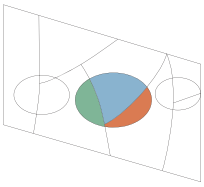

Metalog Method – example Tool steel **Y**

	Steps	PG	FG
Grinding	Surface	MD-Piano 220	MD-Plan
	Abrasive	Diamond	DiaPro Plan 9
	Grain size		9 µm
	Lubricant	Water	
	Rotational speed [rpm]	300	150
	Force[N]/ specimen	30	30
	Time [min]	Until plane	3

	Steps	DP
Polishing	Surface	MD-Floc
	Abrasive	DiaPro Floc 3
	Grain size	3 µm
	Lubricant	
	Rotational speed [rpm]	150
	Force[N]/ specimen	25
	Time [min]	3