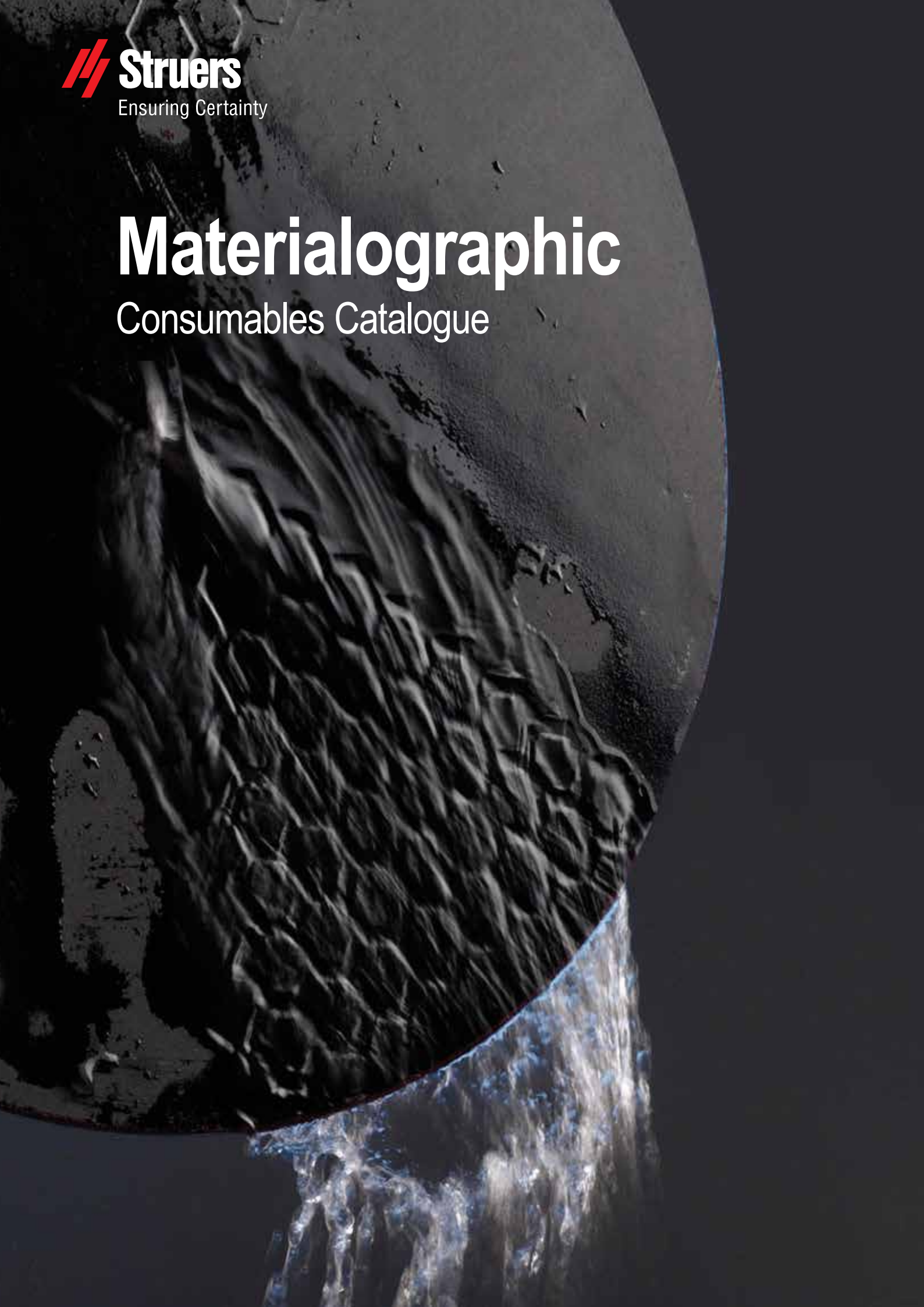
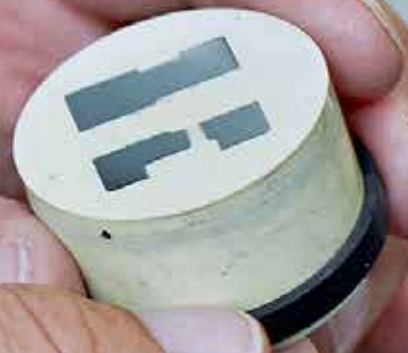


Materialographic

Consumables Catalogue



THE ULTIMATE IN QUALITY CONTROL



WELCOME

At Struers, we have been setting standards in quality control since 1875. Today, we are the world's leading manufacturer of equipment, consumables and services for materialographic surface preparation and analysis of solid materials.

As the world's leading expert in materialographic solutions, we develop and deliver the high quality equipment and consumables that you rely on to do your job. We also provide expert consultancy and training to companies across the globe. Whether you need to improve the efficiency and repeatability of your quality testing, speed up your testing processes, design new workflows or just upgrade your equipment – we are here to help.

Whenever we work with you, our goal is always the same: to help you discover new opportunities. We help you obtain true and consistent preparation and testing results, so you know your products live up to your exacting standards. We call this ensuring certainty – and it is why we are the supplier of choice for thousands of quality testing professionals worldwide.

As a Struers customer, you get access to our unique knowledge base, global service, applications support and training courses by world-leading specialists. In short, everything you need to ensure certainty in your quality testing processes.



Offices and affiliates in **24** countries worldwide



Representation in more than **50** countries worldwide



More than **140** years of experience



Offering **12** training labs worldwide



An elite team of **27** global application specialists



Quality and Environmental Management

To meet our customers' high expectations, it is important to have high international standards. We are constantly increasing and improving our commitment in everything we do, and by having our business processes certified to ISO standards you can always have confidence that our products are reliable and of good quality.

Struers' management system is certified according to the ISO 9001:2015 standard, enabling us to demonstrate our ability to provide products that consistently meet customer and applicable regulatory requirements.

Struers' management system is also certified according to the ISO 14001:2015 standard to confirm our commitment, care, and concern for minimizing the environmental impact of our daily operations.



ISO 9001:2015
ISO 14001: 2015



Manual Quality Control

To be the leading global supplier of materialographic solutions, we strive to meet your expectations of high quality to ensure that you achieve accurate results in your own sample preparation processes. We have our very own team, based in our headquarters in Denmark, who visually control and assess all polishing cloths manually before being packed and distributed. Before the manually quality control is performed, all raw materials have been controlled before being released for production. Furthermore, our quality control team are manually mixing and producing all Struers Diamond suspensions.

All the processes and procedures are documented and described in our ISO system and LEAN standards. This ensures a consistent quality of Struers consumables and serve as your guarantee to obtain the best possible results in your line of work.

Minimizing Our Transportation Carbon Footprint

As an important part of the ISO 14001, we are working on minimizing our environmental footprint when it comes to shipping consumables and equipment. We are striving to achieve the highest possible ratio between sea and air freight to overseas subsidiaries, and our global goal for 2020 is an 80% ratio on sea freight of all consumables.

We are constantly examining every freight setup and calculating how to reduce it to minimize our environmental footprint and, at the same time, further reducing delivery time. In 2020, we are working on a new distribution set-up where we increase the percentage of Equipment send by sea to overseas destinations based on customer needs.



Fast Delivery of Your Consumables

We understand that uptime is important to your business, which is why we constantly strive for fast and reliable delivery of your consumables. With our efficient global setup, we ensure quick and efficient delivery of your consumables.

We ship consumable orders **within 48 hours** **98%** of the time.

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Cutting

Perfect materialographic cutting requires precision without overheating or material deformation, usually combined with speed. Therefore, Struers machines and consumables are designed to work together to control all parameters of the cutting process, such as cooling, rotational speed and feed speed. This way, you get the most out of your investment.

Intelligent cut-off wheels

Struers cut-off wheels have a built-in compensation to changing wear characteristics throughout its life. The abrasive density of our wheels varies across the wheel radius, with increasing density toward the centre. This results in more constant wear characteristics, which can be converted into less wear and improved control of the cut.

Hexagonal 3D cut-off wheels

Struers 3D cut-off wheels have a unique, patented hexagonal surface. The surface of the wheels contribute to a more efficient cooling and helps eliminate cutting debris build-up. This results in lower heat damage and less time for cleaning.

Struers consumables are designed to get the most out of your Struers equipment.

Selection Guide for Cut-off Wheels



Selection Guide for Cut-off Wheels

Struers offers the markets' most comprehensive ranges of purpose-designed cut-off wheels for materialographic sectioning. Struers cut-off wheels are thoroughly tested and optimized for use on Struers cut-off machines. The cut-off wheels are also applicable for other machines in the market with similar specifications. If you have doubts about compatibility with your machine, please contact Struers.

How to select the correct cut-off wheel:

Struers offers a wide variety of wheels, which means that you can select the hardness that optimally balances durability with finish.

If the hardness of the material is known, use the table at the top of the page. In the table at the bottom, you will then find the cut-off wheel codes for the specific cutting machines. If the hardness of the material is not known, find a suitable cut-off wheel according to material group in the table below.

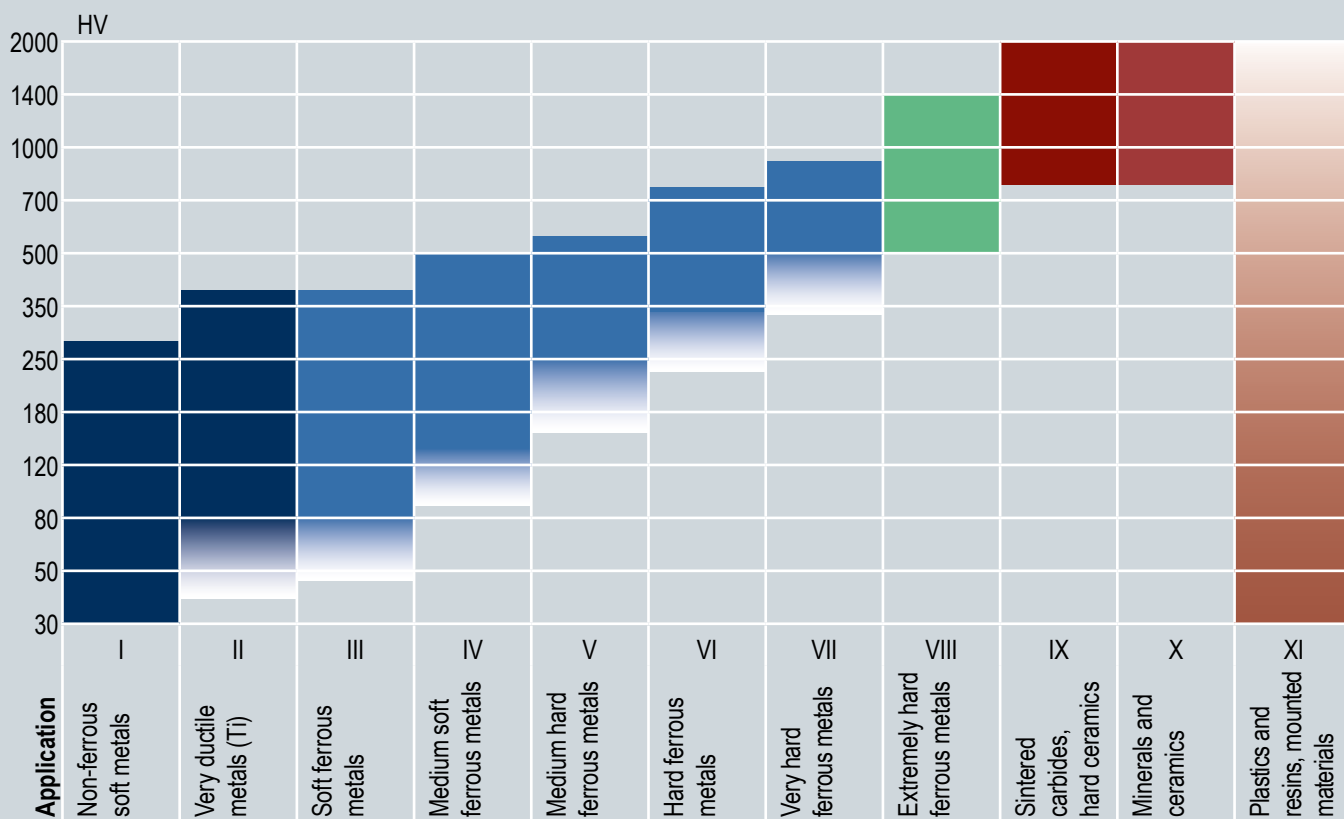
1. Go upwards on the y-axis of the overview to the right until you find the hardness value of your material.
2. Move to the right, until you cross the material group that fits your application. If you only have one material to cut, find the wheel where your material's hardness is placed as close to the middle of the interval as possible. For two or more materials, see if you can find a wheel that covers the whole hardness range. For workpieces with smaller or larger diameters, it may improve the result to choose a material group one step to the left, respectively to the right of the initial selection.
3. Find the number (I-XI) of the material group, and see the table below for the code of the correct wheel for your cut-off machine.

