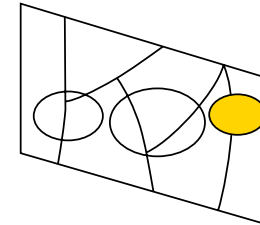












Metalog Method










Z



Grinding

 Step	 PG	 FG
 Surface	MD-Piano 120	MD-Allegro
 Abrasive	Diamond	DiaPro AllegroLargo 9
 Grit/ Grain size		9 μm
 Lubricant	Water	
 [rpm]	300	150
 Force [N]	300	240
 Time [min]	Until plane	4

Polishing

 Step	 DP
 Surface	MD-Dac
 Abrasive	DiaPro Dac 3
 Grain size	3 μm
 Lubricant	
 [rpm]	150
 Force [N]	30
 Time [min]	3