














PREPARATION METHOD

SOFT TO MEDIUM-HARD STEEL (<35 HRC/350HV)

 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, Bakelite red/black KEM 15 plus			Method Hot mounting Cold mounting	
 GRINDING/ POLISHING		Equipment QATM Qpol / Saphir Sample size Ø 40 mm					
STEP	MEDIUM		 rpm		 N	 min	
 Planar grinding	SiC-paper/foil P320 (280)	H ₂ O	250-300	▶▶ Synchronous rotation	30	Until plane	
 Pre-polishing	BETA	Dia Complete Poly, 9 µm	120-150	◀▶ Counter rotation	35	5:00	
 Polishing	SIGMA/GAMMA	Dia Complete Poly, 3 µm	120-150	▶▶ Synchronous rotation	30	6:00	
 Final polishing	LAMBDA/OMEGA	Eposal, 0.06 µm*	120-150	▶▶ Synchronous rotation	20	1:00 (H ₂ O during final 0:30)	
 Optional: Etching (chemical)	Nital 3% (micro), Adler's reagent (macro)					Approx. 0:03-0:10 Approx. 0:03-0:10	

* For weld analysis