















## PREPARATION METHOD

### CAST IRON (GJS/GJL)

 <b>CUTTING</b>		<b>Equipment</b> QATM Qcut / Brillant	<b>Consumables</b> Cut-off wheel: corundum, resin bond Anti-corrosion coolant			
 <b>MOUNTING</b>		<b>Equipment</b> QATM Qpress / Opal	<b>Consumables</b> EPO black, EPO-Max, Bakelite red/black KEM 30	<b>Method</b> Hot mounting Cold mounting		
 <b>GRINDING/ POLISHING</b>		<b>Equipment</b> QATM Qpol / Saphir Sample size $\varnothing$ 40 mm				
STEP	MEDIUM		 rpm		 N	 min
 Planar grinding	SiC-paper/foil P320 (280)	H <sub>2</sub> O	250-300	▶▶ Synchronous rotation	30	Until plane
 Grinding	SiC-paper/foil P600 (400)	H <sub>2</sub> O	250-300	▶▶ Synchronous rotation	30	1:00
 Grinding	SiC-paper/foil P1200 (600)	H <sub>2</sub> O	250-300	▶▶ Synchronous rotation	30	1:00
 Polishing	SIGMA/GAMMA	Dia Complete Poly, 3 $\mu$ m	120-150	▶▶ Synchronous rotation	25	5:00
 Final polishing	LAMBDA/OMEGA	Eposal, 0.06 $\mu$ m	120-150	◀▶ Counter rotation	20	1:00 (H <sub>2</sub> O during final 0:30)*
 Optional: Etching (chemical)	Nital 3%					0:03-0:10

\* Rinsing with water can cause corrosion