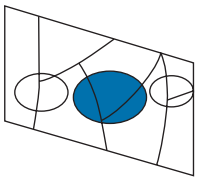
Metalog Method – example Tool steel Y



Grinding

Step	PG	FG
Surface	MD-Piano 220	MD-Plan
Abrasive	Diamond	DiaPro Plan 9
Grit/ Grain size		9 µm
Lubricant	Water	
Rotational speed [rpm]	300	150
Force[N]/ specimen	30	30
Time [min]	Until plane	3

Polishing

Step	DP
Surface	MD-Floc
Abrasive	DiaPro Floc 3
Grain size	3 µm
Lubricant	
Rotational speed [rpm]	150
Force[N]/ specimen	25
Time [min]	3