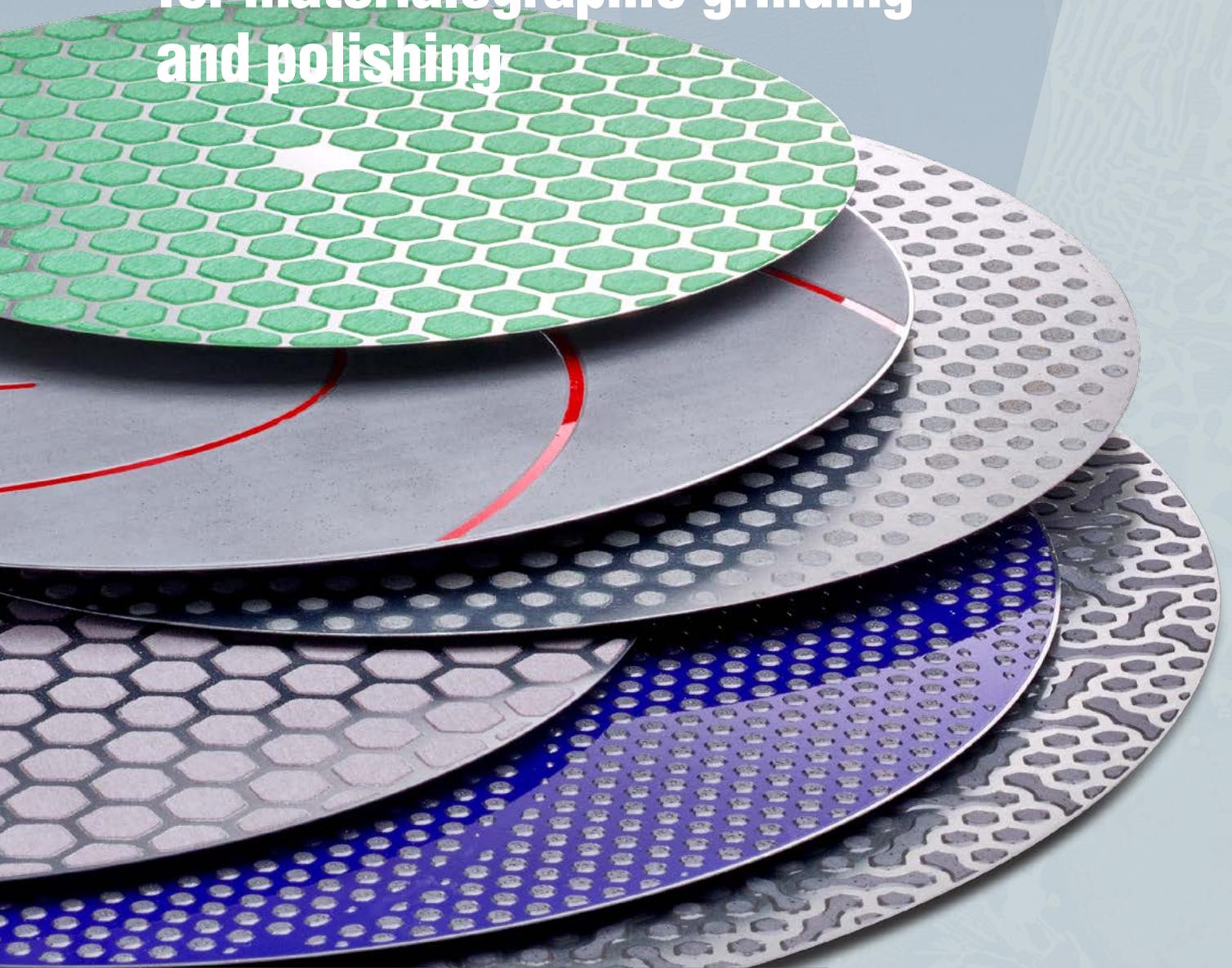


**The unique consumables
for materialographic grinding
and polishing**



- Ready-to-use
- Easy handling makes your job easier
- Constantly high removal
- Reduced preparation time
- Low maintenance

Introducing the MD-System to your lab

MD-Disc

The MD-Disc is the supporting disc for all preparation surfaces. It is available for most of your existing grinding and polishing equipment. The MD-Disc is equipped with a magnetic layer and is designed to provide the magnetic attraction required. Simply place the MD-grinding and polishing surfaces of your choice on the magnetic disc, the magnet will hold the preparation surface in place during the preparation. One disc is sufficient to support all preparation surfaces, so both space and money can be saved.

