


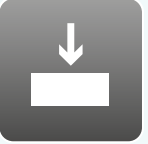

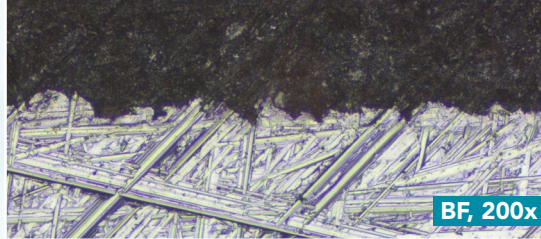


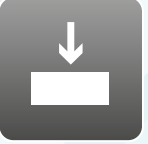

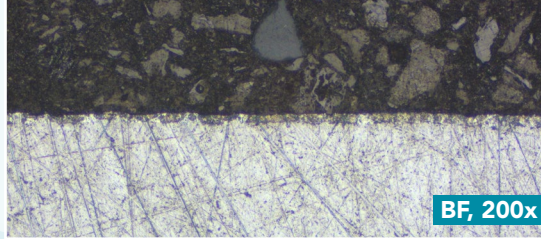



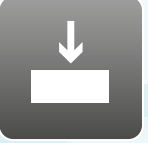

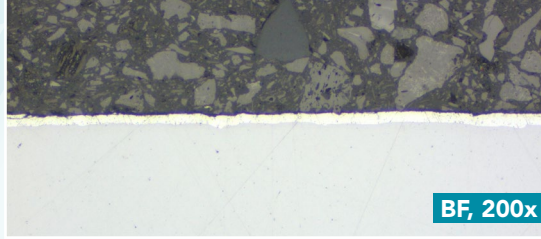





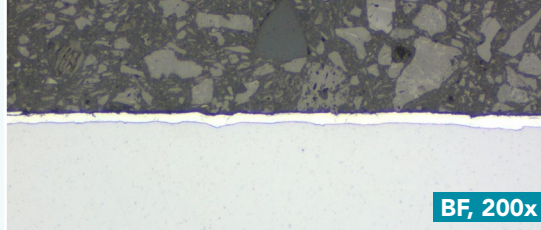


Aka-Brief #15 Zinc Coated Steel

1							
	Piatto 220	Water	300 rpm	20 N	Until plane		
2							
	Allegran 3	DiaUltra 6 µm**	150 rpm	30 N	3:30 min		
3							
	Silk	DiaUltra 1 µm**	150 rpm	25 N	3:30 min		
4							
	Chemal	Fumed Silica 0.2 µm WF	150 rpm	15 N	2:00 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.

*** For water sensitive coatings:**

The use of water should be avoided for cleaning after the 6 µm, 1 µm and the final preparation step. Ethanol de-natured with isopropyl alcohol can be used for cleaning.

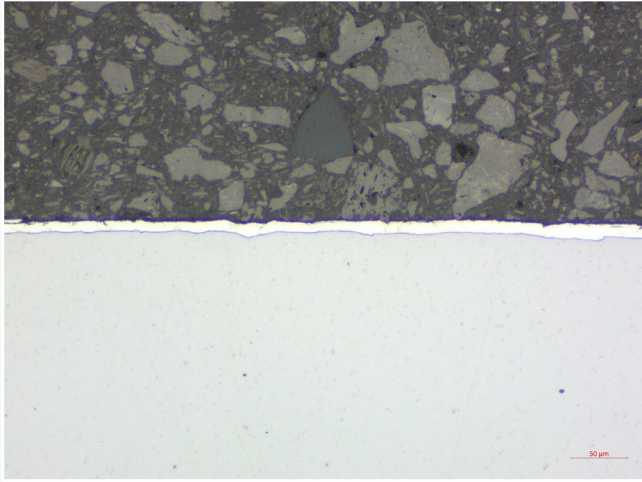
**** For very water sensitive coatings:**

Only diamond grinding/polishing using water-free suspensions for the 6 µm and 1 µm steps is recommended.

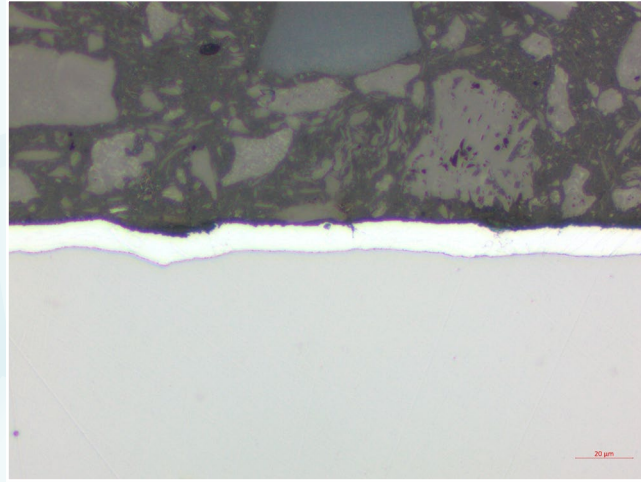


Aka-Brief #15 Zinc Coated Steel

FINAL RESULT



BF, 200x



BF, 500x