	Abrasive	Bond
	SiC	Bakelite
	Al ₂ O ₃	Bakelite
	CBN	Bakelite
	Diamond	Bakelite <i>Hard and ductile materials</i>
	Diamond	Metal <i>Hard and brittle materials</i>
	Diamond	Metal electroplated <i>Mounted materials, predominately resin</i>

Cut-off machine	Std. wheel size*
Magnutom-500/-5000	508 x 3.5 x 32
Exotom-100/-150 Magnutom-400/-500/-5000	432 x 3.0 x 32
Axitom-5/400	400 x 3.0 x 32
Axitom-5	350 x 2.5 x 32
Labotom-15	
Exotom/Unitom-2/-5/-50	
Unitom/Discotom-50/-60/-65/-100	300 x 2.0 x 32
Discotom-5/-6/-10/Labotom-3/-5	250 x 1.5 x 32
Discotom/Labotom	235 x 1.5 x 22
Discoplan-TS	200 x 1.0 x 22
1) 406 x 1.8 x 32 2) 350 x 1.5 x 32 3) 356 x 1.5 x 32	
11) For hard and ductile materials, Ni-base alloys	

Precision cut-off machine	Std. wheel size*
Secotom-1/-10/-15/-50-6/-20/-60**	200 x 0.8 x 22
Accutom-10/-100/-5/-50	150 x 0.5 x 12.7
Accutom-2	125 x 0.5 x 12.7
Minitom	125 x 0.5 x 12.7
Wheels with special sizes	100 x 0.3 x 12.7
	75 x 0.15 x 12.7

*) Diameter x Width x Bore in mm.



CUTTING

MOUNTING

GRINDING

POLISHING

SPECIAL APPLICATIONS

ACCESSORIES

TEST BLOCKS

10S51			30A51	40A51 42A51 ¹⁰	50A51 52A51 ¹⁰	60A51 62A51 ¹⁰	B0C41 ¹	B0D51 ¹⁷	M0D51 ¹⁶	E0D36 ³
10S43	20S43		30A43	40A43 42A43 ¹⁰	50A43 52A43 ¹⁰ 58A43 ¹⁸	60A43 62A43 ¹⁰ 66A43 ¹² 68A43 ¹⁸	B0C41 ¹	B0D35 ²	M0D35 ²	E0D36 ³
10S35	20S35	X20A400C	X30A400C	X40A400C	X50A400C X58A400C	X60A400C X68A400C	B0C41 ¹	B0D35 ²	M0D35 ²	E0D36 ³
10S35	20S35	20A35	20A35	30A35	40A35	50A35 56A35 ¹² 58A35 ¹⁸	B0C35 ⁶	B0D35 ² B7D35 ^{2/15}	M0D35 ²	E0D36 ³
10S35	20S35	30A35	40A35	50A35 56A35 ¹²	60A35 66A35 ¹²	60A35 66A35 ¹²	B0C35 ⁶	B0D35 ² B7D35 ^{2/15}	M0D35 ²	E0D36 ³
10S35	30S35	20A35	30A35	40A35	50A35 56A35 ¹² 58A35 ¹⁸	60A35 66A35 ¹² 68A43 ¹⁸	B0C35 ⁶	B0D35 ² B7D35 ^{2/15}	M0D35 ²	E0D36 ³
10S30	20S30		30A30	40A30	50A30	60A30 66A30 ¹²	B0C31 ⁴	B0D31 ⁴	M0D31 ⁵	E0D30 ⁵
10S25	20S25	20A25	30A25 33A25 ⁹	40A25 46A25 ¹²	54A25 50A25 ¹¹ 56A25 ¹²	60A25 66A25 ¹²	B0C25 ⁷	B0D25 ⁸	M0D25 ⁸	E0D25
10S24	20S24		30A24	40A24	50A24	60A24		B4D20	M4D20	

4) 305 x 1.8 x 32 5) 305 x 1.5 x 32 6) 350 x 1.8 x 32 7) Width = 1.3 8) Width = 1.1 9) Width = 0.8 10) Fibreglass reinforced
 12) 3D cut-off wheels 13) Width=0.6 14) Width=0.4 15) For sintered carbides in steel 16) Width = 2.4 17) Width = 3.2 18) Premium cut-off wheels

10S20	10S20	30A20	30A20	50A20	50A20	50A20	B0C20	B0D20	M0D20 ¹³ M1D20 ¹³	E1D20
10S15	10S15	40A15 30A15	40A15 30A15	50A15	50A15	50A15	B0C15	B0D15	M0D15 M1D15	E0D15
30A13	30A13	30A13	30A13	50A13	50A13	50A13	B0C13	B0D13 ¹³	M0D13 ¹⁴ M1D13 ¹⁴	M1D13 ¹⁴
M1D13 ¹⁴	M1D13 ¹⁴	B0C13 ¹³	B0C13 ¹³	B0C13 ¹³	B0C13 ¹³	B0C13 ¹³	B0C13 ¹³	B0D13 ¹³	M0D13 ¹⁴ M1D13 ¹⁴	M1D13 ¹⁴
These wheels can be used on both Accutom-2/-5/-50 and Secotom-1/-10/-15/-50-6/-20/-60 for cutting of small specimens where high precision or minimum material loss is required.									M0D10 M1D10	M1D10
									M0D08 M1D08	M1D08

**) On Secotom-1 only use MOD20 + B0D20



68A43 - Premium Cut-off Wheel



52A51 - Abrasive Cut-off Wheel



350 mm Abrasive Cut-off Wheels

Cutting

508 mm Abrasive Cut-off Wheels

40009160	<p>Cut-off wheel 10S51 For cutting soft, non-ferrous materials (HV 30-300). Silicon carbide. Resin bond. 508 mm (20") dia. x 3.5 mm x 32 mm dia., 3 pcs.</p>
40009161	<p>Cut-off wheel 30A51 For cutting of medium soft ferrous metals (<HV 300). Aluminum oxide. Resin bond. 508 mm (20") dia. x 3.5 mm x 32 mm dia., 3 pcs.</p>
40009162	<p>Cut-off wheel 40A51 For cutting of medium hard ferrous metals (HV 200 - 500), stainless steel and softer ferrous metals with diameters above 150 mm. Aluminum oxide. Resin bond. 508 mm (20") dia. x 3.5 mm x 32 mm dia., 3 pcs.</p>
40009163	<p>Cut-off wheel 42A51 For cutting of medium hard ferrous metals (HV 200-500), stainless steel and softer ferrous metals with diameters above 150 mm. Aluminum oxide. Resin bond. Fibre reinforced 508 mm (20") dia. x 3.5 mm x 32 mm dia., 3 pcs.</p>
40009164	<p>Cut-off wheel 50A51 For cutting of hard ferrous metals (HV 450 - 600). Aluminum oxide. Resin bond. 508 mm (20") dia. x 3.5 mm x 32 mm dia., 3 pcs.</p>
40009165	<p>Cut-off wheel 52A51 For cutting of hard ferrous metals (HV 450 - 600). Aluminum oxide. Resin bond. Fibre reinforced 508 mm (20") dia. x 3.5 mm x 32 mm dia., 3 pcs.</p>
40009166	<p>Cut-off wheel 60A51 For cutting of extra hard ferrous metals (>HV 600). Aluminum oxide. Resin bond. 508 mm dia. x 3.5 mm x 32 mm dia. 3 pcs.</p>
40009167	<p>Cut-off wheel 62A51 For cutting of very hard ferrous metals (> HV 600). Aluminum oxide. Resin bond. Fibre reinforced 508 mm (20") dia. x 3.5 mm x 32 mm dia., 3 pcs.</p>

432 mm Abrasive Cut-off Wheels

40009150	<p>Cut-off Wheel 10S43 For cutting of soft, non-ferrous metals (HV 30 - 300). Silicon carbide. Resin bond. 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009170	<p>Cut-off Wheel 20S43 For cutting of very ductile metals (e.g. titanium) (HV 70 - 400). Silicon carbide. Resin bond. 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009151	<p>Cut-off Wheel 30A43 For cutting of medium soft ferrous metals (< HV 300) and for general applications. Aluminum oxide. Resin bond. 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>

432 mm Abrasive Cut-off Wheels

40009152	<p>Cut-off Wheel 40A43 For cutting of medium hard ferrous metals (HV 200 - 500), stainless steel and general applications. Aluminum oxide. Resin bond. 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009158	<p>Cut-off Wheel 42A43 For cutting of case hardened and medium hard ferrous metals (HV 200 - 700), and for stainless steel. Fibre-reinforced. Aluminum oxide. Resin bond. 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009153	<p>Cut-off Wheel 50A43 For cutting of hard ferrous metals (HV 450 - 600). Aluminum oxide. Resin bond. 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009154	<p>Cut-off Wheel 52A43 For cutting of hard ferrous metals (HV 450 - 600). Fibre-reinforced. Aluminum oxide. Resin bond. 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009174	<p>Cut-off wheel, Premium 58A43 For high volume cutting of hard ferrous metals (HV 450-600). With spiral pattern. Aluminum oxide. Resin bond. 432 mm (17") dia. x 2.7 mm x 32 mm dia. 5 pcs.</p>
40009155	<p>Cut-off Wheel 60A43 For cutting of extra hard ferrous metals (> HV 600). Aluminum oxide. Resin bond. 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009156	<p>Cut-off Wheel 62A43 For cutting of extra hard ferrous metals (> HV 600). Fibre-reinforced. Aluminum oxide. Resin bond 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009159	<p>Cut-off Wheel, Hexagonal 66A43 For cutting of extra hard ferrous metals (>HV 600). With 3D hexagon pattern. Aluminum oxide. Resin bond. 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009175	<p>Cut-off wheel, Premium 68A43 For high volume cutting of very hard ferrous metals (HV >600). With spiral pattern. Aluminum oxide. Resin bond. 432 mm (17") dia. x 2.7 mm x 32 mm dia. 5 pcs.</p>

350 mm Abrasive Cut-off Wheels

40009120	<p>Cut-off Wheel 10S35 For cutting of soft, non-ferrous metals (HV 30 - 300) on Unitom (2.775 rpm), Axitom (1.950 rpm) and Labotom-15 (2.350 rpm). Silicon carbide. Resin bond. 350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.</p>
40009121	<p>Cut-off Wheel 20S35 For cutting of very ductile metals (e.g. titanium) (HV 70 - 400) on Axitom (1.950 rpm) and Labotom-15 (2.350 rpm). Silicon carbide. Resin bond. 350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.</p>
40009122	<p>Cut-off Wheel 30S35 For cutting of very ductile metals (e.g. titanium) (HV 70 - 400) on Unitom (2.775 rpm). Silicon carbide. Resin bond. 350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.</p>

350 mm Abrasive Cut-off Wheels

40009123

Cut-off Wheel 20A35

For cutting of soft ferrous metals, steel tubes and small pieces (HV 80 - 400) on Unitom (2.775 rpm) and Axitom (1.950 rpm), and for cutting of medium soft ferrous metals (<HV 300) and for general applications on Axitom (1.950 rpm). Aluminum oxide. Resin bond

350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.

