


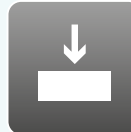

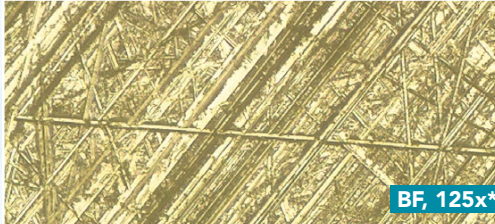





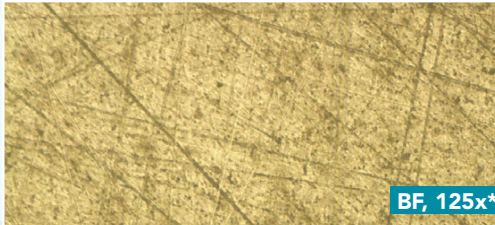





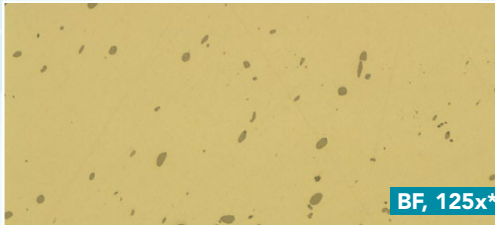


# Aka-Brief #11 Medium Hard Materials 400-700 HV

1						
	Piatto 220	Water	300 rpm	35 N	Until plane	
2						
	Allegran 3	DiaMaxx Poly 6 µm	150 rpm	35 N	5:00 min	
3						
	Ramda	DiaMaxx Poly 1 µm	150 rpm	35 N	4:00 min	

Times are stated for a 300 mm preparation system and 40 mm dia. samples.  
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:  
Free-cutting Steel