

Akasel Fact Sheet

Paran-S Polishing Cloth

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The Paran-S polishing cloth is based on a resin impregnated non-woven textile. Compared to other, woven polishing cloths, it has a very low resilience / high hardness, hence the diamond abrasive cannot be pressed very deep into the textile. This results in a high removal rate and a very good planeness of the prepared samples.



The Paran-S polishing cloth is very well suited for fine-grinding of soft materials like aluminium and aluminium alloys with a hardness >50 HV.



Recommended preparation method for soft materials where Paran-S is used for fine-grinding:























Preparation of soft materials					
1	Rhaco Grit P 320	Water	300 rpm	25 N	Until plane
2	Paran-S	DiaUltra 15 µm	150 rpm	30 N	3:30 min
3	Moran	DiaUltra 3 µm	150 rpm	25 N	3:00 min
4	Chemal	Fumed silica 0.2 µm	150 rpm	20 N	2:00 min

The parameters in the preparation method are based on 300 mm dia. disc size and 30 mm dia. individual samples



Another recommended application area is polishing of very hard materials like sintered carbides. Paran-S provides very good planeness and edge retention and will show excellent results even with coated sintered carbides where very thin layers have to be measured.

Preparation of sintered carbides					
1	 Piatto #220	 Water	 300 rpm	 35 N	 Until plane
2	 Allegran 3	 DiaUltra 6 µm	 150 rpm	 35 N	 3:30 min
3	 Paran-S	 DiaUltra 3 µm	 150 rpm	 30 N	 3:00 min
4	 Chemal	 Colloidal Silica silica 50 nm Alkaline	 150 rpm	 20 N	 1:00 min

The parameters in the preparation method are based on 300 mm dia. disc size and 40 mm dia. individual samples

Tip: Paran-S has a very open structure and therefore a quite long run-in time. To eliminate the run-in time, use Aka-Stick to prime the Paran-S cloth. Use the same grain size as the suspension or spray used.



The image shows the surface of the Paran-S and the open structure is clearly visible.