40009124

Cut-off Wheel 30A35

For cutting of soft ferrous metals, steel tubes and small pieces (HV 80 - 400) on Labotom-15 (2.350 rpm). For cutting of medium soft ferrous metals (<HV 300) on Unitom (2.775 rpm). For cutting of medium hard ferrous metals (HV 200 - 500) and stainless steel on Axitom (1.950 rpm). Aluminum oxide. Resin bond.

350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.

40009125

Cut-off Wheel 40A35

For cutting of medium soft ferrous metals (<HV 300) on Labotom-15 (2.350 rpm). For cutting of medium hard ferrous metals (HV 200 - 500) and stainless steel on Unitom (2.775 rpm). For cutting of hard ferrous metals (HV 300 - 700) on Axitom (1.950 rpm). Aluminum oxide. Resin bond.

350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.

40009126

Cut-off Wheel 50A35

For cutting of medium hard ferrous metals (HV 200 - 500) and stainless steel on Labotom-15 (2.350 rpm). For cutting of hard ferrous metals (HV 300 - 700) on Unitom (2.775 rpm). For cutting of very hard ferrous metals (HV 400 - 800) on Axitom (1.950 rpm). Aluminum oxide. Resin bond.

350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.

40009168

Cut-off wheel 55A35

For cutting of hard ferrous metals (HV 300 - 700) on Unitom (2.775 rpm) and for cutting of extra hard ferrous metals (HV 400 - 800) on Axitom (1.950 rpm). Special cut-off wheel for cutting of 3 mm wide slots. Aluminum oxide. Resin bond.

350 mm (14") dia. x 3,0 mm x 32 mm dia. 8 pcs.

40009127

Cut-off Wheel, Hexagonal 56A35

For cutting of medium hard ferrous metals (HV 200 - 500) and stainless steel on Labotom-15 (2.350 rpm). For cutting of hard ferrous metals (HV 300 - 700) on Unitom (2.775 rpm). For cutting of very hard ferrous metals (HV 400 - 800) on Axitom (1.950 rpm). With 3-D hexagon pattern. Aluminum oxide. Resin bond.

350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.

40009172

Cut-off wheel, Premium 58A35

For cutting of hard ferrous metals (HV 300 - 700) on Unitom (2.775 rpm). For cutting of very hard ferrous metals (HV 400 - 800) on Axitom (1.950 rpm). Suitable for high volume cutting. With spiral pattern. Aluminum oxide. Resin bond.

350 mm (14") dia. x 2.2 mm x 32 mm dia. 10 pcs.

40009128

Cut-off Wheel 60A35

For manual cutting of hard and very hard ferrous metals (HV 300 - 800) on Labotom-15 (2.350 rpm). For cutting of very hard ferrous metals (HV 400 - 800) on Unitom (2.775 rpm). Aluminum oxide. Resin bond.

350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.

40009129

Cut-off Wheel, Hexagonal 66A35

For manual cutting of hard and very hard ferrous metals (HV 300 - 800) on Labotom-15 (2.350 rpm). For cutting of very hard ferrous metals (HV 400 - 800) on Unitom (2.775 rpm). With 3-D hexagon pattern. Aluminum oxide. Resin bond.

350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.

40009173

Cut-off wheel, Premium 68A35

For cutting of very hard ferrous metals (HV 400 - 800) on Unitom (2.775 rpm) and Labotom-15 (2,350 rpm). Suitable for high volume cutting. With spiral pattern. Aluminum oxide. Resin bond.

350 mm (14") dia. x 2.2 mm x 32 mm dia. 10 pcs.

300 mm Abrasive Cut-off Wheels

40009140	Cut-off Wheel 10S30 For cutting of soft, non-ferrous metals (HV 30 - 300). Silicon carbide. Resin bond. 300 mm (12") dia. x 2.0 mm x 32 mm dia. 10 pcs.
40009141	Cut-off Wheel 20S30 For cutting of very ductile metals (e.g. titanium) (HV 70 - 400). Silicon carbide. Resin bond. 300 mm (12") dia. x 2.0 mm x 32 mm dia. 10 pcs.
40009142	Cut-off Wheel 30A30 For cutting of medium soft ferrous metals (<HV 300) and for general applications. Aluminum oxide. Resin bond 300 mm (12") dia. x 2.0 mm x 32 mm dia. 10 pcs.
40009143	Cut-off Wheel 40A30 For cutting of medium hard ferrous metals (HV 200 - 500), stainless steel and general applications. Aluminum oxide. Resin bond. 300 mm (12") dia. x 2.0 mm x 32 mm dia. 10 pcs.
40009144	Cut-off Wheel 50A30 For cutting of hard ferrous metals (HV 450 - 600) and for softer ferrous metals with diameters above 60 mm. Aluminum oxide. Resin bond. 300 mm (12") dia. x 2.0 mm x 32 mm dia. 10 pcs.
40009145	Cut-off Wheel 60A30 For cutting of extra hard ferrous metals (>HV 600). Aluminum oxide. Resin bond 300 mm (12") dia. x 2.0 mm x 32 mm dia. 10 pcs.
40009146	Cut-off Wheel, Hexagonal 66A30 For cutting of extra hard ferrous metals (>HV 600). With 3D hexagon pattern. Aluminum oxide. Resin bond. 300 mm (12") dia. x 2.0 mm x 32 mm dia. 10 pcs.

250 mm Abrasive Cut-off Wheels

40009101	Cut-off Wheel 10S25 For cutting of soft, non-ferrous metals (HV 30 - 300). Silicon carbide. Resin bond. 250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.
40009102	Cut-off Wheel 20S25 For cutting of very ductile metals (e.g. titanium) (HV 70 - 400). Silicon carbide. Resin bond. 250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.
40009103	Cut-off Wheel 20A25 For cutting of soft ferrous metals, steel tubes and small pieces (HV 80 - 400). Aluminum oxide. Resin bond. 250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.
40009104	Cut-off Wheel 30A25 For cutting of medium soft ferrous metals (<HV 300) and for general applications. Aluminum oxide. Resin bond. 250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.
40009105	Cut-off Wheel 33A25 Thin (0.8 mm) cut-off wheel for delicate cutting of medium soft ferrous metals (<HV 300). Aluminum oxide. Resin bond. 250 mm (10") dia. x 0.8 mm x 32 mm dia. 10 pcs.
40009106	Cut-off Wheel 40A25 For cutting of medium hard ferrous metals (HV 200 - 500), stainless steel and general applications. Aluminum oxide. Resin bond. 250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.

250 mm Abrasive Cut-off Wheels

40009107	<p>Cut-off Wheel Hexagonal 46A25 For cutting of medium hard ferrous metals (HV 200 - 500), stainless steel and general applications. With 3D hexagon pattern. Aluminum oxide. Resin bond.</p> <p>250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.</p>
40009108	<p>Cut-off Wheel 50A25 For cutting of hard and ductile ferrous metals and Ni-based alloys (HV 450 - 600). Aluminum oxide. Resin bond.</p> <p>250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.</p>
40009112	<p>Cut-off Wheel 54A25 For cutting of hard ferrous metals (HV 450 – 600) and for softer ferrous metals with diameters above 50 mm (2"). Well suited for manual cutting. Aluminum oxide. Resin bond.</p> <p>250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.</p>
40009109	<p>Cut-off Wheel, Hexagonal 56A25 For cutting of hard ferrous metals (HV 450 - 600) and for softer ferrous metals with diameters above 50 mm (2"). With 3D hexagon pattern. Aluminum oxide. Resin bond.</p> <p>250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.</p>
40009110	<p>Cut-off Wheel 60A25 For cutting of extra hard ferrous metals (>HV 600). Aluminum oxide. Resin bond.</p> <p>250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.</p>
40009111	<p>Cut-off Wheel, Hexagonal 66A25 For cutting of extra hard ferrous metals (>HV 600). With 3D hexagon pattern. Aluminum oxide. Resin bond.</p> <p>250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.</p>

235 mm Abrasive Cut-off Wheels

40009134	<p>Cut-off Wheel 10S24 For cutting of soft, non-ferrous metals (HV 30 - 300). Silicon carbide. Resin bond.</p> <p>235 mm (9") dia. x 1.5 mm x 22 mm dia. 10 pcs.</p>
40009135	<p>Cut-off Wheel 20S24 For cutting of very ductile metals (e.g. titanium) (HV 70 - 400). Silicon carbide. Resin bond.</p> <p>235 mm (9") dia. x 1.5 mm x 22 mm dia. 10 pcs.</p>
40009133	<p>Cut-off Wheel 30A24 For cutting of medium soft ferrous metals (<HV 300) and for general applications. Aluminum oxide. Resin bond.</p> <p>235 mm (9") dia. x 1.5 mm x 22 mm dia. 10 pcs.</p>
40009132	<p>Cut-off Wheel 40A24 For cutting of medium hard ferrous metals (HV 200 - 500), stainless steel and general applications. Aluminum oxide. Resin bond.</p> <p>235 mm (9") dia. x 1.5 mm x 22 mm dia. 10 pcs.</p>
40009131	<p>Cut-off Wheel 50A24 For cutting of hard ferrous metals (HV 450 - 600) and for softer ferrous metals with diameters above 50 mm (2"). Aluminum oxide. Resin bond.</p> <p>235 mm (9") dia. x 1.5 mm x 22 mm dia. 10 pcs.</p>
40009130	<p>Cut-off Wheel 60A24 For cutting of extra hard ferrous metals (>HV 600). Aluminum oxide. Resin bond.</p> <p>235 mm (9") dia. x 1.5 mm x 22 mm dia. 10 pcs.</p>



Cut-off Wheels

200 mm Abrasive Cut-off Wheels

4000092	<p>Cut-off Wheel 10S20 For cutting of soft non-ferrous metals (HV 70 - 400). For Secotom-10/-15/-50. SiC. Resin bond. 200 mm (8") dia. x 0.8 mm x 22 mm dia. 5 pcs.</p>
4000087	<p>Cut-off Wheel 30A20 For cutting of medium hard ferrous metals (< HV 500). For Secotom-10/-15/-50. Aluminum oxide. Resin bond. 200 mm (8") dia. x 0.8 mm x 22 mm dia. 5 pcs.</p>
4000086	<p>Cut-off Wheel 50A20 For cutting of hard ferrous metals (> HV 500). For Secotom-10/-15/-50. Aluminum oxide. Resin bond. 200 mm (8") dia. x 0.8 mm x 22 mm dia. 5 pcs.</p>

