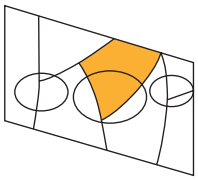
Struers
Ensuring Certainty

Metalog Method – example Grey Cast iron **D**



Grinding

Step	PG	FG
Surface	MD-Piano 220	MD-Allegro
Abrasive	Diamond	DiaPro AllegroLargo 9
Grit/ Grain size		9 µm
Lubricant	Water	
Rotational speed [rpm]	300	150
Force[N]/ specimen	40	30
Time [min]	Until Plane	3

Polishing

Step	DP	OP
Surface	MD-Dac	MD-Chem
Abrasive	DiaPro Dac 3	OP-A
Grain size	3 µm	
Lubricant		
Rotational speed [rpm]	150	150
Force[N]/ specimen	30	15
Time [min]	3	2