











The following recommended procedures were all performed using the CAMEO Magnetic Disc System and LECO GPX200 and GPX300 Grinder/Polishers equipped with fixed sample holders.





### Aluminum/Copper/Brass

Grinding (until flat)	Time (min.)	Wheel Dir.	Head Dir.	Head Speed (RPM)	Head Pressure (lb.)	Wheel Speed (RPM)
	2:00	CCW	CW	75	35	200
Polishing						
 6μ	2:00	CCW	CW	75	35	200
 3μ	3:00	CCW	CW	100	40	200
 1μ	0:30	CCW	CW	100	40	200
 CS	2:00	CCW	CW	75	30	150




### Ductile and Gray Cast Iron

Grinding (until flat)	Time (min.)	Wheel Dir.	Head Dir.	Head Speed (RPM)	Head Pressure (lb.)	Wheel Speed (RPM)
	2:00	CCW	CW	100	50	200
	1:00	CCW	CW	100	40	200
Polishing						
 6μ	2:00	CCW	CW	100	40	200
 3μ	2:00	CCW	CW	100	40	200
 1μ	0:30	CCW	CW	100	35	200





### Hardened Steel for AMH (Auto-Microhardness Tester)

Grinding (until flat)	Time (min.)	Wheel Dir.	Head Dir.	Head Speed (RPM)	Head Pressure (lb.)	Wheel Speed (RPM)
	2:00	CCW	CW	75	40	200
	2:00	CCW	CW	75	35	200
Polishing						
 6μ	2:00	CCW	CW	75	35	200
 3μ	3:00	CCW	CW	100	35	200






### Cemented Carbide


















Grinding (until flat)	Time (min.)	Wheel Dir.	Head Dir.	Head Speed (RPM)	Head Pressure (lb.)	Wheel Speed (RPM)
	1:00	CCW	CCW	75	30	150
Polishing						
 6μ	4:00	CCW	CCW	75	30	150
 3μ	5:00	CCW	CCW	75	35	200
 CS	1:00	CCW	CCW	75	25	200

### Steel

Grinding (until flat)	Time (min.)	Wheel Dir.	Head Dir.	Head Speed (RPM)	Head Pressure (lb.)	Wheel Speed (RPM)
	2:00	CCW	CW	75	35	200
Polishing						
 6μ	2:00	CCW	CW	75	35	200
 3μ	2:00	CCW	CW	100	40	200
 1μ	0:30	CCW	CW	100	40	200

### Coated Cr-C-Ni

Grinding (until flat)	Time (min.)	Wheel Dir.	Head Dir.	Head Speed (RPM)	Head Pressure (lb.)	Wheel Speed (RPM)
	2:00	CCW	CW	75	35	175
	2:00	CCW	CW	75	35	175
Polishing						
 6μ	2:00	CCW	CW	75	35	175
 3μ	3:00	CCW	CW	100	45	200
 CS	2:00	CCW	CW	75	35	150

 CAMEO Platinum 0	 CAMEO Platinum 1	 CAMEO Platinum 2	 CAMEO Platinum 3	 CAMEO Platinum 4	 CAMEO Gold	 CAMEO Silver	 Ultra Silk	 Red Felt	 Imperial Cloth	 PEFA
 Diamond Suspension	 Diamond Compound	 Microid Extender	 Colloidal Silica	 Ultra Lap	 Water					

\*US Patent Number - 6 837 780

CAMEO is a registered trademark of LAM-PLAN Corporation.

**LECO Corporation**  
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Delivering the Right Results

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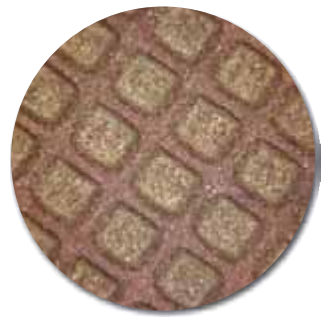
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# CAMEO® Disc System

## The Next Generation in Metallographic Sample Preparation



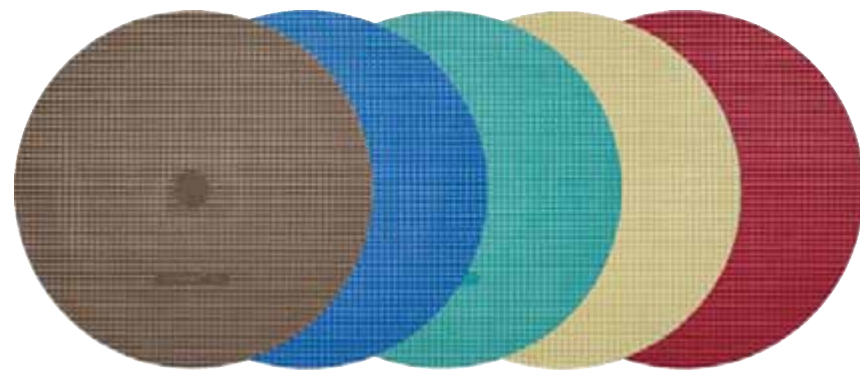
### The CAMEO Disc System Advantages

- Excellent sample flatness
- Consistent removal rates
- Convenient magnetic adhesion system
- Affordable for any metallographic lab