MD-System grinding discs and polishing cloths

MD-System is a line of metal-backed coarse and fine grinding discs as well as polishing cloths available in 200, 250, 300 and 350 mm / 8", 10", 12" and 14" diameters.

Common features

A thin and flexible steel plate

MD-preparation surfaces are all based on a thin flexible steel plate which makes positioning, removal and storage easy. Disc flatness is maintained throughout the life of the disc.

A patterned segment

All MD-grinding discs have a patterned segmented surface, specifically designed for the actual grinding phase, which minimizes build up of abraded material, allowing consistently high material removal rates, very short grinding time and optimum planeness.

Anti-slip backing

The coarser grinding discs are equipped with an anti-slip backing to ensure safe attachment to the MD-Disc even when there is high friction during the grinding process.

Reduced preparation time

Plane and fine grinding are reduced to two steps, shortening the preparation process consistently. As the specimens are totally flat after grinding on MD-Grinding discs, the time spent on the following Fine Grinding step can be reduced to about 50%. The succeeding polishing steps can also be carried out in a shorter time thanks to the outstanding planeness achieved in the fine grinding steps.

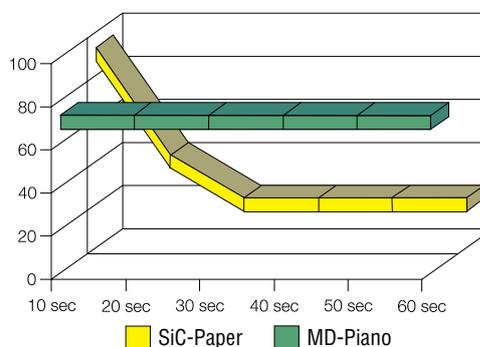
Longer lifetime

MD-Grinding discs have a much longer lifetime than any SiC-Paper.

Reduced preparation cost

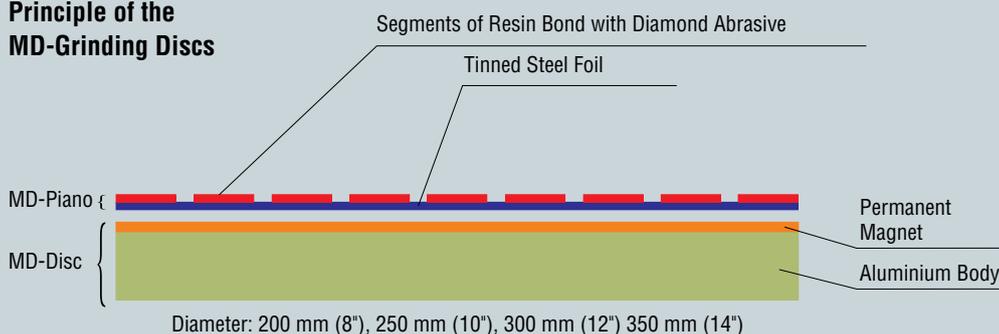
The MD-System produces better quality specimens, reduces maintenance and preparation time and has a longer lifetime than SiC-Paper; thus it potentially reduces preparation costs.

