

Cast Iron Auto-Prep Method

LECO Corporation; Saint Joseph, Michigan USA



[] Fixed Holder [•] Single Sample Numbers in [] below are flow rates in ml/min

Grinding	Time (Minutes: Seconds)	Head Direction	Head Pressure (Pounds)	Head Speed (RPM)	Wheel Direction	Wheel Speed (FPM)
GPX300 (12" Wheel)						
Platinum #1 812-333, Water	2:00	CW	35	150	CCW	300

Pre-Polishing	Time (Minutes: Seconds)	Head Direction	Head Pressure (Pounds)	Head Speed (RPM)	Wheel Direction	Wheel Speed (FPM)
FAS Magnetic System 12" (812-383)						
Silver Disk, 6 μ m Cameo Suspension [5], Microid Extender [5], 812-336, 812-356, 811-003	2:00	CW	35	100	CCW	200

Polishing	Time (Minutes: Seconds)	Head Direction	Head Pressure (Pounds)	Head Speed (RPM)	Wheel Direction	Wheel Speed (FPM)
3 μ m Premium Suspension [1], Ultra Silk, Microid Extender [1], 810-997-016, 812-439, 811-003	3:00	CW	35	100	CCW	200
1 μ m Premium Suspension [5], Red Felt, Microid Extender [15], 810-998-016, 810-644, 811-003	1:00	CW	30	100	CCW	200
0.05 μ m Colloidal Silica, Imperial cloth, 812-110-300, 810-546-010	1:00	CW	25	75	CCW	150

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