













PREPARATION METHOD

MEDIUM-HARD TO HARD STEEL (30-65 HRC/850HV)

|  CUTTING | | Equipment QATM Qcut / Brillant | Consumables Cut-off wheel: corundum, resin bond Anti-corrosion coolant | | | | |
|--|------------|--|--|--|--|--|--|
|  MOUNTING | | Equipment QATM Qpress / Opal | Consumables EPO black, EPO-Max KEM 15 plus Hot mounting preferred | | | Method Hot mounting Cold mounting | |
|  GRINDING/ POLISHING | | Equipment QATM Qpol / Saphir Sample size \varnothing 40 mm | | | | | |
| STEP | MEDIUM |  |  rpm |  |  N |  min | |
|  Planar grinding | GALAXY red | H ₂ O | 250-300 | ▶▶ Synchronous rotation | 30 | Until plane | |
|  Pre-polishing | BETA | Dia Complete Poly, 9 μ m | 120-150 | ◀▶ Counter rotation | 30 | 3:00-5:00 | |
|  Final polishing | IOTA | Dia Complete Poly, 3 μ m | 120-150 | ◀▶ Counter rotation | 30 | 3:00-4.00 | |
|  Optional: Etching (chemical) | Nital 3% | | | | | Approx. 0:03 | |