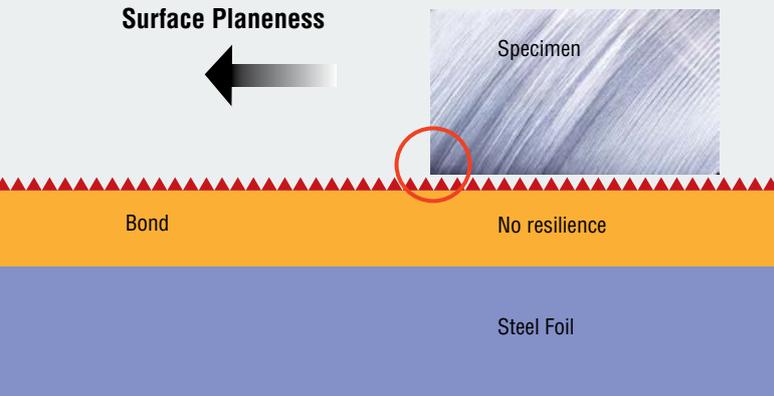
Removal Rate



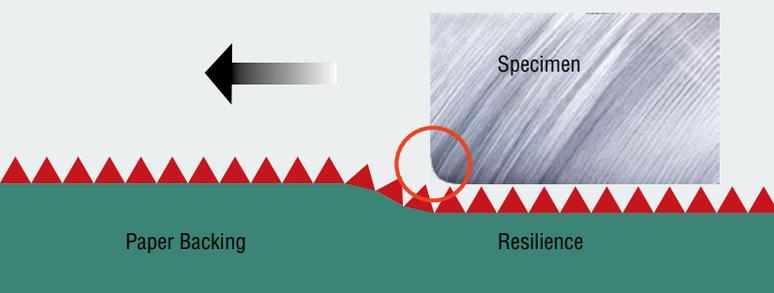
When using conventional grinding techniques with SiC paper, the removal rate decreases dramatically right from the beginning of the preparation. As shown on the graph, by contrast, the MD-Piano diamond grinding disc has a substantially higher and longer lasting removal rate, ensuring better quality specimens.

Principle of the MD-Grinding Discs



Surface Planeness

MD-Piano: No edge-rounding



SiC Paper: Edge rounding

Low maintenance

Except from occasional dressing the MD-Grinding discs need practically no maintenance, making them very easy to use.

Maximum flatness

The diamond bond used in MD-Piano and MD-Forte ensures a uniform material removal from both hard and soft phases during cutting action thus resulting in absolutely plane specimens with no relief between different phases. It also ensures that there will be no smearing in soft phases or chipping in brittle phases. Edge rounding at the interface between resin and specimen material is completely eliminated thus giving high quality specimens. See Surface Planeness drawing.

The MD-System

MD-Consumables are available for every step in the preparation process:

Plane Grinding**MD-Primo**

- For plane and fine grinding
- Particularly suitable for soft ferrous and non ferrous materials, HV 50-250
- High, constant removal during entire lifetime
- For all materials where SiC would normally be best choice
- Use for both manual and automatic grinding

MD-Molto

- For plane grinding
- Designed for grinding of aluminium alloys
- High and constant material removal during entire lifetime
- Can also be used for hard materials containing aluminium
- Use for both manual and automatic grinding

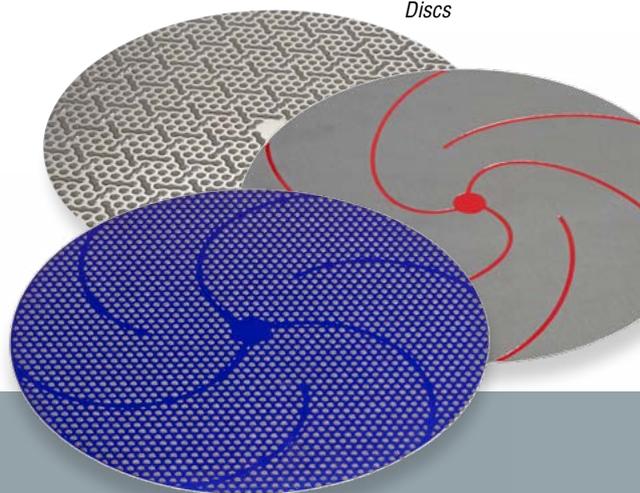
MD-Mezzo

- For plane grinding
- Designed for grinding of titanium alloys
- High, constant removal during entire lifetime
- Perfect planeness and edge retention

MD-Piano

- For plane and fine grinding of materials >150 HV
- Particularly suitable for ferrous materials
- High, constant removal during entire lifetime
- Alternative to diamond pads for larger ceramic /sintered carbide specimens
- Bar-pattern provides optimal support for moving specimen, meaning optimal planeness
- Water cooled, no need for additives
- Not suitable for ductile materials (low removal, excessive wear)

MD-Plane Grinding Discs



Fine Grinding

- For single step fine grinding
- Both discs can be used with diamond suspension or spray
- Recommended for use with all-in-one DiaPro diamond products

MD-Allegro is used for materials with a hardness higher than HV 150.

MD-Largo is designed for soft materials in the range HV 40-250, or for composites with a soft matrix. MD-Largo gives very good results where MD-Allegro tends to be too aggressive, for example grey cast iron.

MD-Allegro and MD-Largo can be used to replace two different types of preparation routines.

