

Plasma Spray Coatings - Ceramic Layers - Dense and thick layers

952

Grinding

	Steps	 PG	 FG	 FG 2
Surface 	Type	MD-Piano 220	MD-Largo	MD-Largo
	Disc speed (rpm)	300	150	150
Abrasive 	Type		DiaPro Allegro/Largo 9 µm	DiaPro Largo 3 µm
	Predosing/dosing		3/6	3/6
Lubricant 	Type	Water		
	Predosing/dosing			
	Force (N)	30	40	35
	Holder direction	>>	>>	>>
	Holder speed (rpm)	150	150	150
	Time (min)	1	5	4

Polishing

	Steps	 DP	 OP
Surface 	Type	MD-Dac	MD-Chem
	Disc speed (rpm)	150	150
Abrasive 	Type	DiaPro Dac 3 µm	OP-S, 0.25 µm
	Predosing/dosing	3/6	1/10
Lubricant 	Type		
	Predosing/dosing		
	Force (N)	35	15
	Holder direction	>>	><
	Holder speed (rpm)	150	150
	Time (min)	3	1

Method comments

The method is developed to fit a standard equipment configuration with 30 mm specimen on 300mm disc. Dosing levels are valid for following equipment: Tegramin, AbraPol and LaboPol

The preparation time for the plane grinding (PG) step depends very much on the condition of the samples and if they are prepared as single specimens or clamped in a specimen holder. Please check the samples after the first step and repeat it if necessary.

For advice on how to adjust the method to fit your equipment, please take a look at Preparation Parameters.

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