

## GALA Preparation for Coated Steel Samples (e.g. Tin, ZE, Zinc, Galfan, Galvalume, Galvannealed)

For 6 samples, diameter 40 mm  
with central pressure system  
Hot-mounted samples

Process	Medium / Grit size	Rotation direction	rpm (min <sup>-1</sup> )	Pressure per sample 40 mm (N)	Time (min)
<b>Grinding I</b>	SiC Paper #320 <sup>1</sup>	⇒	300	250	1.5
<b>Grinding II</b>	SiC Paper #500 <sup>1</sup>	⇒	300	250	1.5
<b>Alternative Grinding III</b>	Pad QUICK-STEP MAGNUM-GREEN 15 μm <sup>2</sup>	⇒	150	400	2
<b>Polishing I</b>	Pad STEP-PLUS MAGNUM-GREEN 3 μm <sup>2</sup>	⇒	150	400	2-2.5
<b>Polishing II</b>	Pad GOLD MAGNUM-GREEN 1 μm <sup>2</sup>	⇒	150	200	2

### Notes

<sup>1</sup> Use water as coolant/lubricant. Use reduced flow-rate for CARAT disc.

<sup>2</sup> MAGNUM-GREEN: alcohol-based suspension for manual dosage - spray 5x only before polishing. During polishing use only LUBRICANT-YELLOW. Not for use with automatic dosing systems.

### Cleaning

After the 3 μm polishing step, the samples may be cleaned only using 99% pure alcohol (ethanol 642). Do not use cotton wool pads since this may cause scratching. Use alcohol or LUBRICANT-YELLOW in an ultrasonic bath directly after the polishing step for best results. If necessary wipe samples carefully using a Kleenex tissue wetted with alcohol.