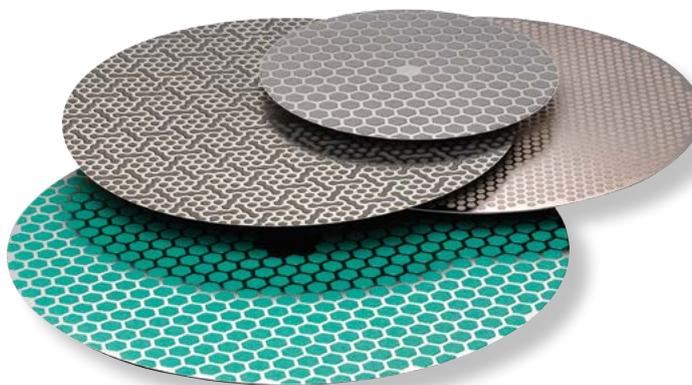
- Both MD-Allegro and MD-Largo offer Fine Grinding in one step with DiaPro-Allegro/Largo instead of the normal grinding steps with SiC-Paper #500, #1000, #2400 and 4000.
- MD-Allegro and MD-Largo can also be used instead of fine grinding cloths.
- For very fragile materials or high requirements on planeness, MD-Largo can also be used with DiaPro Largo that is equivalent to a 3 µm diamond suspension.

MD-Piano 500/1200

MD-Piano 500/1200 is used for Fine Grinding. MD-Piano 500 will reduce grinding time when grinding specimens clamped in holder. A specimen finished on MD-Piano 500 can be used directly for electrolytic polishing or micro-hardness testing.

MD-Piano 2000/4000

MD-Piano 2000/4000 can be used instead of MD-Allegro/MD-Largo for both manual and automatic fine grinding.



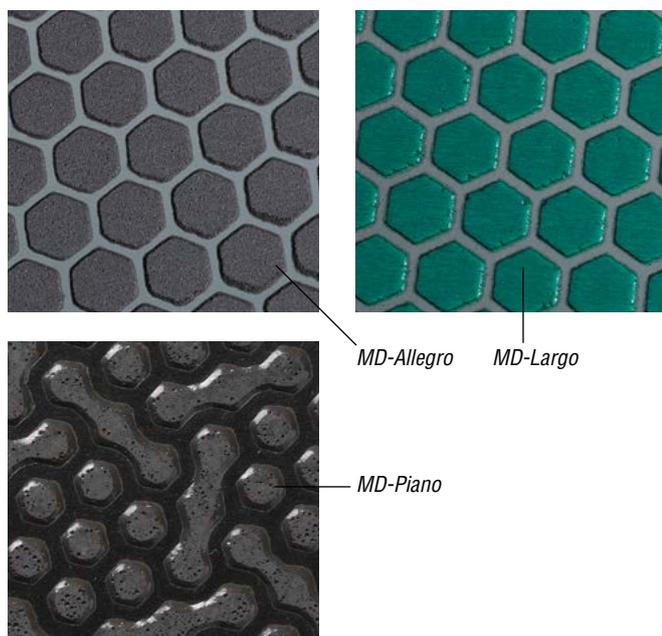
MD-Fine Grinding Discs

Advantages:

- Shorter preparation time. Thanks to the perfect planeness of the specimens after grinding on MD-Piano 80, 120 or 220, it is possible to go directly to MD-Piano 500 or 1200.
- Automatic fine grinding is also possible.
- Very short grinding times.
- Easier cleaning if MD-Piano 1200, 2000 and 4000 are used instead of MD-Allegro as the black swarf is avoided.
- Very long lifetime compared to SiC-Paper. MD-Piano 500 and 1200 can prepare up to 100 specimen holders. MD-Piano 2000 and 4000 prepare up to 300 specimen holders.

Polishing

The MD-Polishing Cloths is a line of cloths suitable for all final polishing procedures. The MD-Polishing cloths are equipped with a magnetic backing for the supporting layer and an intermediate layer which keeps the diamond grains in the active layer.



