


Date:	21.04.2009								
Editor:	Füllmann, Robert								
Material:	AlMgSi0,5 (EN AW-6060) with Sn-solder, laser welding test								
Mounting:	cold, D=40 mm, EpoClear (Epoxy-Resin)								
<p>TIP // For reference images, take a look at our wide-ranging microstructure database. There you will find many micrographs of various materials, including their state of heat treatment and the etching agent we used.</p>									
<p>Link to our Microstructure Database (Gefügedatenbank)</p>									
	Grinding					Polishing			
	1	2	3	4	5	1	2	3	4
Base	SiC paper	SiC paper	SiC paper	SiC paper	SiC paper	MolTec	ChemTec		
Grit size	500	800	1200	2500	4000	3 µm mkd water-based	< 0,05 µm SiO2 OPS		
Lubricant	H2O	H2O	H2O	H2O	H2O	coolTec I	-		
Drive	150 rpm	150 rpm	150 rpm	150 rpm	150 rpm	150 rpm	150 rpm		
Rotation direction	><	><	><	><	><	><	><		
Downforce !centralpressure!	10 N/sample	10 N/sample	10 N/sample	10 N/sample	10 N/sample	10 N/sample	10 N/sample		
Time	bis plan	1,0 min	1,0 min	0,5 min	0,5 min	3,0 min	2+0,5 Spüli		
Etching	5% NaOH								
Remarks									

Legend [EN]	Legende [DE]
DPS = Diamond Plane Grinding Disc DSS = Diamond Grinding Disc ADAMANT = ADAMANT Diamond Grinding Disc IDAMANT = IDAMANT Diamond Grinding and Polishing Disc	DPS = Diamant-Planschleifscheibe DSS = Diamant-(Fein)schleifscheibe ADAMANT = ADAMANT Diamantschleifscheibe IDAMANT = IDAMANT-Schleifpolierscheibe
>< Countercurrent >> Concurrent	>< Gegenlauf >> Gleichlauf
mkd = monocrystalline Diamond, concentration 50 carat/litre pkd = polycrystalline Diamond, concentration 50 carat/litre	mkd = monokristalliner Diamant, Konzentration 50 Karat/Liter pkd = polykristalliner Diamant, Konzentration 50 Karat/Liter
Lubricant: coolTec I (Water-based) coolTec II (Alcohol-based) coolTec III (Oil-based) coolTec IV (Water-based) coolTec Orange (Anhydrous)	Schmiermittel: coolTec I (Wasserbasis) coolTec II (Alkohobasis) coolTec III (Ölbasis) coolTec IV (Wasserbasis) coolTec Orange (Wasserfrei)
Spüli: Dishwasher detergent with H2O for cleaning the samples	Spüli: Spüli mit Wasser zum Reinigen der Proben
You can find metallography supplies in our store (link)	Verbrauchsmaterialien finden Sie in unserem Shop (Link)