<200mm Abrasive Cut-off Wheels

40000103	<p>Cut-off Wheel 10S15 For cutting of soft non-ferrous metals (HV 30 - 400). For Secotom-10/-15/-50, Accutom-100/-10/-50/-5/-2. Silicon Carbide. Resin bond. 150 mm (6") dia. x 0.5 mm x 12.7 mm dia. 5 pcs.</p>
40000102	<p>Cut-off Wheel 30A15 For cutting of medium soft ferrous metals (<HV 300) and for general applications. For Secotom-10/-15/-50, Accutom-100/-10/-50/-5/-2. Aluminum oxide. Resin bond. 150 mm (6") dia. x 0.5 mm x 12.7 mm dia. 5 pcs.</p>
40000101	<p>Cut-off Wheel 40A15 For cutting of medium hard ferrous metals (HV 200 - 500), stainless steel and general applications. For Secotom-10/-15/-50, Accutom-100/-10/-50/-5/-2. Aluminum oxide. Resin bond. 150 mm (6") dia. x 0.5 mm x 12.7 mm dia. 5 pcs.</p>
40000100	<p>Cut-off Wheel 50A15 For cutting of hard ferrous metals (HV 500 - 800) and for specimens with relatively large dimensions. For Secotom-10/-15/-50, Accutom-100/-10/-50/-5/-2. Aluminum oxide. Resin bond. 150 mm (6") dia. x 0.5 mm x 12.7 mm dia. 5 pcs.</p>
40000045	<p>Cut-off Wheel 30A13 For cutting of medium hard ferrous metals (< HV 500). For Secotom-10/-15/-50, Accutom-100/-10/-50/-5, Accutom-2 and Accutom. Aluminum oxide. Resin bond. 125 mm (5") dia. x 0.5 mm x 12.7 mm dia. 5 pcs.</p>
40000044	<p>Cut-off Wheel 50A13 For cutting of hard ferrous metals (> HV 500). For Secotom-10/-15/-50, Accutom-100/-10/-50/-5, Accutom-2 and Accutom. Aluminum oxide. Resin bond. 125 mm (5") dia. x 0.5 mm x 12.7 mm dia. 5 pcs.</p>

Dia./CBN Cut-off Wheels

40000094	<p>Diamond Cut-off Wheel B0D51 For cutting of sintered carbides and ceramics (> HV 800). Resin bond. 508 mm dia. x 2.7 mm x 32 mm dia.</p>
40000095	<p>Diamond Cut-off Wheel M0D51 For cutting of ceramics (> HV 800) and minerals. Metal bond, high concentration. 508 mm (20") dia. x 3.2 mm x 32 mm dia.</p>
40000096	<p>CBN Cut-off Wheel B0C50 For cutting of extremely hard ferrous metals (HV 500 - 1400). Resin bond, high concentration 500 mm (19.7") dia. x 2.3 mm x 32 mm dia.</p>
40000077	<p>Diamond Cut-off Wheel M0D35 For cutting of ceramics (> HV 800) and minerals. Metal bond, high concentration. 350 mm (14") dia. x 1.5 mm x 32 mm dia.</p>
40000036	<p>Diamond Cut-off Wheel B0D35 For cutting of sintered carbides and ceramics (> HV 800). Resin bond. 350 mm (14") dia. x 1.5 mm x 32 mm dia.</p>
40000093	<p>Diamond Cut-off Wheel B7D35 For cutting of drilling tools containing steel and sintered carbides. Resin bond. 350 mm (14") dia. x 1.8 mm x 32 mm dia.</p>
40000082	<p>Diamond Cut-off Wheel E0D36 For cutting of mounted samples and components containing resin or plastic. Electroplated. 356 mm (14") dia. x 1.5 mm x 32 mm dia.</p>
40000075	<p>Diamond Cut-off Wheel M0D31 For cutting of ceramics (> HV 800) and minerals. Metal bond, high concentration. 305 mm (12") dia. x 1.5 mm x 32 mm dia.</p>
40000035	<p>Diamond Cut-off Wheel B0D31 For cutting of sintered carbides and ceramics (> HV 800). Resin bond 305 mm (12") dia. x 1.8 mm x 32 mm dia.</p>
40000081	<p>Diamond Cut-off Wheel E0D30 For cutting of mounted samples and components containing resin or plastic. Electroplated. 300 mm (12") dia. x 1.5 mm x 32 mm dia.</p>
40000034	<p>Diamond Cut-off Wheel M0D25 For cutting of ceramics (> HV 800) and minerals. Metal bond, high concentration. 250 mm (10") dia. x 1.1 mm x 32 mm dia.</p>
40000033	<p>Diamond Cut-off Wheel B0D25 For cutting of sintered carbides and ceramics (> HV 800). Resin bond. 254 mm (10") dia. x 1.1 mm x 32 mm dia.</p>
40000080	<p>Diamond Cut-off Wheel E0D25 For cutting of mounted samples and components containing resin or plastic. Electroplated 250 mm (10") dia. x 1.5 mm x 32 mm dia.</p>
40000079	<p>CBN Cut-off Wheel B0C41 For cutting of extremely hard ferrous metals (HV 500 - 1400). Resin bond, high concentration. 406 mm (16") dia. x 1.8 mm x 32 mm dia.</p>
40000078	<p>CBN Cut-off Wheel B0C35 For cutting of extremely hard ferrous metals (HV 500 - 1400). Resin bond, high concentration. 350 mm (14") dia. x 1.8 mm x 32 mm dia.</p>
40000076	<p>CBN Cut-off Wheel B0C31 For cutting of extremely hard ferrous metals (HV 500 - 1400). Resin bond, high concentration. 305 mm (12") dia. x 1.8 mm x 32 mm dia.</p>

Dia./CBN Cut-off Wheels

40000018	CBN Cut-off Wheel B0C25 For cutting of extremely hard ferrous metals (HV 500 - 1400). Resin bond, high concentration. 252 mm (10") dia. x 1.3 mm x 32 mm dia.
40000029	Diamond Cut-off Wheel M4D20 For manual cutting of minerals and composites with hard phases. For Discoplan-TS, manual cutting table on Secotom-10 or Secotom-1. Metal bond, high concentration. 202 mm (8") dia. x 1.0 mm x 22 mm dia.
40000032	Diamond Cut-off Wheel B4D20 For manual cutting of sintered carbides and ceramics (> HV 800). For Discoplan-TS. Resin bond. 202 mm (8") dia. x 1.1 mm x 22 mm dia.



Diamond precision Cut-off Wheels

Dia./CBN prec. Cut-off Wheels

40000084	Diamond Cut-off Wheel M0D20 For cutting of ceramics and minerals (> HV 800). Can be used with manual cutting table. For Secotom-1/-10/-15/-50. Metal bond, high concentration. 203 mm (8") dia. x 0.6 mm x 22 mm dia.
40000072	Diamond Cut-off Wheel M1D20 For cutting of hard and brittle materials. Can be used with manual cutting table. For Secotom-1/-10/-15/-50. Metal bond, low concentration. 203 mm (8") dia. x 0.6 mm x 22 mm dia.
40000083	Diamond Cut-off Wheel B0D20 For cutting of sintered carbides and ceramics (> HV 800). For Secotom-1/-10/-15/-50. Resin bond. 203 mm (8") dia. x 0.9 mm x 22 mm dia.
40000090	Diamond Cut-off Wheel E1D20 For cutting of mounted samples and components containing resin or plastic. For Secotom-1/-10/-15/-50. Electroplated, single-layer. 200 mm (8") dia. x 0.8 mm x 22 mm dia.
40000046	Diamond Cut-off Wheel M4D18 For manual cutting of minerals and composites with hard phases. For Accutom-2 and Accutom with manual cutting table. Metal bond, high concentration. 176 mm (7") dia. x 0.8 mm x 12.7 mm dia.
40000054	Diamond Cut-off Wheel M0D15 For cutting of ceramics and minerals (> HV 800). For Secotom-10/-15/-50, Accutom-100/-10 and Accutom-50/-5. Metal bond, high concentration 152 mm (6") dia. x 0.4 mm x 12.7 mm dia.
40000068	Diamond Cut-off Wheel M1D15 For cutting of hard and brittle materials. For Secotom-10/-15/-50, Accutom-100/-10 and Accutom-50/-5. Metal bond, low concentration. 152 mm (6") dia. x 0.4 mm x 12.7 mm dia.

Dia./CBN prec. Cut-off Wheels

40000055	<p>Diamond Cut-off Wheel B0D15 For cutting of sintered carbides and ceramics (> HV 800). For Secotom-10/-15/-50, Accutom-100/-10 and Accutom-50/-5. Resin bond. 152 mm (6") dia. x 0.8 mm x 12.7 mm dia.</p>
40000089	<p>Diamond Cut-off Wheel E0D15 For cutting of mounted samples and components containing resin or plastic. For Secotom-10/-15/-50, Accutom-100/-10 and Accutom-50/-5. Electroplated, multi-layer. 150 mm (6") dia. x 0.4 mm x 12.7 mm dia.</p>
40000038	<p>Diamond Cut-off Wheel M0D13 For cutting of ceramics and minerals (> HV 800). For Secotom-10/-15/-50, Accutom-100/-10, Accutom-50/-5, Accutom-2, Accutom and Minitom. Metal bond, high concentration. 127 mm (5") dia. x 0.4 mm x 12.7 mm dia.</p>
40000071	<p>Diamond Cut-off Wheel M1D13 For cutting of hard and brittle materials. For Secotom-10/-15/-50, Accutom-100/-10, Accutom-50/-5, Accutom-2, Accutom and Minitom. Metal bond, low concentration. 127 mm (5") dia. x 0.4 mm x 12.7 mm dia.</p>
40000039	<p>Diamond Cut-off Wheel B0D13 For cutting of sintered carbides and ceramics (> HV 800). For Secotom-10/-15/-50, Accutom-100/-10, Accutom-50/-5, Accutom-2, Accutom and Minitom. Resin bond. 127 mm (5") dia. x 0.6 mm x 12.7 mm dia.</p>
40000043	<p>Diamond Cut-off Wheel M0D10 For precision cutting of ceramics and minerals. For Secotom-10/-15/-50, Accutom-100/-10, Accutom-50/-5, Accutom-2, Accutom and Minitom. Metal bond, high concentration. 102 mm (4") dia. x 0.3 mm x 12.7 mm dia.</p>
40000070	<p>Diamond Cut-off Wheel M1D10 For cutting of hard and brittle materials. For Secotom-10/-15/-50, Accutom-100/-10, Accutom-50/-5, Accutom-2, Accutom and Minitom. Metal bond, low concentration 102 mm (4") dia. x 0.3 mm x 12.7 mm dia.</p>
40000041	<p>Diamond Cut-off Wheel M0D08 For high precision cutting of very small specimens. Mainly recommended for ceramics and minerals. For Secotom-10/-15/-50, Accutom-100/-10, Accutom-50/-5, Accutom-2 and Accutom. Metal bond, high concentration. 76 mm (3") dia. x 0.15 mm x 12.7 mm dia.</p>
40000069	<p>Diamond Cut-off Wheel M1D08 For cutting of hard and brittle materials. For Secotom-10/-15/-50, Accutom-100/-10, Accutom-50/-5, Accutom-2 and Accutom. Metal bond, low concentration. 76 mm (3") dia. x 0.15 mm x 12.7 mm dia.</p>
40000074	<p>CBN Cut-off Wheel B0C20 For cutting of extremely hard ferrous metals (HV 500 - 1400). For Secotom-10/-15/-50. Resin bond, high concentration. 203 mm (8") dia. x 0.9 mm x 22 mm dia.</p>
40000073	<p>CBN Cut-off Wheel B0C15 For cutting of extremely hard ferrous metals (HV 500 - 1400). For Secotom-10/-15/-50, Accutom-100/-10 and Accutom-50/-5. Resin bond, high concentration. 152 mm (6") dia. x 0.8 mm x 12.7 mm dia.</p>
40000040	<p>CBN Cut-off Wheel B0C13 For cutting of extremely hard ferrous metals (HV 500 - 1400). For Secotom-10/-15/-50, Accutom-100/-10, Accutom-50/-5, Accutom-2, Accutom and Minitom. Resin bond, high concentration. 127 mm (5") dia. x 0.6 mm x 12.7 mm dia.</p>



