

STANDARD STEEL

Polishing Process: ST.V1

Cutting: NX10

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	2,5
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	XL20	150	150	Same	15	4
6	X300	XM25 3μ	XL20	150	150	Same	15	3
7	X220	XM25 1μ	XL20	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.
- . This process is for specimen Ø30mm. If specimen Ø40mm, increase grinding and polishing time by 1 minute.