MD-Polishing Cloths

Selection Guide

Plane Grinding

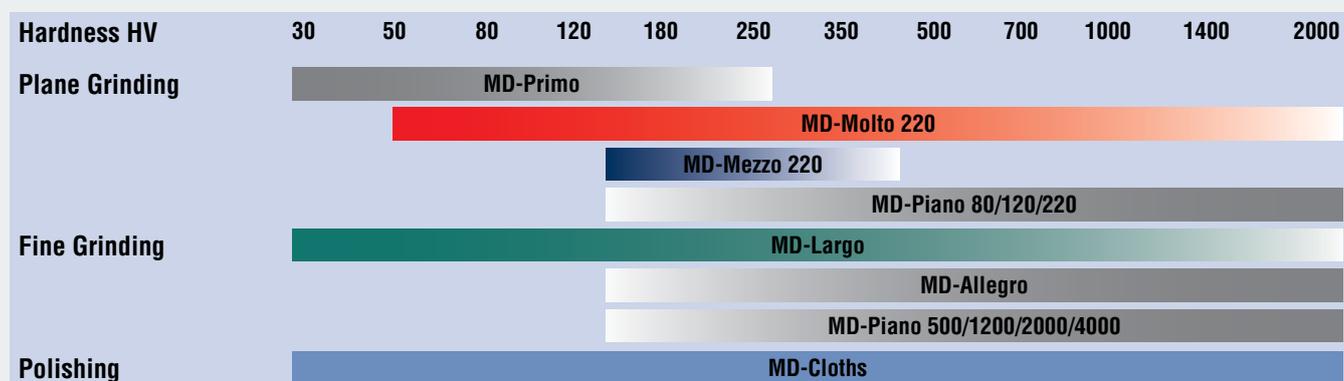
Disc	Application areas	Hardness range	FEPA P grit size equivalent	ANSI (US) grit size equivalent	Grain size equivalent (µm)	Abrasive (embedded)	Abrasive Bond	Indicative lifetime*	Pre-dressed/Ready-to-use
MD-Primo 120 220	Non-ferrous metals + soft materials -	40 - 250 HV -	120 220	120 220	125 68	SiC -	Resin -	50 -	Yes -
MD-Molto 220	Aluminium alloys, and hard materials containing aluminium	50 - 2000 HV	220	220	68	Diamond	Resin	100	Yes
MD-Mezzo 220	Titanium alloys	150 - 450 HV	220	220	68	Diamond	Resin	100	Yes
MD-Piano 80 120 220	Ferrous metals + hard materials - -	150 - 2000 HV - -	80 120 220	80 120 220	200 125 68	Diamond - -	Resin - -	100 - -	Yes - -

Fine Grinding

Disc	Application areas	Hardness range	FEPA P grit size equivalent	ANSI (US) grit size equivalent	Grain size equivalent (µm)	Abrasive (embedded)	Abrasive Bond	Indicative lifetime*	Pre-dressed/Ready-to-use
MD-Piano 500 1200 2000 4000	Ferrous metals + hard materials - - -	150-2000 HV - - -	500 1200 2000 4000**	360 600 800 1000**	30 15 10 5	Diamond - - -	Resin - - -	100 - 300 -	Yes - - -
Disc	Application areas	Hardness range	Abrasive (added)	Abrasive (µm)	Indicative lifetime*	Pre-dressed/Ready-to-use			
MD-Allegro	Fine grinding of materials harder than 150 HV	>150 HV	Suspension/spray	15-6	150	Yes			
MD-Largo	Soft materials, composites with soft matrix	40-250 HV	-	9-3	-	-			

Polishing cloth - please see separate brochure for further details

Disc	Application areas	Resilience	Hardness range	Abrasive (µm)	Material
MD-Plan	Fine grinding of soft material Pre-polishing of hard materials	Very low	Hard	15-3	Coated, woven polyester
MD-Pan	Fine grinding of soft metals. Pre-polishing and polishing of hard and brittle materials	Very low	Hard	15-1	Impregn. non-woven technical textile
MD-Sat	Fine grinding and polishing of ferrous metals, non-ferrous metals, coatings and plastics	Medium	Hard	9-3	Woven acetate
MD-Dur	Fine grinding and polishing of ferrous metals, non-ferrous metals, coatings and plastics	Medium	Hard	9-1	Satin woven natural silk
MD-Dac	Polishing of all materials	Medium	Hard	6-3	Satin woven acetate
MD-Mol MD-Mol APS	Polishing of ferrous and non-ferrous metals and polymers	High	Soft	≤ 3	Taffeta woven 100 % wool APS for Automatic Preparation Systems
MD-Plus	One step polishing for sintered carbides and steels	High	Soft	≤ 3	Synthetic nap
MD-Floc	Polishing of all materials	High	Soft	≤ 3	Synthetic nap
MD-Nap	Final polishing of all materials	Very high	Very soft	≤ 1	Synthetic short nap
MD-Chem MD-Chem NonStick	Final polishing of all materials	High	Soft	<1	Porous neoprene NonStick for large specimens to avoid suction



Maintenance

The MD-Consumables are practically maintenance-free which makes them very easy to use.

