


Aka-Brief #16 Materials of Hardness 150-400 HV

1						→	
	Piatto 220	Water	300 rpm	30 N	Until plane		
2						→	
	Allegran 3	DiaUltra 9 μm	150 rpm	35 N	4:00 min		
3						→	
	Silk	DiaUltra 3 μm	150 rpm	30 N	3:00 min		
4						→	
*	Napal	DiaUltra 1 μm	150 rpm	20 N	1:00 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.

The rotational speed of the head (sample holder or sample mover plate) used is 150 rpm.

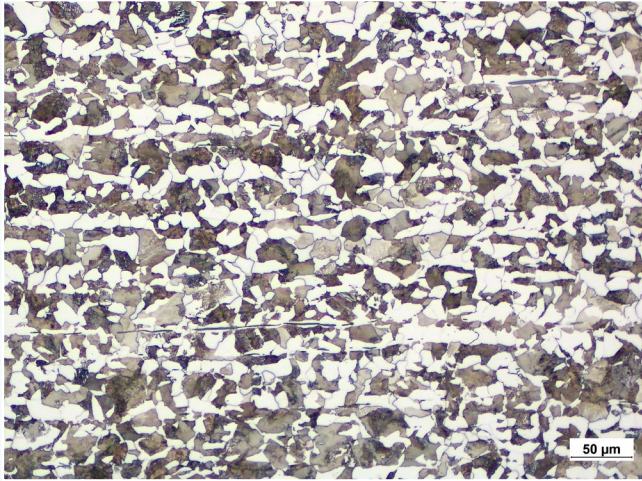
Time and force may vary depending on the equipment.

* This step can be replaced by oxide polishing with Chermal. See our oxide polishing brochure for more information.

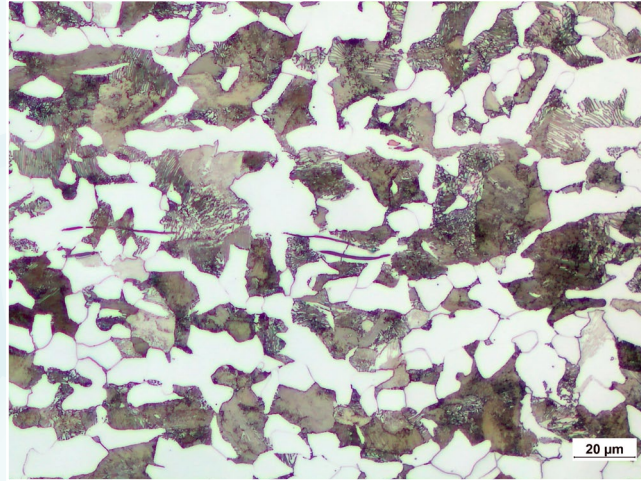
Please make sure that all necessary safety precautions are taken when handling chemicals.

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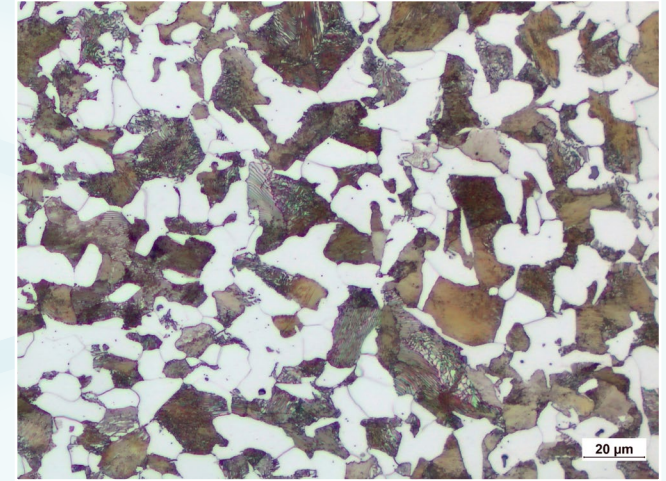
FINAL RESULT



0.45% C Steel, normalised, 200 HV, longitudinal section etched with Nital 3%, BF, 200x



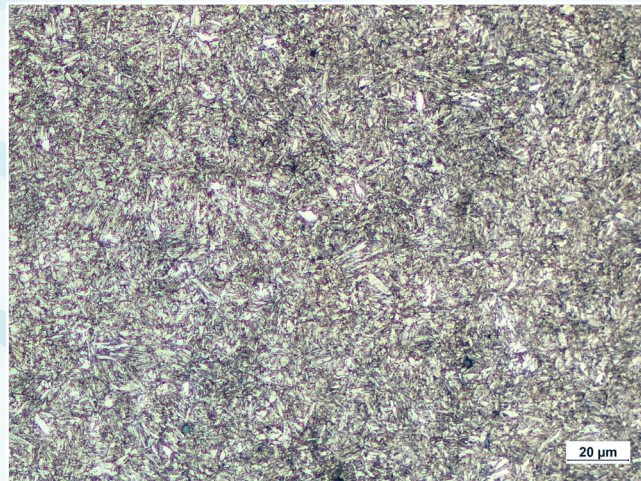
0.45% C Steel, normalised, 200 HV, longitudinal section etched with Nital 3%, BF, 500x



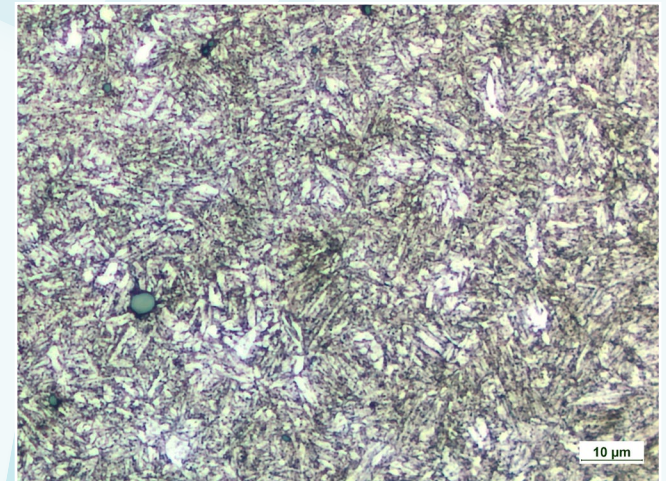
0.45% C Steel, normalised, 200 HV, cross section etched with Nital 3%, BF, 500x



Low Alloy Steel 42CrMo4+QT, 330 HV, BF, 500x



Low Alloy Steel 42CrMo4+QT, 330 HV etched with Nital 3%, BF, 500x



Low Alloy Steel 42CrMo4+QT, 330 HV etched with Nital 3%, BF, 1000x