

ALUMINIUM ALLOYS

Polishing Process: AL.V1

Cutting: NX70, NX80

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	1,5
3	AP	P600	Water	300	150	Same	20	1,5
4	AP	P1200	Water	300	150	Same	20	2
5	X500	XM25 6 μ	XL20	150	150	Same	15	4
6	X300	XM25 3 μ	XL20	150	150	Same	15	3
7	X220	XM25 1 μ	XL20	150	150	Same	15	2
8	X100	XA05 or XA15	(Water)	150	150	Contrary	15	1,5

Note:

- . Step 1: Grinding time, 2 minutes or more depending quality of the mounting.
- . Step 8: Optionnal. Use water 20 seconds before end of the step to clean polishing cloth.
- . This process is for specimen Ø30mm. If specimen Ø40mm, increase grinding and polishing time by 1 minute.