



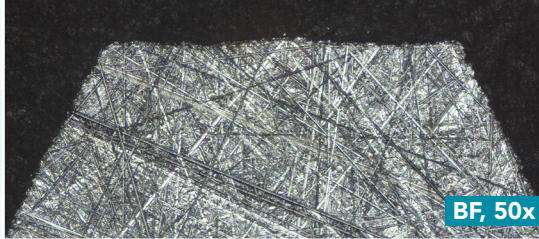
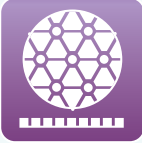

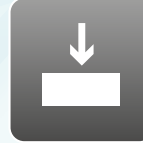






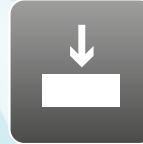




Aka-Brief #18 Surface Hardened Steel

1						➡➡➡➡			
	Piatto 220	Water	300 rpm	30 N	Until plane				
2								➡➡➡➡	
	Allegran 3	DiaUltra 9 μm	150 rpm	35 N	2:30 min				
3						➡➡➡➡			
	Ramda	DiaUltra 3 μm	150 rpm	30 N	2:00 min				
4								➡➡➡➡	
	Napal	DiaUltra 1 μm	150 rpm	20 N	0:30 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.

* The last preparation step is optional.

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

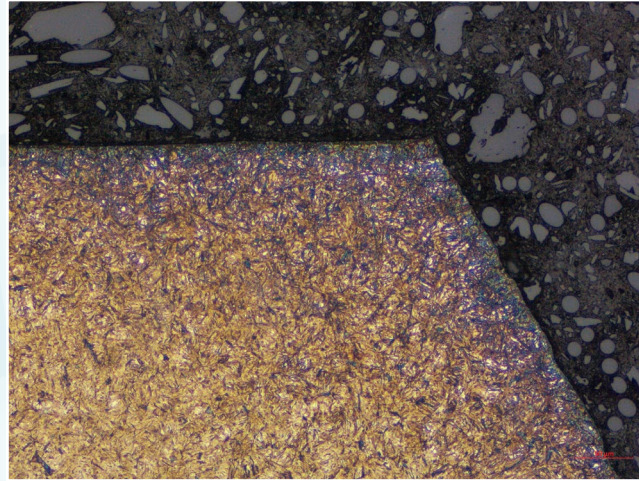


Aka-Brief #18 Surface Hardened Steel

FINAL RESULT



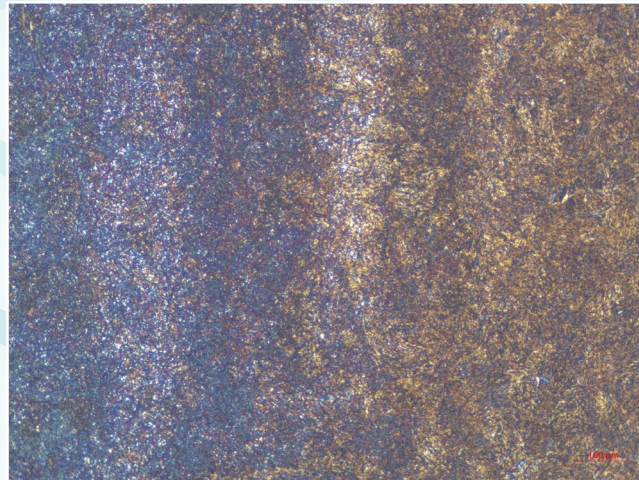
Etched with Nital 3%, BF, 50x



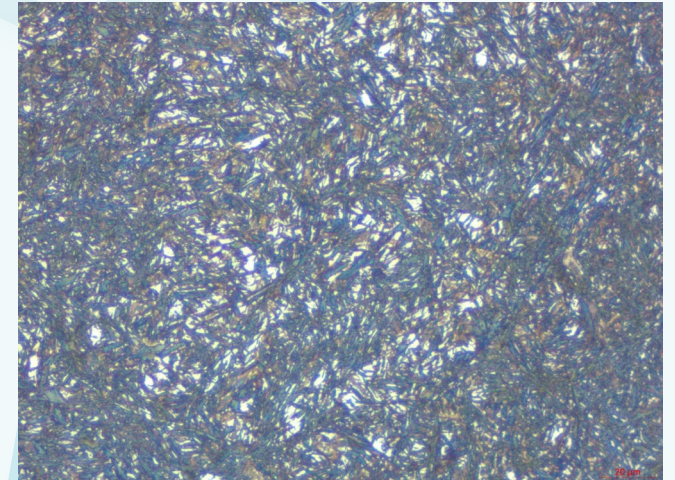
Etched with Nital 3%, BF, 200x



Etched with Nital 3%, BF, 50x



Etched with Nital 3%, BF, 100x



Etched with Nital 3%, BF, 500x