Cooli Additive



Bandfilter paper

Additive

49900073	<p>Cooli Additive Additive for recirculation water for cutting and grinding. Additive to improve cutting/grinding and cooling properties and protect the machine from corrosion. Recommended concentration: 4%. 4 L</p>
49900071	<p>Cooli Additive Plus High performance cutting additive for recirculation water. Additive to improve cutting and cooling properties and protect the machine from corrosion. Recommended concentration: 4%. 1 L</p>
49900072	4 L
49900068	<p>Corrozip-Cu Additive for use in recirculation cooling units, in particular for machines which mainly cut copper and copper alloys. The formula protects the machine from corrosion while improving cutting and cooling qualities. Mixed with water. Concentration of the Corrozip-Cu in the cooling fluid 2.7-3.3 %. Not recommended for use with Coolimat-200 bandfilter due to formation of foam. 1 l Additive for Cooling Systems</p>
49900069	5 l Additive for Cooling Systems
49900070	<p>Water-free Cutting Fluid For cutting of water-sensitive materials on Accutom-5/-50/-10/-100 or Secotom-10/-15/-50. Special pump tube required on Accutom-10/-100 and Secotom-15/-50. 5 l</p>
49900040***	<p>Unitclean For cleaning of Recirculation Cooling Units to stop attack of micro-organisms and remove unpleasant odours. 1 l</p>

Others

49900065	<p>Filter tube 100 l Single-use filter tube for static recirculation cooling system. Capacity: 100-200 l tanks. 10 pcs. Filter bag for use with 100 l, 150 l and 200 l tanks</p>
05766928	<p>Filter bag Filter bag for use with 50 l tank (05766906) and 100 l tank (05766905), requires 05766927 for use with 100 l tank. Reusable sieve. Stainless steel. For use with 50 l tank</p>
05766933	<p>XL Filter bag Replacement filter bag for repeated use with the filter tray. Replacement filter bag</p>
06166901	<p>Bandfilter paper Width: 500 mm. For use with Coolimat-200 bandfilter (06161116)</p>
05766914	<p>Bandfilter paper for use with band filter (057663xx). Width: 45 cm. Roll with 90 m</p>

Others

06526901	Width: 500 mm. For use with Coolimat-2000 with bandfilter. Includes 4 x rolls, each length 100 m. Filter paper roll
05766915	Paper for Static Filter For use with static filter (05766907) For 100 l filter. 100 pcs.
05766916	For use with static filter (05766908) For 50 l filter. 100 pcs.
49900060	Filter paper For Accutom-10 and Accutom-100. 100 pcs.
49900001	Disposable Liners For collecting waste material in recirculation cooling unit (025361xx) with capacity 30 l. 20 pcs.
49900013	For collecting waste material in recirculation cooling unit, capacity 65 l. 10 pcs.
49900042	For collecting waste material in 50 l tank (05766906). 20 pcs.
49900043	For collecting waste material in 100/150 l tank. 20 pcs.
06166906	Disposable liner for Coolimat collection bin, 10 pcs
49900057	For collecting waste material in 200 l tank (06161X16), 5 pcs.

3 times as many cuts

with Cooli Additive Plus



- **A safe work environment.** No allergens, free of boric acid
- Up to **3 times as many cuts** in case-hardened steel
- A **minimum of foam** for a maximum of efficiency
- Up to **30 % more cuts** in aluminum alloy
- **Pre-dosed bottles**, ready to use

Discover more



CUTTING

MOUNTING

GRINDING

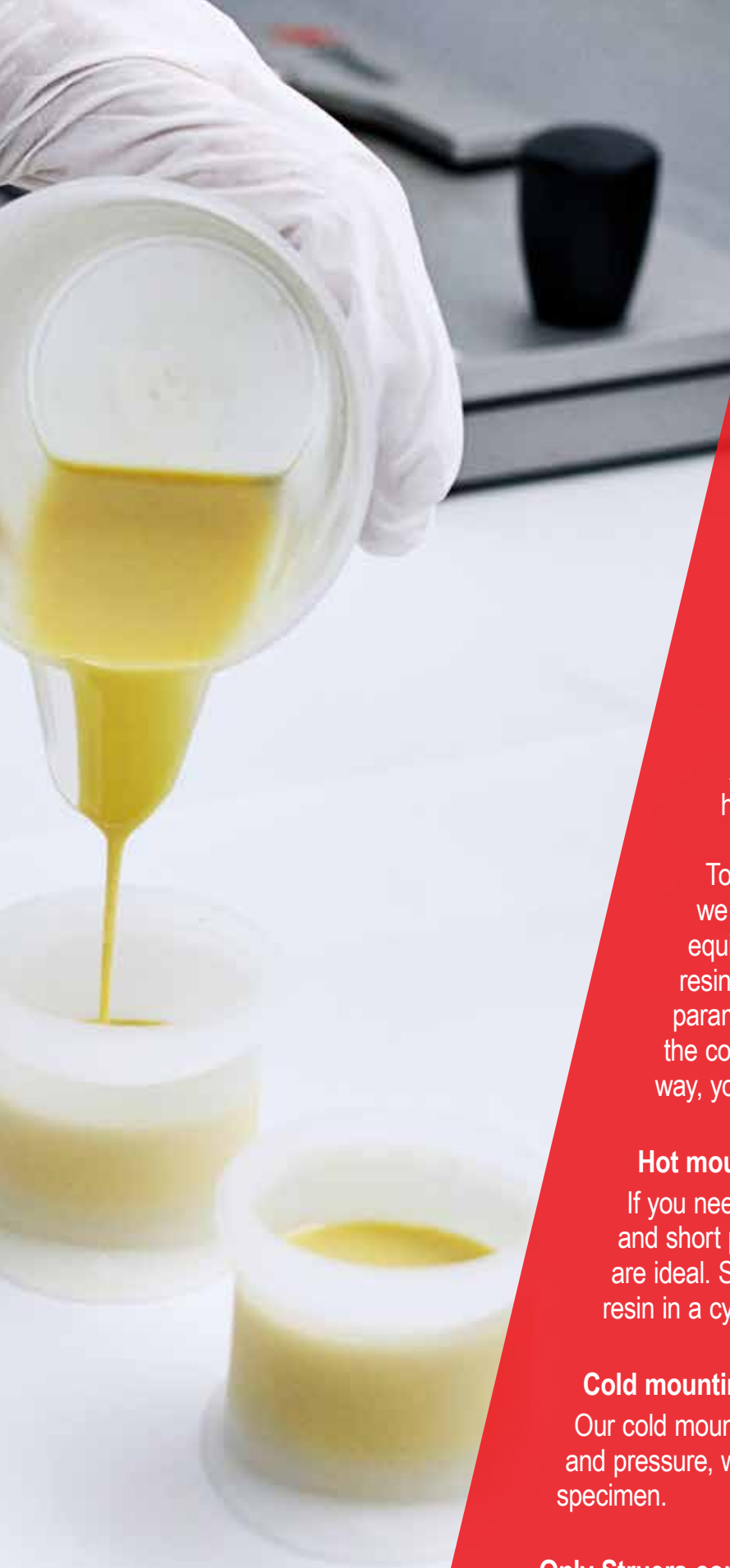
POLISHING

SPECIAL APPLICATIONS

ACCESSORIES

TEST BLOCKS





Mounting

No matter your application, you'll find a Struers resin that meets your every hot and cold mounting need. Easy dosing, safety and specimen integrity are a given. As are consistently superior results that help you achieve an efficient work process.

To ensure premium mounting performance, we encourage you to use our resins with our equipment. That's because each machine and resin is designed to work together to control all parameters of the mounting process, such as the cooling and heating cycle and dosing. That way, you get the most out of your investment.

Hot mounting




If you need high quality, uniform size and shape and short process times, our hot mounting solutions are ideal. Simply place the specimen and appropriate resin in a cylinder within your mounting press.

Cold mounting

Our cold mounting resins protect specimens from heat and pressure, while delivering a stable, secure testing specimen.

Only Struers consumables are designed to get the most out of Struers equipment.





Hot Mounting – Selection guide

Resin	ClaroFast	CitoFast	ConduFast
			
Material	Acrylic	Acrylic with aluminum filler	Acrylic with iron filler
Specific properties	Clear transparent	Very fast mounting. Low process times also when it is used as 'backing' for DuroFast or LevoFast	Electrically conductive
Recommended use	Clear mounts Porous specimens	Fast mounting times For soft materials	Electrolytic polishing
Type	Thermoplastic	Thermoplastic	Thermoplastic
Shrinkage From 1-3 (1 is best)	••	••	••
Hardness From 1-3 (1 is softest)	••	••	•
Removal rate	High	High	High
Process parameters*			
Heating temperature (°C)	180	180	180
Quantity (ml)	20	20	20
Heating time (min.)	4	2,5	3,5
Heating pressure (bar)	350	300	250
Cooling time (min.)	6,5	1	1.5
Cooling rate	Low	High	High
Total process time (min.)	10.5	3.5	5
Application / Specific properties	Transparent mounts. Porous specimens.** Surface electrical insulator for ConduFast	For soft materials.* Fast mounting also when used as backing	Electrolytic polishing

30 mm dia. mount with a 45% carbon steel specimen (20 vol%)

* Embedded abrasives can occur in the aluminum filler

** For some materials, using sensitive mode.

DuroFast	LevoFast	PolyFast	MultiFast
			
Epoxy with mineral filler	Melamine with mineral and glass filler	Bakelite with carbon filler	Bakelite with wood filler
Very low shrinkage. Very low removal rate	Very low shrinkage High removal rate	Very low shrinkage High removal rate	Medium shrinkage Medium removal rate
Excellent edge-retention for hard materials	Excellent edge-retention for soft to medium hard materials	Fast mounting process SEM examination	Routine examination of soft to medium hard materials. Color coding
Thermosetting	Thermosetting	Thermosetting	Thermosetting
•	•	•	•••
•••	•••	••	•••
Low	High	High	Medium
180	180	180	180
20	25	20	25
3,5	3,5	3,5	3
325	250	250	250
2	2	5	2
High	High	High	High
5.5	5.5	5	5
For hard materials Excellent edge retention	For soft to medium hard materials. Excellent edge retention	SEM examination	Routine examination of soft to medium hard materials. Suitable as backing

CUTTING

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TEST BLOCKS

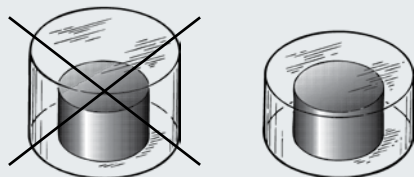
Hot Mounting – How to optimize the process time

When specimens are to be mounted in series it is recommended to optimize the heating and cooling times.

