



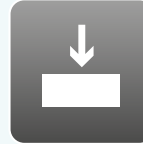



Aka-Brief #17 Nitrided and Nitrocarburized Steels

1						
	Piatto 220+	Water	300 rpm	35 N	Until plane	BF, 100x
2						
	Piatto 600+	Water	300 rpm	35 N	1:00 min	BF, 100x
3						
	Allegan 3	DiaUltra 9 μm	150 rpm	40 N	3:00 min	BF, 100x
4						
	Ramda	DiaUltra 3 μm	150 rpm	35 N	3:00 min	BF, 100x
5						
	Napal	DiaUltra 1 μm	150 rpm	25 N	0:30 min	BF, 100x

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.

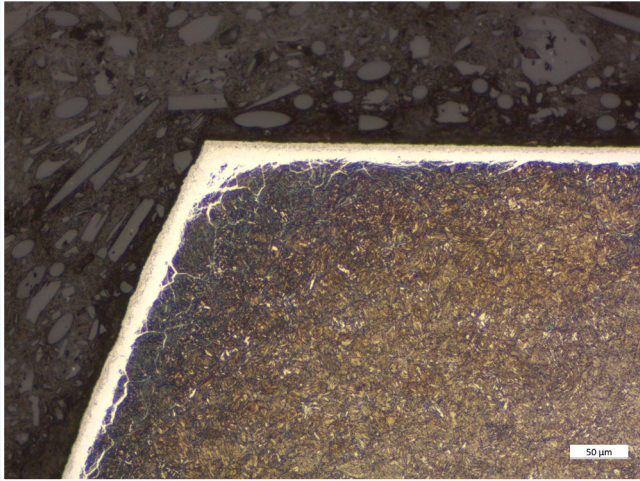
Time and force may vary depending on the equipment.

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

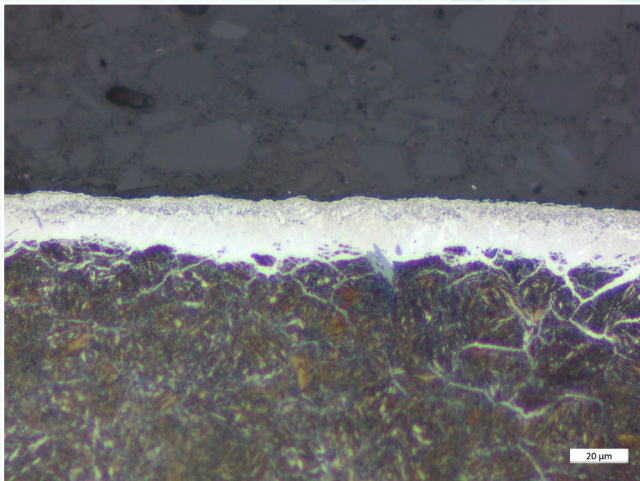


Aka-Brief #17 Nitrided and Nitrocarburized Steels

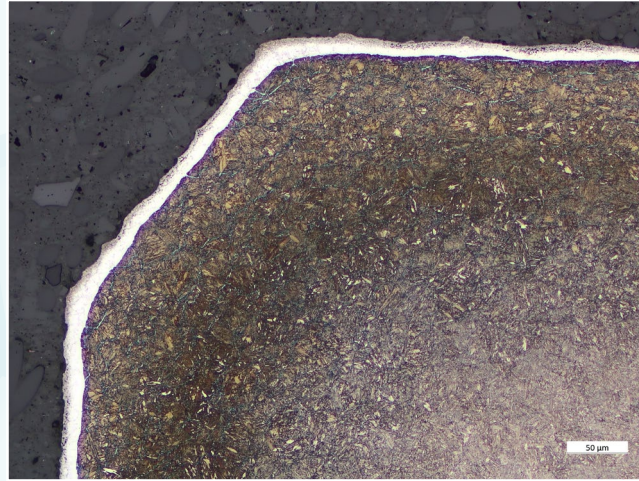
FINAL RESULT



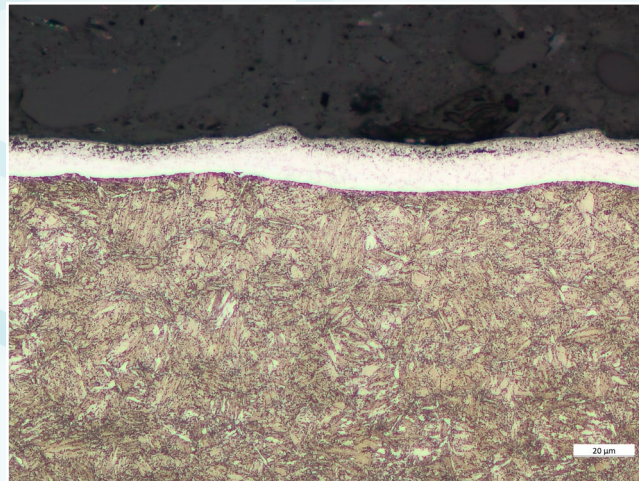
Nitrided Steel, etched with Nital 3%, BF, 200x



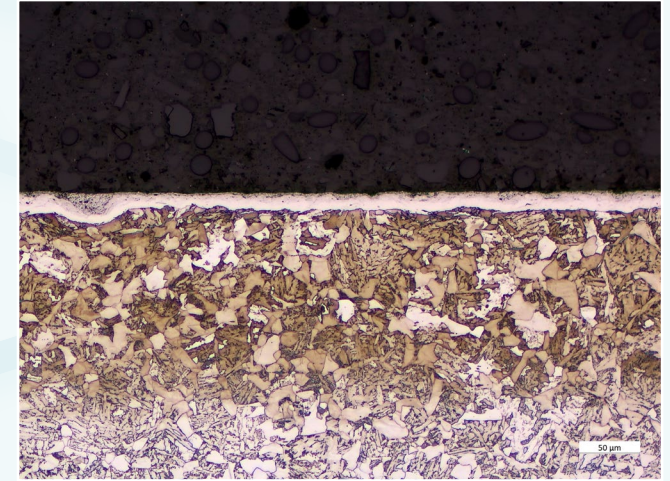
Nitrided Steel, etched with Nital 3%, BF, 500x



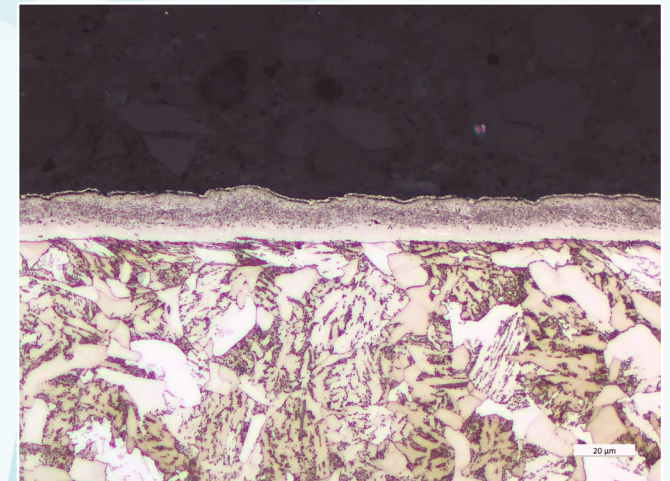
Nitrocarburized Impax Steel, etched with Nital 3%, BF, 200x



Nitrocarburized Impax Steel, etched with Nital 3%, BF, 500x



Nitrocarburized 16MnCr5 Steel, etched with Nital 3%, BF, 200x



Nitrocarburized 16MnCr5 Steel, etched with Nital 3%, BF, 500x