



Date:	09.12.2022
Editor:	Füllmann, Robert
Material:	Carbon fibre reinforced plastic (CFK)
Mounting:	Cold, D=40 mm, EpoClear (epoxy resin)

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.

[Link to our Microstructure Database \(Gefügedatenbank\)](#)

	Grinding					Polishing			
	1	2	3	4	5	1	2	3	Kurth
Base	SiC paper	SiC paper	SiC paper	SiC paper	SiC paper	RamTec	RamTec	RamTec	MolTec
Grit size	P120	P220/P500	P800	P1000	P2400	9 µm mkd water-based	3 µm mkd water-based	1 µm mkd water-based	1 µm mkd water-based
Lubricant	H2O	H2O	H2O	H2O	H2O	coolTec I	coolTec I	coolTec I	coolTec I
Drive	100 rpm	100 rpm	100 rpm	100 rpm	100 rpm	100 rpm	100 rpm	100 rpm	55 rpm
Rotation direction	>>	>>	>>	>>	>>	<<	<<	<<	oscillating
Downforce centralpressure!	10 N/sample	10 N/sample	15 N/sample	15 N/sample	15 N/sample	20 N/sample	20 N/sample	20 N/sample	1,75 kg*
Time	until planar	1,5 min	1,5 min	1,5 min	1,5 min	5,0 min	5,0 min	5,0 min	max. 30 min
Etching									
Remarks	9 µm RamTec can also be replaced by PanTec. Use plenty of lubricant for cooling. For small samples, start with > P320.								

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)