

**For optimal processing it is necessary to specify the delivered condition of the workpieces.
The following requirements must be met:**

1. Material

- Exact material and hardness specifications
- Homogeneous material structure
- No cavities, pores, grinding marks, foreign matter, mill scale, cracks, damage
- $Rz < 2 \mu m$
- Avoid cavities and blind holes
- No material distortion
- Avoid different material combinations
- No joints or overlaps
- No contamination by corrosion products
- No residues from mechanical pre-treatment
- Welding seams should be continuous
- Demagnetised

2. Pre-grinding

- Prevent localised overheating
- Apply sufficient cooling lubricant
- No cooling agents containing silicone, molybdenum, graphite or sulphur
- Avoid embedded particles by firing without infeed
- No residual turning marks

3. Pre-polishing

- No polishing agents containing silicone, molybdenum, graphite or sulphur
- Improper polishing leads to grease and polishing agent working into the surface

4. Preservation

- Avoid the following ingredients:
- Metal soaps
- Alkali soaps
- Sulphurated oils
- Chlorinated substances
- Natural oils (rapeseed ester)
- Ester oils
- Waxes and fats with a melting point $> 50^{\circ}C$
- Zinc
- Silicones

Recommended ingredients:

- Mineral oils, not pre-emulsified
- Paraffin oils
- Fatty alcohols

Other Notes:

- Sufficient mechanical protection (transport damage)
- Intact packaging (reuse for return)
- Avoid corrugated cardboard packaging