MD-Primo	A brief dressing of the SiC layer is necessary from time to time
MD-Molto / MD-Mezzo	A brief dressing of the diamond layer can be required from time to time
MD-Piano	A brief dressing of the diamond layer is necessary from time to time
MD-Allegro	Are virtually maintenance-free though occasional cleaning is recommended
MD-Largo	Are virtually maintenance-free though occasional cleaning is recommended
MD-Cloths	No maintenance required

* Indicative values corresponding to preparation of number of specimen holders, 6 x ø 30 mm. Actual lifetime depends on application (prepared material, size, shape, number etc).

** Not part of FEPA P or ANSI standardization



Other consumables

MD-Gekko is an adapter disc with a high friction foil that makes consumables with a glossy back stick

very well, yet at the same time very easy to remove again. Also self-adhesive consumables stick safely and can be removed again effortlessly without leaving even a trace of adhesive on the MD-Gekko surface.

MD-Gekko is ideal for the use with SiC Foil. Based on a strong PET film, the SiC Foil, due to its glossy surface sticks safely to the MD-Gekko. It can easily be removed and reapplied. Because of MD-Gekko, SiC Foil is superior to both plain and self-adhesive SiC Paper.

MD-Rondo is an alternative to MD-Gekko for use with self-adhesive consumables like polishing cloths.

Adaptability and multi-functionality

Both MD-Gekko and MD-Rondo extend the product range of the MD-System. They allow the use of any self-adhesive consumables and with MD-Gekko also all consumables with a glossy back. Thereby they are adding all the advantages of the MD-System to your favourite grinding discs or polishing cloths.

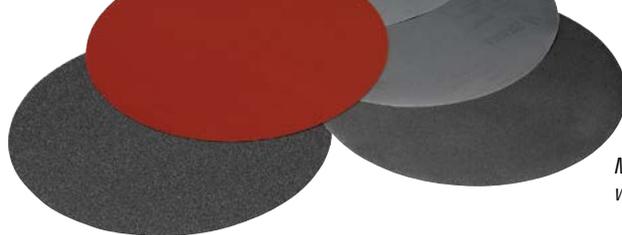
A dual-adhesion surface

MD-Rondo makes the polishing cloths or self adhesive grinding papers stick safely but also easy to remove. The top surface is covered with two different coatings with dissimilar properties, thus dual-adhesion: a 2 cm wide outer rim with higher adhesion properties which makes the cloth stick safely; and the centre which is coated with a low adhesion coating, allowing for very easy removal of the consumables. The combination of these two coatings ensures that the edges of the cloth does not lift up from MD-Rondo, and that at the same time, removal towards the centre, where the contact area gets larger, is very easy.

A surface with a three dimensional topography

The three dimensional surface makes it very easy to apply a polishing cloth or grinding paper without trapping air bubbles underneath. The coating that is printed on the surface of MD-Rondo is in a hexagon pattern. Between these hexagons are small air channels. When the polishing cloth is applied on the surface of MD-Rondo, air can easily escape thereby completely avoiding air bubbles.

It is virtually impossible to trap air under a polishing cloth applied to this unique surface.



MD-Gekko
with SiC Foil

Magnetic Foil

Magnetic Foil is a self-adhesive, magnetic foil that allows you to use your MD-consumables onto a standard aluminium-supporting disc.

Magnetic Foil comes as a square sheet and with a knife so it can be cut to the exact size of your aluminium supporting disc. Magnetic Foil is a soft foil which is easy to apply and should be used only on aluminium supporting discs.

Storage

MD-Concertino is a storage cabinet with 8 identical compartments. for 200 mm / 8" MD-Consumables.

MD-Concertino has the same structure and is used the same way as MD-Concert. It takes up less storage room than the larger MD-Concert.

MD-Concert is a storage cabinet for 200 mm / 8", 250 mm /10" and 300 mm /12" MD-Consumables. It has 10 identical compartments and is easy to clean.

