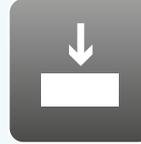
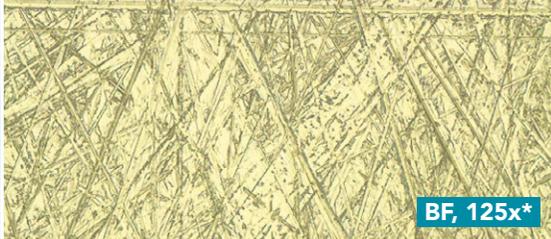
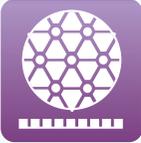
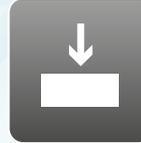
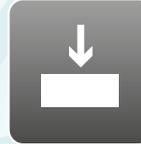


Aka-Brief #12 Hard Materials 700-2000 HV

1						→	
	Piatto 120	Water	300 rpm	35 N	Until plane		
2						→	
	Allegran 9	DiaUltra 9 μm	150 rpm	35 N	3:30 min		
3						→	
	Daran	DiaUltra 3 μm	150 rpm	35 N	3:30 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.

* Material prepared:
Tool Steel

