

Grinding

 Step	 PG	 FG
 Surface	MD-Piano 120	MD-Allegro
 Abrasive	Diamond	DiaPro AllegroLargo 9
 Grit/ Grain size		9 μm
 Lubricant	Water	
 Rotational speed [rpm]	300	150
 Force[N]/ specimen	50	40
 Time [min]	Until plane	4

Step	DP
Surface	MD-Dac
Abrasive	DiaPro Dac 3
Grain size	3 μm
Lubricant	
Rotational speed [rpm]	150
Force[N]/specimen	180
Time [min]	3