

Hot Dip Zn-Coating - Water sensitive layer

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Grinding

 Steps		 PG	 FG
Surface 	Type	SiC Foil #320	MD-Largo
	Disc speed (rpm)	300	150
Abrasive 	Type		DiaPro Allegro/Largo 9 µm
	Predosing/dosing		3/6
Lubricant 	Type	Water	
	Predosing/dosing		
	Force (N)	30	35
	Holder direction	>>	>>
	Holder speed (rpm)	150	150
	Time (min)	1	3

Polishing

 Steps		 DP	 DP 2
Surface 	Type	MD-Dur	MD-Dur
	Disc speed (rpm)	150	150
Abrasive 	Type	DP-Susp. A. 3 µm	DP-Susp. A. 1 µm
	Predosing/dosing	3/6	3/6
Lubricant 	Type	DP-Yellow	DP-Yellow
	Predosing/dosing	3/10	3/10
	Force (N)	30	15
	Holder direction	>>	><
	Holder speed (rpm)	150	150
	Time (min)	3	3

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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