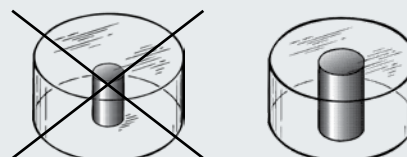
One of the factors limiting both the heating and cooling times is the relatively low heat conductivity

of the resins. An efficient way to reduce the process time is to minimize the distance the heat needs to travel through the resin. When mounting metallic pieces (with high heat conductivity), the heating and cooling times may be reduced when:

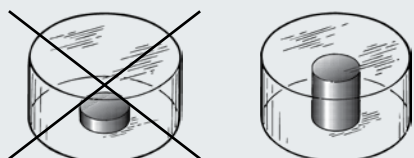
The amount of resin is optimized:



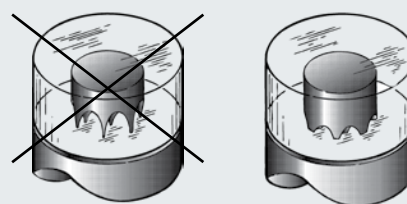
Choose smallest possible mounting cylinder:



A relatively high instead of a low sample is mounted:



Good thermal contact between metal and ram is ensured:



When optimizing the time it should be reduced stepwise with intermediate inspection of the mount. Insufficient heating and cooling times will result in artifacts (See: "Trouble Shooting").

ConduFast and ClaroFast

For electrolytical purposes, ClaroFast, although not electrically conductive, can be used in conjunction with ConduFast. By adding a small amount of ClaroFast first, and then completing the required amount with ConduFast, a mount with a conducting body and an insulating preparation surface is formed.

DuroFast, LevoFast and PolyFast with MultiFast or CitoFast

When using the more expensive PolyFast, DuroFast and Levo-Fast, a substantial cost saving can be made by adding only a small amount of

the desired resin to form the preparation surface, then completing the required amount with the less expensive MultiFast. For fast mounting, use CitoFast as a 'backing' resin. Recommended ratio 1:2 (1/3 DuroFast/LevoFast/PolyFast to 2/3 CitoFast).

Mount Release Agent

This is recommended to be applied to the mounting rams as a thin layer before the mounting process begins. This prevents the adhesive qualities of the resins from making it difficult to remove the mounts afterwards.

Distance to Cylinder Wall

The distance between the specimen and the cylinder wall must be a minimum of 3 mm (1/8"), to avoid cracks in the resin. This is especially critical for specimens with sharp corners.

Small Specimens

Small, thin specimens can be supported during the hot mounting process by the use of Struers Fixation clips. Only metal clips should be used for hot mounting.

Clean Specimens

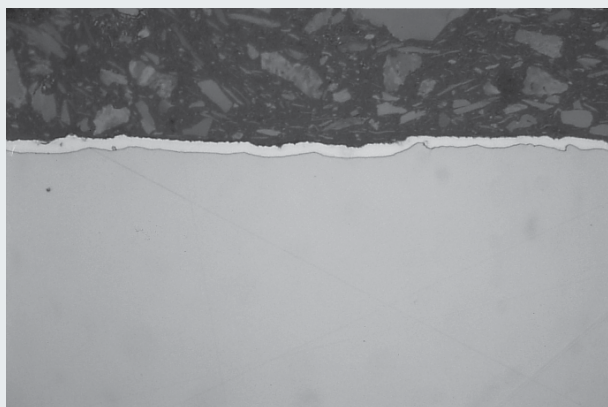
To obtain the best results the specimens must be clean, dry and free from grease. If necessary, clean with alcohol or another suitable degreasing fluid.

Preheating

For porous and/or pressure sensitive specimens, such as minerals, electronic parts etc., it is advantageous to soften the resin by heating, before applying pressure. Preheating is also useful when using thermoplastic resins, particularly ClaroFast.

On CitoPress-15/-30, preheating is available as an automatic programme with the *Sensitive* option. In Sensitive mode, the total heating time is split into two, preheating and heating, where no force is applied during the preheat phase, only during the heating phase.

For metal specimens, we recommend that pressure is applied only for the last minute of the total heating time. If the total heating time is 15 min, preheating should be set to 14 min and 0 bar, and heating to 1 min and 350 bar (ClaroFast).



Polished zinc coating, Mounted in PolyFast 1000 x

For mounting of PCB, plastics and other poor conductors, add 1 min to the preheating time (15 min, 0 bar).

Temperature Sensitive Specimens

The temperature for the mounting process can be reduced to a minimum of 150°C for all resins. This is useful when dealing with temperature sensitive materials. If the temperature is reduced, the recommended heating time should then be increased.

For very temperature sensitive specimens, hot compression mounting should be avoided. Use Struers cold mounting resins instead.

Porous Specimens

Thermoplastic resins, (ClaroFast), penetrate into porous specimens. The best results are obtained by initially preheating the resin (see Preheating).

For very porous materials, hot compression mounting should be avoided. Use of Struers epoxy cold mounting resins is recommended.

Pressure Sensitive Specimens

Thermoplastic resins, (ClaroFast), should be used. The best results are obtained by initially preheating the resin (see Pre-heating).

For very pressure sensitive specimens, hot compression mounting should be avoided. Use Struers cold mounting resins instead.

Specimen Removal

It is crucial that the resin and parameters are correctly matched to each individual specimen. Thermoplastic mounts can be reprocessed. Specimens mounted in thermosetting resins cannot be reprocessed. They have to be re-mounted. Damage free removal from the completed mount cannot be guaranteed.

Hot Mounting Data

The heating and cooling times in the tables refer to the following conditions:

- The heating times in the tables refer to the full process time counted from the start of the process and not from when the pre-set temperature is reached.
- The mounting parameters are based on specimens with a volume approx. 20% of the total volume of the mount. If larger specimens are mounted, less resin should be used.
- If smaller specimens or specimens with low heat conductivity are mounted, the heating and cooling times should be increased. It might also be necessary to increase the pressure to avoid pores in the cured mount.
- A higher pressure is recommended with ClaroFast to avoid "cotton ball" effect.
- The amount of resin in the tables has been adjusted to result in a final height of the mounts of approx. 20 mm (0.8").
- If several resins are combined in one mount, use the process parameters for the resin with the longest times. When using CitoFast as 'backing', use the CitoFast process parameters. For several, or very complicated specimens, add one min. of heating time.
- The mounting parameters are based on using the Citopress 5/15/30.

Cylinder dia.	Resin		Heating			Cooling		Time
	Type	Quantity	Time	Temp.	Pressure	Time	Rate	Total time
25 mm / 1"		[ml]	[min]	[°C]	[bar]	[min]		[min]
	ClaroFast	20	4	180	350	6	Low	9.5
	CitoFast	15	2	180	300	1	High	3
	ConduFast	15	3	180	300	1	High	4
	DuroFast	15	3	180	325	2	High	5
	LevoFast	20	3	180	350	1	High	4
	PolyFast	15	3.5	180	325	1.5	High	5
	MultiFast	20	3	180	300	2	High	5

Cylinder dia.	Resin		Heating			Cooling		Time
	Type	Quantity	Time	Temp.	Pressure	Time	Rate	Total time
30 mm		[ml]	[min]	[°C]	[bar]	[min]		[min]
	ClaroFast	20	4	180	350	6.5	Low	10.5
	CitoFast	25	2.5	180	300	1	High	3.5
	ConduFast	20	3.5	180	250	1.5	High	5
	DuroFast	20	3.5	180	325	2	High	5.5
	LevoFast	25	3.5	180	250	2	High	5.5
	PolyFast	20	3.5	180	250	1.5	High	5
	MultiFast	25	3	180	250	2	High	5

Cylinder dia.	Resin		Heating			Cooling		Time
	Type	Quantity	Time	Temp.	Pressure	Time	Rate	Total time
1¼"		[ml]	[min]	[°C]	[bar]	[min]		[min]
	ClaroFast	20	4	180	350	6.5	Low	10.5
	CitoFast	25	2.5	180	300	1	High	3.5
	ConduFast	20	3.5	180	250	1.5	High	5
	DuroFast	20	4	180	325	2	High	6
	LevoFast	25	3.5	180	250	2	High	5.5
	PolyFast	20	3.5	180	250	1.5	High	5
	MultiFast	25	3.5	180	250	2	High	5.5

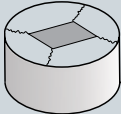
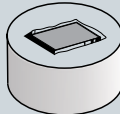
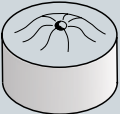
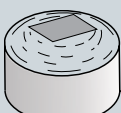
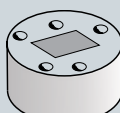

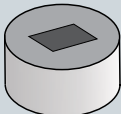
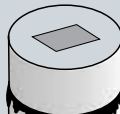
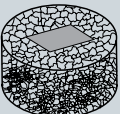
Cylinder dia.	Resin		Heating			Cooling		Time
	Type	Quantity	Time	Temp.	Pressure	Time	Rate	Total time
1½"		[ml]	[min]	[°C]	[bar]	[min]		[min]
	ClaroFast	30	4	180	350	7	Low	11
	CitoFast	45	3	180	300	1.5	High	4.5
	ConduFast	35	3.5	180	250	2	High	5.5
	DuroFast	35	4.5	180	350	2.5	High	7
	LevoFast	40	4.5	180	250	2	High	6.5
	PolyFast	30	4.5	180	250	2	High	6.5
	MultiFast	40	4.5	180	250	2.5	High	7

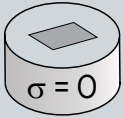
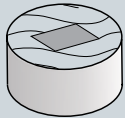
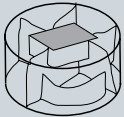
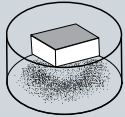
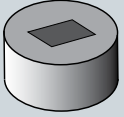
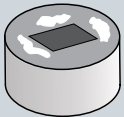
Cylinder dia.	Resin		Heating			Cooling		Time
	Type	Quantity	Time	Temp.	Pressure	Time	Rate	Total time
40 mm		[ml]	[min]	[°C]	[bar]	[min]		[min]
	ClaroFast	35	4	180	350	6.5	Low	10.5
	CitoFast	45	3	180	300	1.5	High	4.5
	ConduFast	40	3.5	180	250	2	High	5.5
	DuroFast	40	4.5	180	350	2.5	High	7
	LevoFast	50	5	180	250	2	High	7
	PolyFast	35	4	180	250	2	High	6
	MultiFast	45	4	180	250	2.5	High	6.5

Cylinder dia.	Resin		Heating			Cooling		Time
	Type	Quantity	Time	Temp.	Pressure	Time	Rate	Total time
50 mm / 2"		[ml]	[min]	[°C]	[bar]	[min]		[min]
	ClaroFast	55	5	180	250	8.5	Low	13.5
	CitoFast	65	3.5	180	250	2	High	5.5
	ConduFast	65	4	180	250	2	High	6
	DuroFast	70	5.5	180	250	3	High	8.5
	LevoFast	75	6	180	250	3	High	9
	PolyFast	55	5.5	180	250	2	High	7.5
	MultiFast	70	6	180	250	4	High	10

