


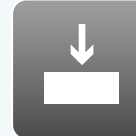

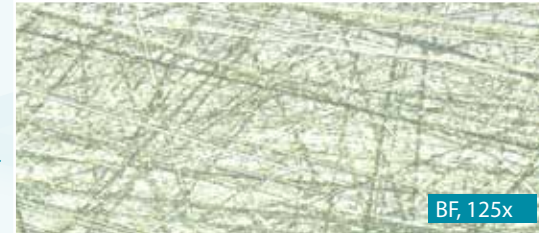


Aka-Brief #6 Coated Sintered Carbides






1

Piatto 220+ Water 300 rpm 35 N Until plane








2

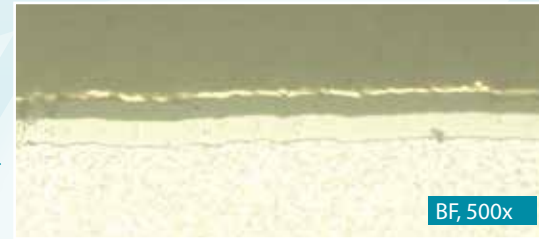
Allegran 3 Poly+ 3 µm Lube Blue 150 rpm 35 N 9:00 min



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 Forces for an individual 40 mm dia. sample.

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.