

### TREATED STEEL (very hard)

#### Polishing Process: TS.V1

Cutting: NX30

Mounting: Hard 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	35	2
2	<b>XTOP</b>	<b>18</b>	Water	300	150	Same	35	2
3	<b>X500</b>	<b>XM25 9μ</b>	<b>XL20</b>	150	150	Same	30	5
4	<b>X500</b>	<b>XM25 3μ</b>	<b>XL20</b>	150	150	Same	25	4
5	<b>X220</b>	<b>XM25 1μ</b>	<b>XL20</b>	150	150	Same	25	2

**Note:**

- . Step 1: Grinding time, 2 minutes or more depending quality of the mounting.
- . Possible to stop after step 4, for routine examination or microhardness testing.
- . **XP35** diamond suspensions can be use instead of **XM25** to improve performance.
- . This process is for specimen Ø30mm. If specimen Ø40mm, increase grinding and polishing time by 1 minute.