Hot Mounting – Trouble shooting guide

General Problems

<p>Radial Cracking</p> 	<p>Cause: Insufficient distance between specimen edge/corner and cylinder wall, or specimen has sharp corners</p> <p>Solution: Increase cylinder diameter or reduce specimen size. The distance between the specimen and the cylinder wall must be a minimum of 3 mm to avoid cracks in the resin. This is especially critical for specimens with sharp corners.</p>	<p>Shrinkage</p> 	<p>Cause: Incorrect choice of resin.</p> <p>Solution: Re-mount a new specimen using a resin with a lower linear shrinkage value.</p>	<p>Blistering</p> 	<p>Cause: Insufficient heating time.</p> <p>Solution: Increase heating time, or increase process temperature.</p> <p>Cause: Overcured surface.</p> <p>Solution: Decrease process temperature.</p> <p>Cause: Entrapped gas within mount.</p> <p>Solution: Preheat resin.</p>
<p>Bulging</p> 	<p>Cause: Insufficient cooling.</p> <p>Solution: Increase cooling time.</p>	<p>Porosity</p> 	<p>Cause: Excessive temperature.</p> <p>Solution: Reduce process temperature.</p>	<p>Voiding within large mounts</p> 	<p>Cause: Insufficient heating time.</p> <p>Solution: Increase heating time.</p> <p>Cause: Excessive temperature.</p> <p>Solution: Reduce process temperature.</p> <p>Cause: Insufficient force/pressure.</p> <p>Increase mounting force/pressure.</p>
<p>Dull Surface Finish</p> 	<p>Cause: Insufficient heating time.</p> <p>Solution: Increase heating time.</p>	<p>Adhesion between mount and rams</p> 	<p>Cause: Insufficient application of mould release agent.</p> <p>Solution: Apply mould release agent. This must always be applied to the mounting rams as a thin layer before the mounting process begins. This prevents the resins from sticking to the rams and makes it easier to remove the mounts afterwards.</p> <p>Cause: Insufficient heating time.</p> <p>Solution: Increase heating time.</p> <p>Cause: Excessive force/pressure.</p> <p>Solution: Decrease mounting force/pressure.</p>	<p>Individual Grains Visible on Mount*</p> 	<p>Cause: Resin has cured without force/pressure.</p> <p>Solution: Increase force/pressure during heating cycle.</p> <p>Cause: Insufficient heating time.</p> <p>Solution: Increase the heating time and/or temperature.</p> <p>*Thermosetting resins only</p>

ConduFast Problems			
Lack of conductivity 	Cause: No contact with specimen due to use of an excessive amount of ClaroFast, (refer to Helpful Hints). Solution: Re-mount a new specimen using a smaller amount of ClaroFast than before. Cause: Insufficient heating time Solution: Reinsert the mount in the press and reprocess using an increased heating time.	Metallic particles in resin removed during the electrolytic process 	Cause: Insufficient amount of ClaroFast, (refer to Helpful Hints). Solution: Re-mount a new specimen using a larger amount of ClaroFast. Cause: Excessive grinding time. Solution: Re-mount with a new specimen.
ClaroFast Problems			
Internal cracking 	Cause: Excessive cooling rate. Solution: Reduce the cooling rate	“Cottonball” effect in centre of mount 	Cause: Excessive cooling rate. Solution: Reduce the cooling rate. Cause: Insufficient heating time. Solution: Reduce the physical height of the mount, lower the process temperature and increase the heating time. Cause: Moist resin. Solution: Dry the resin by exposing the open container to 30-70°C for 2 hours.
LevoFast Problems			
The mounts turn dark after preparation 	Cause: Insufficient heating time Solution: Increase heating time and/or temperature		
PolyFast and MultiFast Problems			
Parts of mount become light or colourless on contact with alcohol 	Cause: Insufficient heating time. Solution: Increase heating time and/or temperature		

Safe, accurate and easy dosing of hot mounting resins

EasyDoser is the first universal manual dosing system on the market, making resin dosing both simpler and safer. Applicable with Struers 1kg resins.




Yes,
I want to improve resin dosing



Cold Mounting – Selection guide for acrylics

Material	VersoCit-2	ClaroCit
		
Curing time	10 min.	20 min.
Shrinkage from 1-4 (1 is best)	****	***
Application	For routine examination <ul style="list-style-type: none"> • Routine examination of soft to medium hard materials 	For extraordinarily clear mounts <ul style="list-style-type: none"> • For universal use • Target preparation
Mixing ratio weight recommended	Liquid: 2 parts Powder: 3 parts	Liquid: 6 parts Powder: 10 parts
Mixing ratio volume	Liquid: 1 part Powder: 2 parts	Liquid: 2 parts Powder: 5 parts
Mixing time	30 s	1 ½ min.
Potlife	3 min.	1 ½ min.
Colour	Dull yellowish, partly transparent	Colourless, clear (extremely clear when cured under pressure)
Can be coloured with EpoDye		X
Can be coloured with AcryDye	X	X
Peak temperature	100 °C / 212 °F	90 °C / 194 °F
Hardness	82 Shore D	85 Shore D

(30 mm dia. mount without specimen at 21 °C / 70 °F)

DuroCit-3	LevoCit	ViaFix
		
30 min.	20 min.	20 min.
*	**	***
Fast curing and no shrinkage <ul style="list-style-type: none"> • For medium hard and hard ferrous metals and other hard materials – including ceramics, carbides etc. • For specimens where protection of layers is important e.g. coated specimens • Excellent edgeretention and planeness 	Good edge-retention and planeness <ul style="list-style-type: none"> • For non-ferrous metals and soft ferrous metals • Low shrinkage • Low peak temperature 	For vias and microvias <ul style="list-style-type: none"> • Excellent for filling of microvias <p><i>* Affected by alcohol. When using diamond products or lubricants containing alcohol, the surface will be affected and the structure of the polymer beads will appear</i></p>
Liquid I: 8 parts Liquid II: 4 parts Powder: 14 parts	Liquid: 1 part Powder: 2 parts	Liquid: 9 parts Powder: 11 parts
Liquid I: 10 parts Liquid II: 5 parts Powder: 15 parts	Liquid: 1 part Powder: 2 parts	Liquid: 1 part Powder: 2 parts
1 ½ min.	45 s	30 s
4 min.	1 ½ min.	2 min.
Light yellow	Off-white	Colourless, clear (extremely clear when cured under pressure). Otherwise semi-transparent
		X
X	X	X
138 °C / 280 °F	75 °C / 167 °F	115 °C / 239 °F
85 Shore D	84 Shore D	83 Shore D

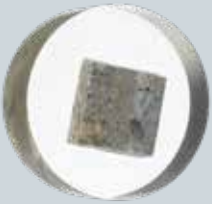

Cold Mounting – Selection guide for Epoxies

Material	CaldoFix-2	SpeciFix-40
		
Curing time	1 ½ hour in oven at 75 °C / 167 °F ¹⁾	3 ½ hours in oven at 50 °C / 122 °F ¹⁾
Shrinkage from 1-4 (1 is best)	*	*
Application	For all-round vacuum impregnation <ul style="list-style-type: none"> • Short curing time • Low viscosity • Relatively hard after curing 	Extremely good adhesion <ul style="list-style-type: none"> • Relative fast curing time • Very clear colourless mounts • Cures in oven or Drybox
Mixing ratio weight recommended	Resin: 25 parts Hardener: 7 parts	Resin: 2.5 parts Curing Agent: 1 parts
Mixing ratio volume	Resin: 31 parts Hardener: 10 parts	Resin: 10.5 parts Curing Agent: 5 parts
Mixing time	5 min.	3 min.
Potlife	> 60 min.	> 60 min.
Colour	Clear, transparent Refractive index: ND = 1.561	Clear, transparent Refractive index: ND = 1.573
Can be coloured with EpoDye	X	X
Can be coloured with AcryDye		
Peak temperature	170 °C / 338 °F	100 °C / 212 °F
Hardness	85 Shore D	82 Shore D

30 mm dia. mount without specimen at 21 °C / 70 °F)

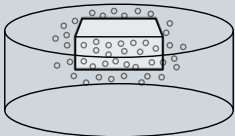
* 40 mm mount, 10% specimen volume, 25 °C / 73 °F ambient temperature, Covered while curing

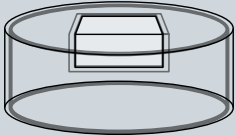
** 30 mm mount, 10% specimen volume, 25 °C / 73 °F ambient temperature, Covered while curing

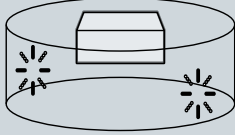
EpoFix	ProntoFix Standard	ProntoFix Accelerated																			
																					
Approx. 12 hours	90 min. *	90 min. **																			
*	*																				
For vacuum impregnation - low viscosity <ul style="list-style-type: none"> • Can be used on all types of specimens • Extremely low curing temperature – Very good for heat sensitive specimens • Superior penetration of cracks and pores • Excellent adhesion 	For mounting and preparing specimens the same day <ul style="list-style-type: none"> • Suitable for vacuum impregnation • Excellent adhesion • Superior penetration of cracks and pores 	<table border="1"> <thead> <tr> <th rowspan="2">TEMPERATURE IN LAB (°C / °F)</th> <th colspan="3">DIAMETER OF CUP (mm) (")</th> </tr> <tr> <th>Ø25 Ø1.00</th> <th>Ø30 Ø1.25</th> <th>Ø40 Ø1.50</th> </tr> </thead> <tbody> <tr> <td><23 <73.4</td> <td>Standard system</td> <td>Standard system</td> <td>Standard system</td> </tr> <tr> <td>23-27 73.4-80.6</td> <td>Standard system</td> <td>Accelerated system</td> <td>Accelerated system</td> </tr> <tr> <td>>27 >80.6</td> <td>Standard system</td> <td>Accelerated system</td> <td>Accelerated system</td> </tr> </tbody> </table> <p>RECOMMENDATIONS</p> <ul style="list-style-type: none"> Accelerated system Standard system Curing not possible in less than 4 hours 	TEMPERATURE IN LAB (°C / °F)	DIAMETER OF CUP (mm) (")			Ø25 Ø1.00	Ø30 Ø1.25	Ø40 Ø1.50	<23 <73.4	Standard system	Standard system	Standard system	23-27 73.4-80.6	Standard system	Accelerated system	Accelerated system	>27 >80.6	Standard system	Accelerated system	Accelerated system
TEMPERATURE IN LAB (°C / °F)	DIAMETER OF CUP (mm) (")																				
	Ø25 Ø1.00	Ø30 Ø1.25	Ø40 Ø1.50																		
<23 <73.4	Standard system	Standard system	Standard system																		
23-27 73.4-80.6	Standard system	Accelerated system	Accelerated system																		
>27 >80.6	Standard system	Accelerated system	Accelerated system																		
Resin: 25 parts Hardener: 3 parts	Resin: 20 parts Hardener: 5.3 parts	Resin: 20 parts Hardener: 4.2 parts Accelerator: 1.1 parts																			
Resin: 15 parts Hardener: 2 parts	Resin: 20 parts Hardener: 5.3 parts	Resin: 20 parts Hardener: 4.2 parts Accelerator: 1.1 parts																			
2 min.	1 min.																				
30 min.	25 min.	20 min.																			
Clear, transparent Refractive index: ND = 1.578	Transparent, Yellow																				
X	X																				
40 °C / 104 °F	140 °C / 284 °F	150 °C / 302 °F																			
78 Shore D	83 Shore D																				

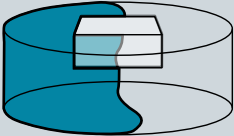
*** Use the matrix to find out if the accelerator is recommended. For example if you are mounting with 30 mm cups and the room temperature is between 23-27°, it is recommended to use the ProntoFix accelerator.

