


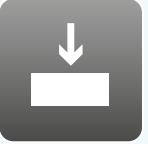

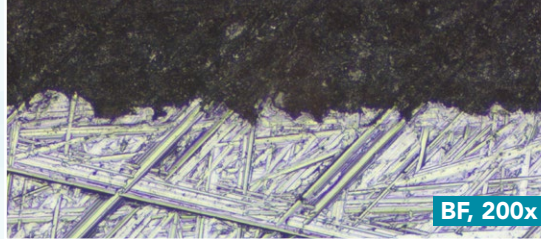



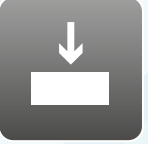

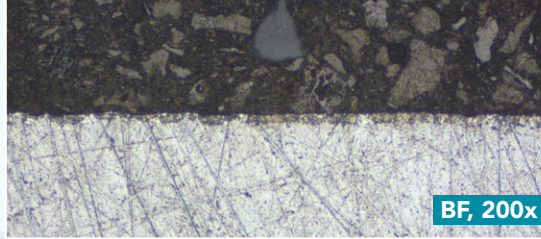



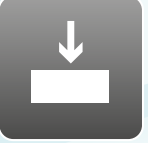

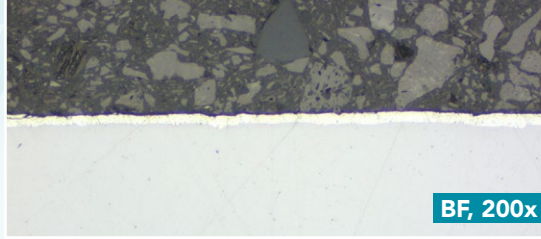





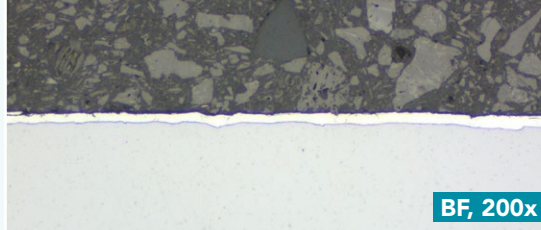


Aka-Brief #15 Zinc Coated Steel

| | | | | | | | |
|---|--|--|--|--|---|--|---|
| 1 |  |  |  |  |  |  | |
| | Piatto 220 | Water | 300 rpm | 25 N | Until plane | | |
| 2 |  |  |  |  |  | |  |
| | Allegran 3 | DiaUltra 6 µm** | 150 rpm | 25 N | 3:30 min | | |
| 3 |  |  |  |  |  |  | |
| | Silk | DiaUltra 1 µm** | 150 rpm | 25 N | 3:30 min | | |
| 4 |  |  |  |  |  |  | |
| | Chemal | Fumed Silica 0.2 µm WF | 150 rpm | 20 N | 2:00 min | | |

Times are stated for a 300 mm preparation system and Forces for an individual 40 mm dia. sample.

On a 250 mm system the times should be increased by 30%, on a 200 mm system by 100%.

With larger samples the force should be increased, with smaller samples decreased.

Time and Force may vary depending on the equipment.

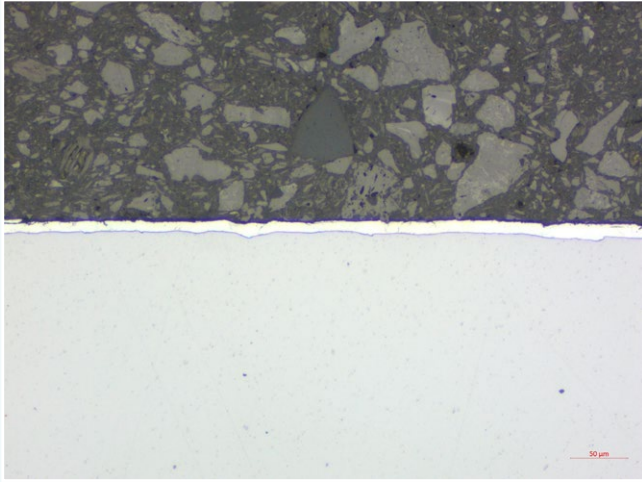
*** For water-sensitive coatings:** The use of water should be avoided for cleaning after the 6 µm, 1 µm and the final preparation step. Ethanol denatured with isopropyl alcohol can be used for cleaning.

**** For very water-sensitive coatings:** Only diamond grinding/polishing using water-free suspensions for the 6 µm and 1 µm steps is recommended.

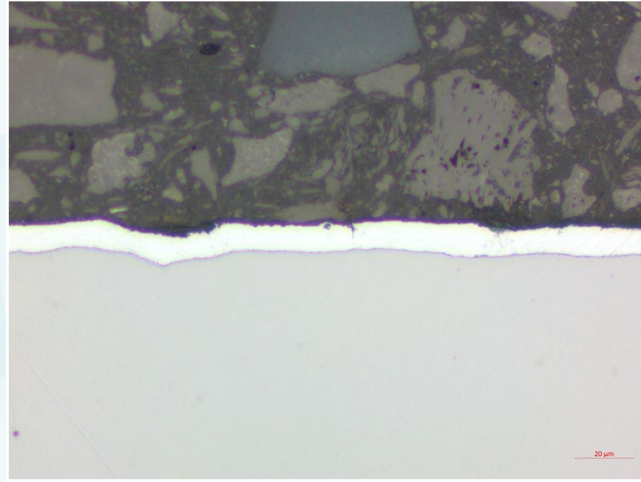


Aka-Brief #15 Zinc Coated Steel

FINAL RESULT



BF, 200x



BF, 500x