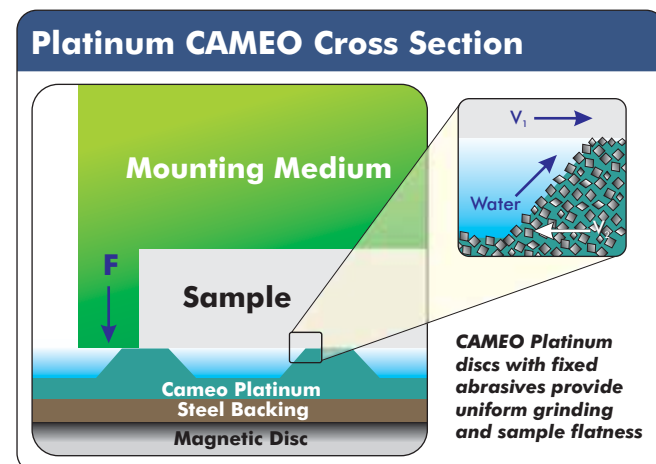
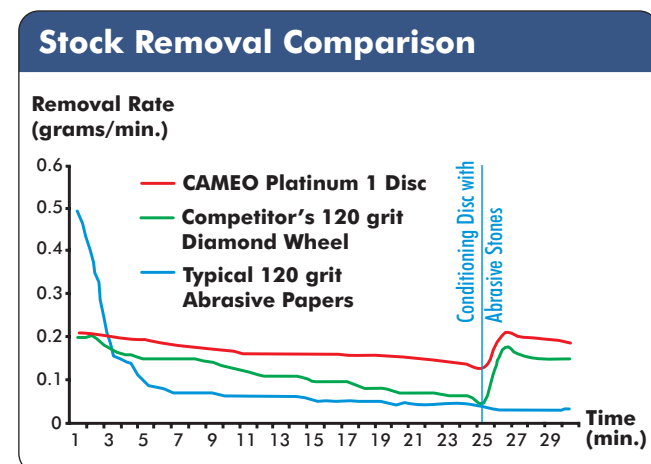
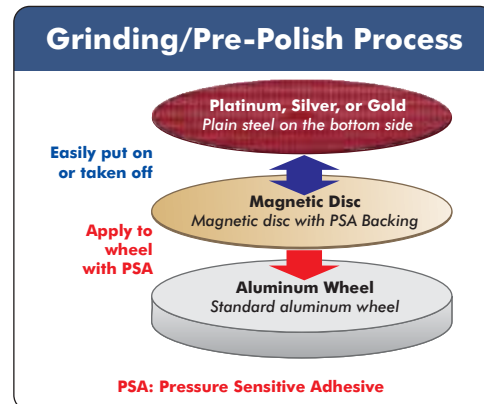
The key to CAMEO's success is the patented honeycombed structure. This system is ideal for materials with a hardness of 120 HV or greater. The micro-cavity concept provides uniformity and even distribution of abrasive suspension and coolant.

### CAMEO Platinum Series

The Platinum Series consists of diamond-grinding discs designed to flatten samples in a minimal amount of time. The CAMEO's patented structure provides uniform coolant and lubrication distribution. The magnetic adhesion system provides quick application and removal of the desired CAMEO disc.



Platinum CAMEO Disc	Color	Grinding Performance is Similar to this Abrasive Disc (CAMI)
Platinum 0	Brown	60 to 120 grit
Platinum 1	Blue	120 to 180 grit
Platinum 2	Green	220 to 280 grit
Platinum 3	Yellow	400 grit
Platinum 4	Red	600 grit



## CAMEO Silver and Gold Series

The CAMEO Silver and Gold Series are pre-polishing discs designed to replace 400 to 1200 grit SiC paper. Unlike the Platinum discs, the Silver and Gold discs must be regularly charged with diamond suspension (3  $\mu$ m-15  $\mu$ m). The CAMEO's patented structure retains the diamond abrasive, providing uniform grinding and sample flatness. The magnetic adhesion system provides quick application and removal of the desired CAMEO disc.

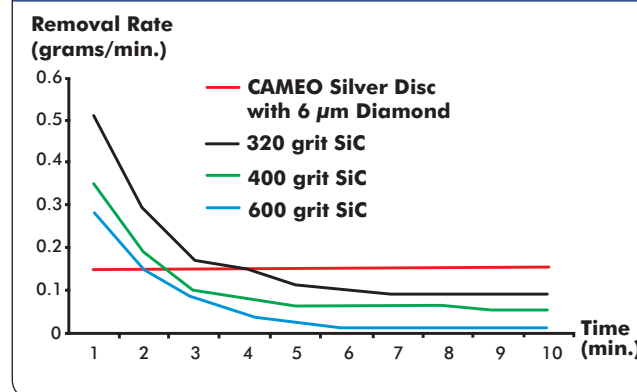


### Application

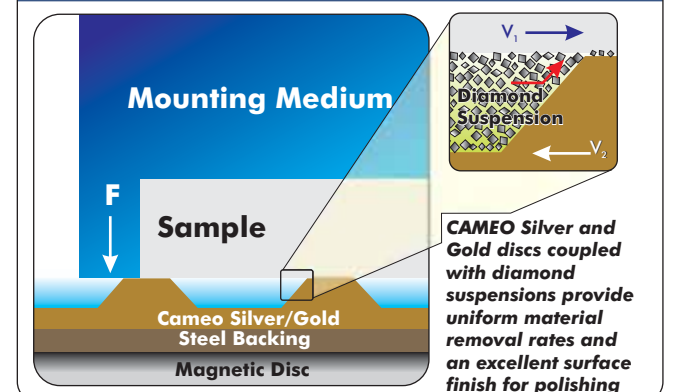
Gold—Nonferrous and softer materials (Charged with 3  $\mu$ m-6  $\mu$ m diamond)

Silver—Materials with a hardness of HV > 200 (Charged with 6  $\mu$ m-15  $\mu$ m diamond)

### Stock Removal Comparison/Abrasive Papers



### Silver and Gold CAMEO Cross Section



## CAMEO FAS Disc

The Fast Attachment System (FAS) disc allows PSA polishing cloths to be used in conjunction with the CAMEO magnetic adhesion system. The FAS disc's Teflon™ coating promotes effortless replacement.

