


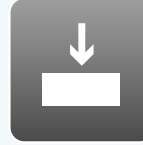

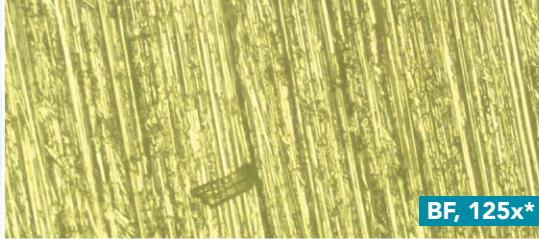
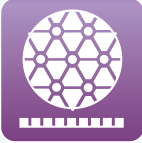


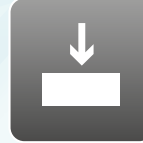

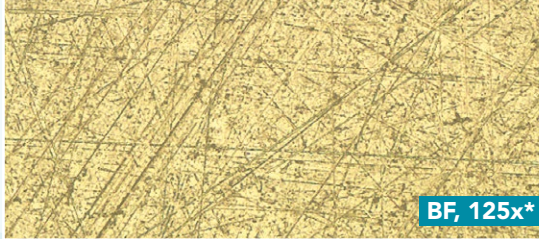





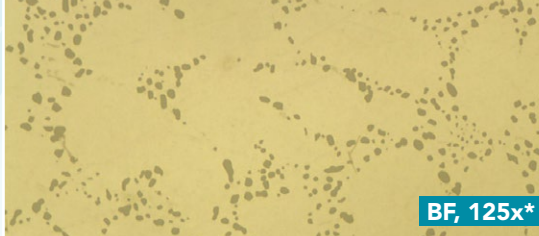


Aka-Brief #10 Soft Materials 50-150 HV

1						
	Rhaco Grit P320	Water	300 rpm	35 N	Until plane	BF, 125x*
2						
	Largan 9	DiaUltra 9 µm	150 rpm	35 N	3:30 min	BF, 125x*
3						
	Napal	DiaUltra 1 µm	150 rpm	35 N	2:30 min	BF, 125x*

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.

Time and Force may vary depending on the equipment.

* Material prepared:
AISI

