

## GALA Preparation for Copper and Brass Samples

Sample diameter: 30 mm, 40 mm, 50 mm  
with multiple pressure systems for individual sample pressure

Process	Medium / Grit size	Rotation direction	rpm (min <sup>-1</sup> )	Pressure per sample 30 mm (N)	Pressure per sample 40 mm (N)	Pressure per sample 50 mm (N)	Time (min)
<b>Grinding I</b>	SiC Paper #1200 (if needed down to SiC #2500) <sup>1</sup>	⇒	300	20	35	55	2
<b>Polishing I</b>	Pad SWING-PLUS - or - STEP-PLUS MAGNUM-TOP-DUO 3 μm <sup>3</sup> - or - MAGNUM-GREEN 3 μm <sup>2</sup>	⇒	150	35	50	80	5
<b>Polishing II</b>	Pad SWING-PULS - or - ALUPOL-PLUS MAGNUM-TOP-DUO 1 μm <sup>3</sup> - or - MAGNUM GREEN 1 μm <sup>2</sup>	⇒	150	20	35	55	3-4
<b>Polishing III</b>	Pad MAMBO O.P.S. oxide slurry 50 nm <sup>4</sup>	⇒	150	20	30	55	40 s O.P.S. 10 s water

### Notes

<sup>1</sup> Use water as coolant/lubricant.

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

<sup>3</sup> MAGNUM-TOP-DUO: water-based suspension for manual or automatic dosage. Use without lubricants.

<sup>4</sup> Moisten MAMBO pad before usage with de-ionized water. After O.P.S. polishing rinse with de-ionized water for 10 s.

