

GALA Preparation for Nitrided Case Samples and Case-Hardened Steel Samples

Sample diameter: 30 mm, 40 mm, 50 mm
with multiple pressure systems for individual sample pressure
Hot-mounted samples

Process	Medium / Grit size	Rotation direction	rpm (min ⁻¹)	Pressure per sample 30 mm (N)	Pressure per sample 40 mm (N)	Pressure per sample 50 mm (N)	Time (min)
Grinding I	SiC Paper #240 ¹	⇒	300	20	35	55	2
Grinding II	CARAT 15 μm ¹	⇒	300	35	60	100	3-4
Polishing I	Pad STEP-PLUS MAGNUM-GREEN 3 μm ²	⇒	150	35	50	90	5
	- or - MAGNUM-TOP-DUO 3 μm ³						
Polishing II	Pad MAMBO O.P.S. oxide slurry 50 nm ⁴	⇒	150	20	30	55	30 s O.P.S. 10 s water

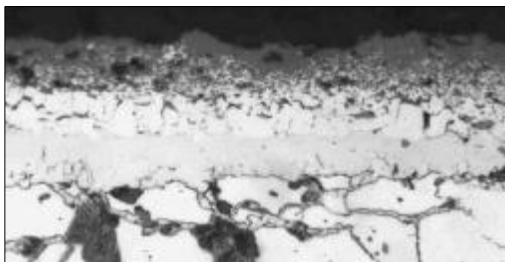
Notes

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

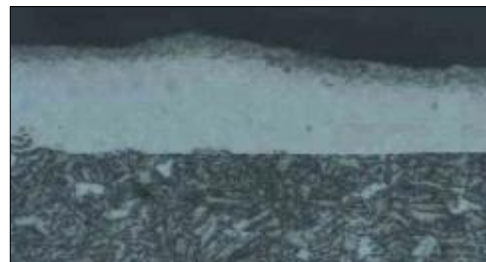
² MAGNUM-GREEN: alcohol-based suspension for manual dosage - spray 5x only before polishing. During polishing use only LUBRICANT-BLUE. Not for use with automatic dosing systems.

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

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



Nitrided case sample, mag. 1000x



Nitrided case sample, mag. 1000x

