














PREPARATION METHOD

SPRAY COATINGS (METALLIC, CERAMIC)

	CUTTING	Equipment QATM Qcut / Brillant	Consumables Cut-off wheel: diamond, resin bond Anti-corrosion coolant	
	MOUNTING	Equipment Vacuum	Consumables KEM 90	Method Cold mounting

		Equipment QATM Qpol / Saphir Sample size \varnothing 40 mm				
STEP	MEDIUM		 rpm		 N	 min
	Planar grinding SiC-paper/foil P240 (180)	H ₂ O	250-300	▶▶ Synchronous rotation	30	Until plane
	Grinding SiC-paper/foil P800 (280)	H ₂ O	250-300	▶▶ Synchronous rotation	30	1:30
	Pre-polishing ALPHA/BETA	Dia Complete Poly, 9 μ m	120-150	◀▶ Counter rotation	25	5:00-8:00*
	Polishing DELTA	Dia Complete Poly, 3 μ m	120-150	▶▶ Synchronous rotation	30	5:00-8:00*
	Final polishing OMEGA	Eposal, 0.06 μ m	120-150	◀▶ Counter rotation	25	2:00 (H ₂ O during final 0:30)

* Until homogeneous porosity → next polishing step