	<b>XL50</b>	150	150	Same	20	3
6	<b>X220</b>	<b>XM25 1μ</b>	<b>XL50</b>	150	150	Same	15	2
7	<b>X100</b>	<b>XA05</b>	(Water)	150	150	Same	15	2

#### Note:

- . Step 1: Grinding time, 2,5 minutes or more depending quality of the mounting.
- . Possible to stop after step 6, for routine examination or microhardness testing.
- . Step 7: optional. Use water 20 seconds before end the step to clean polishing cloth.
- . Do not use too much diamond suspensions to avoid micro black points on the sample.
- . This process is for specimen Ø30mm. If specimen Ø40mm, increase grinding and polishing time by 1 minute.