




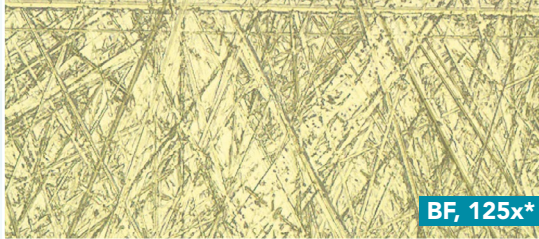
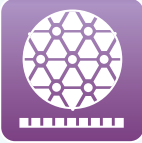


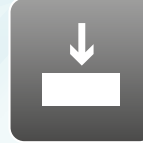









Aka-Brief #12 Hard Materials 700-2000 HV

1						➡➡➡➡	
	Piatto 120	Water	300 rpm	40 N	Until plane		
2							
	Allegran 9	DiaUltra 9 μm	150 rpm	45 N	3:30 min		
3						➡➡➡➡	
	Daran	DiaUltra 3 μm	150 rpm	40 N	3:30 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.

* Material prepared:
Tool Steel, 700 HV