MD-Concert consists of a steel spindle on which the compartments are stacked.

The compartments can be turned to the left and the right, so that they can be accessed from both sides, no matter where the MD-Concert is placed.

The storage cabinet allows the consumables to dry effectively, and protects the preparation discs from contamination.

For **350 mm** MD-Consumables a **storage cabinet** is available. It holds 10 MD-Consumables and allows the consumables to dry effectively, and protects the preparation discs from contamination.



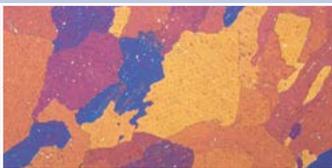
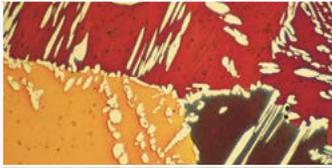
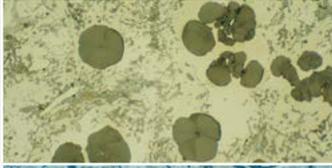
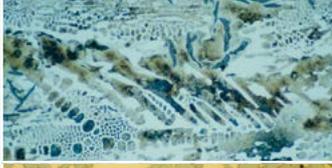
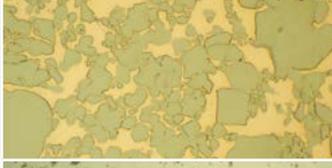
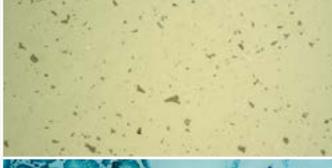
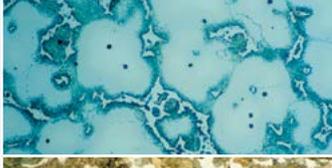
350 mm storage cabinet

MD-Concert and MD-Concertino for easy storage and immediate identification of MD-Consumables



Preparation methods overview

10 Metallog Guide preparation methods

			Plane Grinding	Fine Grinding	Diamond Polishing	Oxide Polishing
Method A Ex. Al 99,5 sand cast		 Surface	SiC-Foil (on MD-Gekko)	MD-Largo	MD-Mol	MD-Chem
		 Abrasive, Grit/Grain	SiC # 320	DiaPro Allegro/Largo 9 µm	DiaPro Mol R 3 µm	OP-S NonDry 0.04 µm
Method B Ex. Cu pure		 Surface	SiC Foil (on MD-Gekko)	MD-Largo	MD-Mol	MD-Chem
		 Abrasive, Grit/Grain	SiC # 320	DiaPro Allegro/Largo 9 µm	DiaPro Mol R 3 µm	OP-S NonDry 0.04 µm
Method C Ex. Cu 58 Zn 42		 Surface	SiC Foil (on MD-Gekko)	MD-Largo	MD-Dac	MD-Chem
		 Abrasive, Grit/Grain	SiC # 320	DiaPro Allegro/Largo 9 µm	DiaPro Dac 3 µm	OP-S NonDry 0.04 µm
Method D Ex. Nodular cast iron		 Surface	MD-Piano 220	MD-Allegro	MD-Dac	MD-Chem
		 Abrasive, Grit/Grain	Diamond * ~ #220	DiaPro Allegro/Largo 9 µm	DiaPro Dac 3 µm	OP-AA 0.02 µm
Method E Ex. White cast iron		 Surface	MD-Piano 220	MD-Allegro	MD-Dur	MD-Chem
		 Abrasive, Grit/Grain	Diamond * ~ #220	DiaPro Allegro/Largo 9 µm	DiaPro Dur 3 µm	OP-U NonDry 0.04 µm
Method F Ex. WC in Cu matrix		 Surface	MD-Piano 120	MD-Allegro	MD-Dac	MD-Chem
		 Abrasive, Grit/Grain	Diamond * ~ #120	DiaPro Allegro/Largo 9 µm	DiaPro Dac 3 µm	OP-U NonDry 0.04 µm
Method G Ex. Al ₂ O ₃		 Surface	MD-Piano 220	MD-Plan		MD-Chem
		 Abrasive, Grit/Grain	Diamond * ~ #220	DiaPro Plan 9 µm		OP-S NonDry 0.04 µm
Method X Ex. MgAl alloy		 Surface	SiC-Foil (on MD-Gekko)	MD-Largo	MD-Mol	
		 Abrasive, Grit/Grain	SiC # 320	DiaPro Allegro/Largo 9 µm	DiaPro Mol R 3 µm	
Method Y Ex. Medium carbon steel		 Surface	MD-Piano 220	MD-Plan	MD-Floc	
		 Abrasive, Grit/Grain	Diamond * ~ #220	DiaPro Plan 9 µm	DiaPro Floc 3 µm	
Method Z Ex. Sintered carbide with coatings		 Surface	MD-Piano 120	MD-Allegro	MD-Dac	
		 Abrasive, Grit/Grain	Diamond * ~ #120	DiaPro Allegro/Largo 9 µm	DiaPro Dac 3 µm	

