

## STAINLESS STEEL

### Polishing Process: SS.V1

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	AP	P180	Water	300	150	Same	20	2
2	AP	P320	Water	300	150	Same	20	2
3	AP	P600	Water	300	150	Same	20	2
4	AP	P1200	Water	300	150	Same	20	2
5	X500	XM25 6µ	XL50	150	150	Same	15	4
6	X300	XM25 3µ	XL50	150	150	Same	15	3
7	X220	XM25 1µ	XL50	150	150	Same	15	2
8	X100	XA05	(Water)	150	150	Same	15	1,5

#### Note:

- . Step 1: Grinding time, 2 minutes or more depending quality of the mounting.
- . Possible to stop after step 6, for routine examination or microhardness testing.
- . Step 8: optionnal. 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.