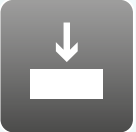



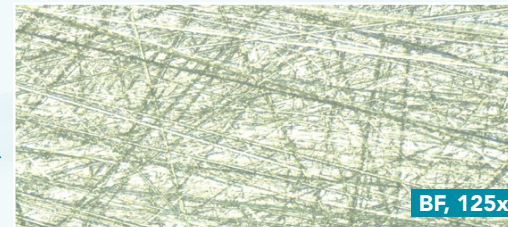


Aka-Brief #6 Coated Sintered Carbides


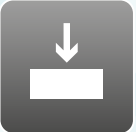



1



Piatto 220+ Water 300 rpm 35 N Until plane




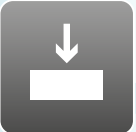



2



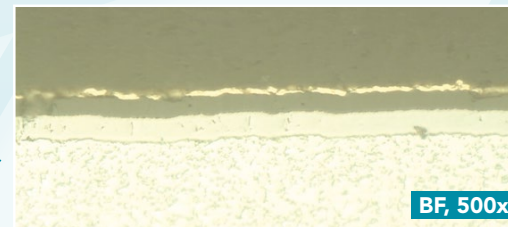
Allegran 3 Poly+ 3 µm Lube Blue 150 rpm 35 N 9:00 min



3



Allegran 1 Poly+ 1 µm Lube Blue 150 rpm 35 N 5:00 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.