*Corresponds to FEPA P standard grain size.

SPECIFICATIONS
Magnetic supporting disc

Name	Disc dia. 350 mm (14")	Disc dia. 300 mm (12")	Disc dia. 250 mm (10")	Disc dia. 200 mm (8")
MD-Disc	02426933	02426918	02426919	02426920
MD-Disc with cone		For Tegramin-30 06086403	For Tegramin-25 06086402	For Tegramin-20 06086401

Grinding surfaces for plane grinding

Name	Disc dia. 350 mm (14")	Disc dia. 300 mm (12")	Disc dia. 250 mm (10")	Disc dia. 200 mm (8")
MD-Primo 120	40800118*	40800087*	40800086*	40800085*
MD-Primo 220		40800090*	40800089*	40800088*
MD-Molto 220	40800190*	40800189*	40800188*	40800187*
MD-Mezzo 220	40800194*	40800193*	40800192*	40800191*
MD-Piano 80	40800124*	40800123*	40800122*	40800121*
MD-Piano 120	40800128*	40800127*	40800126*	40800125*
MD-Piano 220	40800132*	40800131*	40800130*	40800129*

Grinding surfaces for fine grinding

Name	Disc dia. 350 mm (14")	Disc dia. 300 mm (12")	Disc dia. 250 mm (10")	Disc dia. 200 mm (8")
MD-Piano 500	40800136*	40800135*	40800134*	40800133*
MD-Piano 1200	40800140*	40800139*	40800138*	40800137*
MD-Piano 2000	40800144*	40800143*	40800142*	40800141*
MD-Piano 4000	40800148*	40800147*	40800146*	40800145*
MD-Allegro	40500140	40500067 40500136*	40500066 40500135*	40500065 40500134*
MD-Largo	40500141	40500099 40500139*	40500098 40500138*	40500097 40500137*

Polishing cloths

Name	Disc dia. 350 mm (14")	Disc dia. 300 mm (12")	Disc dia. 250 mm (10")	Disc dia. 200 mm (8")
MD-Plan	40500147	40500088	40500087	40500086
MD-Pan	40500160	40500159	40500158	40500157
MD-Sat		40500408	40500407	40500406
MD-Dur	40500149	40500076	40500075	40500074
MD-Dac	40500150	40500073	40500095	40500071
MD-Mol	40500152	40500079	40500078	40500077
MD-Mol APS	40500156	40500155		
MD-Plus	40500151	40500091	40500090	40500089
MD-Floc		40500405	40500404	40500403
MD-Nap	40500153	40500082	40500081	40500080
MD-Chem	40500154	40500094	40500093	40500092
MD-Chem NonStick		40500410		

Other consumables

Name	Application	Disc dia. 350 mm (14")	Disc dia. 300 mm (12")	Disc dia. 250 mm (10")	Disc dia. 200 mm (8")
MD-Gekko	Adapter disc for use with SiC-Foil	49900050	49900049	49900048	49900047
MD-Rondo	Adapter disc for use with self-adhesive polishing cloths	40503082	40503002	40503001	40503000
Magnetic Foil	Self-adhesive magnetic Foil		40800115*	40800114*	40800113*

Storage

Name		
MD-Concert	Storage cabinet for 9 MD consumables in 200/8", 250/10" and 300 mm/12"	05306101
MD-Concertino	Storage cabinet for 7 MD consumables in 200 mm (8") dia.	05306102
Storage cabinet	Storage cabinet for 10 MD consumables in 350 mm (14") dia.	05666001

* 1 pc. package (MD-Gekko: 2 pcs. Others: 5 pcs.)

Struers' products are subject to constant product development. Therefore, we reserve the right to introduce changes in our products without notice.



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