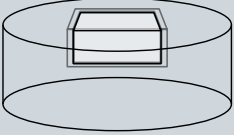
Cold Mounting – Trouble shooting guide

Problem	Cause	Solution
Air bubbles along the sides of the specimen  The system creates too many bubbles – generation of excessive heat	Lab temperature > 23°C	<ul style="list-style-type: none"> · Uncover the mount during curing · Use Struers DryBox to increase airflow · Use a smaller amount of mounting material · Cool down mounting material during mixing · If Accelerator is used try to use standard system
	Specimen/ProntoFix volume ratio < 20% < 10% for metallic specimen (Too small specimen)	<ul style="list-style-type: none"> · Uncover the mounting cup · Use Struers DryBox to increase airflow · Pour less ProntoFix in the mounting cup · If Accelerator is used try to use standard system
	The mount is less than 5mm from the top of the mounting cup	<ul style="list-style-type: none"> · Uncover during curing · Use Struers DryBox to increase airflow
	Diameter 50mm	<ul style="list-style-type: none"> · Fill up only half of the mounting cup · If you need a 20mm tall mount, cure in two steps · Uncover while curing · Use a smaller mounting cup · Use Struers DryBox to increase airflow · If Accelerator is used try to use standard system
	Insufficient degreasing of specimen	<ul style="list-style-type: none"> · Clean and degrease samples prior to mounting
	Too active stirring of mixture	<ul style="list-style-type: none"> · Stir without introducing air into the mixture

Problem	Cause	Solution
High shrinkage 	Too high temperature during curing	<ul style="list-style-type: none"> · Use Struers DryBox to increase airflow
	Insufficient degreasing of specimen	<ul style="list-style-type: none"> · Clean and degrease samples prior to mounting
	Insufficient mixing of resin and hardener	<ul style="list-style-type: none"> · Stir mixture thoroughly
	Too large volume of mixture or too long time after stirring before pouring	<ul style="list-style-type: none"> · Mix smaller volumes and pour over specimens immediately after stirring

Problem	Cause	Solution
Sticky or rubbery surface  The system cures too slowly	Lab temperature < 23°C	<ul style="list-style-type: none"> · Fill up the mounting cup sufficiently · Use a bigger mounting cup · Use the Struers DryBox to increase temperature · If the standard hardener is used, try to use the Accelerator to decrease curing time
	Specimen/ProntoFix volume ratio > 20% > 10% for metallic specimen (Too big specimen)	<ul style="list-style-type: none"> · Use a bigger mounting cup · Reduce the size of the specimen · Use the Struers DryBox to increase temperature · If the standard hardener is used, try to use the Accelerator to decrease curing time
	The mount is more than 5mm from the top of the mounting cup (Too low mount)	<ul style="list-style-type: none"> · Use the Struers DryBox to increase temperature · If the standard hardener is used, try to use the Accelerator to decrease curing time
	Mounting cup diameter 25mm	<ul style="list-style-type: none"> · Use a Drybox to increase temperature · Use a bigger mounting cup · If the standard hardener is used, try to use the Accelerator to decrease curing time

Problem	Cause	Solution
Indraft/suction at the bottom of the specimen 	Too high temperature during curing	· Use Struers DryBox to increase airflow
	Specimen/ProntoFix volume ratio < 20% < 10% for metallic specimen (Too small specimen)	· Use adequate mounting cup or mount in layers of around 10mm per layer. Wait until the first layer is cured and then cast the next layer

Problem	Cause	Solution
Gap between ProntoFix and specimen 	Too high temperature during curing	· Use Struers DryBox to increase airflow
	Insufficient degreasing of specimen	· Clean and degrease samples prior to mounting
	Specimen/ProntoFix volume ratio < 20% < 10% for metallic specimen (Too small specimen)	· Use Struers DryBox to increase airflow
	Too much hardener in relation to resin	· Mix resin and hardener in the correct ratio

How to cold mount

Some prerequisites have to be taken into account before mounting takes place.

Click and find out





ClaroFast



LevoFast



MultiFast Black, Green and Red

Hot Mounting

ClaroFast

40100055 Clear transparent acrylic hot mounting resin. Thermoplastic.

1 kg

40100054 7.5 kg

40100053 25 kg

CitoFast

40100068 For soft materials or to reduce process time especially as backing material for LevoFast or DuroFast.

1 kg

40100069 7.5 kg

ConduFast

40100039 Acrylic hot mounting resin with iron filler. Thermoplastic.

1 kg

DuroFast

40100044 Black epoxy hot mounting resin with mineral filler, for edge-retention and planeness of hard materials. Thermosetting.

1 kg

40100045 7.5 kg

LevoFast

40100057 Light yellow melamine hot mounting resin with mineral and glass filler. Thermosetting.

1 kg

40100058 7.5 kg

PolyFast

40100036 Black bakelite hot mounting resin with carbon filler. Thermosetting.

1 kg

40100037 7.5 kg

MultiFast Black

40100064 Black bakelite hot mounting resin with wood filler. Thermosetting.

2.5 kg

40100065 7.5 kg

40100066 25 kg

40100067 75 kg

MultiFast Green

40100078	Green bakelite hot mounting resin with wood filler. Thermosetting. 2.5 kg
40100079	7.5 kg
40100080	25 kg
40100081	75 kg

MultiFast Red

40100074	Red bakelite hot mounting resin with wood filler. Thermosetting. 2.5 kg
40100075	7.5 kg
40100076	25 kg
40100077	75 kg

Others

40300043	AntiStick Mould release agent. Stearate powder in applicator. 8 g
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Durocit-3 Kit



ProntoFix

Cold Mounting

ProntoFix

40200108***	ProntoFix Kit Epoxy cold mounting system for mounting and preparing within the same day. Curing at room temperature. No shrinkage, especially suited for vacuum impregnation. Transparent. 1 l resin, 275 ml hardener and required consumables
40200109	ProntoFix Resin To be mixed with ProntoFix Hardener. 1 l resin corresponds to 275 ml hardener. If curing time with the ProntoFix Hardener is too long the ProntoFix Accelerator can be added. 1.3 l Resin corresponds to 275 ml hardener plus 70 ml accelerator. 1 l
40200110***	ProntoFix Hardener To be mixed with ProntoFix Resin. 500 ml hardener corresponds to 1.8 l resin. 500 ml
40200111***	ProntoFix Accelerator To be mixed with ProntoFix Resin and ProntoFix Hardener. To accelerate the ProntoFix system if curing time with the ProntoFix Hardener is too long. 70 ml accelerator must be mixed with 275 ml ProntoFix Hardener. The mixture corresponds to 1.3 l ProntoFix Resin. Empty bottle for premixing Hardener and Accelerator is available. 70 ml

EpoFix

40200029***

EpoFix Kit

Epoxy cold mounting system curing at room temperature in about 12 hours, with no shrinkage, especially suited for vacuum impregnation. Transparent.

1 l resin, 130 ml hardener and required consumables

40200030

EpoFix Resin

To be mixed with EpoFix Hardener. 1 l resin corresponds to 130 ml hardener.

1 l

40200031***

EpoFix Hardener

To be mixed with EpoFix Resin. 500 ml hardener corresponds to 4 l resin.

500 ml

SpeciFix

40200049***

SpeciFix-40 Kit

Epoxy cold mounting system curing at elevated temperature (40-60 °C) in about 3.5 hours, with very low shrinkage, suitable for vacuum impregnation. Transparent.

1 l resin, 500 ml curing agent and required consumables

40200051

SpeciFix Resin

To be mixed with Specifix-40 Curing Agent. 1 l resin corresponds to 500 ml Specifix-40 Curing Agent.

1 l

40200053***

SpeciFix-40 Curing Agent

To be mixed with Specifix Resin. 1 l curing agent corresponds to 2 l resin.

1 l

CaldoFix

40200084***

CaldoFix-2 Kit

Epoxy cold mounting system, curing within 1½ hours when heated to 75 °C / 167 °F. Very low shrinkage, suitable for vacuum impregnation. Transparent.

1 l resin, 325 ml hardener and required consumables

40200085

CaldoFix-2 Resin

To be mixed with CaldoFix-2 Hardener. 1 l resin corresponds to 325 ml hardener.

1 l

40200086***

CaldoFix-2 Hardener

To be mixed with CaldoFix-2 Resin. 500 ml hardener corresponds to 1.5 liter resin.

500 ml

ClaroCit

40200072***

ClaroCit Kit

Acrylic cold mounting system for universal use. Provides extremely clear, transparent mounts (especially when cured under pressure).

800 g powder, 500 ml liquid and required consumables

40200074

ClaroCit Powder

To be mixed with ClaroCit liquid. 3 kg powder corresponds to 1.9 l liquid.

3 kg

40200073***

ClaroCit Liquid

To be mixed with ClaroCit Powder. 1 l liquid corresponds to 1.6 kg powder.

1 l

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Get to know us better and let us share our more than 143 years of expertise in materialographic surface preparation and analysis. Stay updated with news and insights from Struers, with specialist insights, tips and tricks, news on products, courses, and webinars. All of this is specifically designed for you to improve your own materialographic skill set.

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CUTTING

MOUNTING

GRINDING

POLISHING

SPECIAL APPLICATIONS

ACCESSORIES

TEST BLOCKS

DuroCit

40200095***

DuroCit-3 Kit

Acrylic cold mounting system with mineral filler. For excellent edge-retention.

570 g powder, 300 ml liquid I, 150 ml liquid II and required consumables

40200081

DuroCit Powder

To be mixed with DuroCit Liquid I and II. 3 kg Powder corresponds to 1.6 l Liquid I and 0.8 l Liquid II
3 kg

40200096***

DuroCit-3 Liquid I

To be mixed with DuroCit Powder and DuroCit-3 Liquid II. 1 l Liquid I corresponds to 1.9 kg powder and 0.5 l Liquid II.

1 l

40200097***

DuroCit-3 Liquid II

To be mixed with DuroCit Powder and DuroCit-3 Liquid I. 1 l Liquid II corresponds to 3.8 kg powder and 2 l Liquid I.

1 l

LevoCit

40200092***

LevoCit Kit

Acrylic cold mounting resin with filler optimised for non-ferrous and soft ferrous metals.

600 g powder, 300 ml liquid and required consumables

40200093

LevoCit Powder

To be mixed with LevoCit Liquid. 3 kg powder corresponds to 1.5 l Liquid.

3 kg

40200094***

LevoCit Liquid

To be mixed with LevoCit Powder. 1 l liquid corresponds to 2 kg powder.

1 l

VersoCit-2

40200089	VersoCit-2 Kit Acrylic cold mounting system for routine examination of soft to medium hard materials. 750 g powder, 500 ml liquid and required consumables
40200090	VersoCit-2 Powder To be mixed with VersoCit-2 Liquid. 3 kg powder corresponds to 2 l liquid. 3 kg
40200091	VersoCit-2 Liquid To be mixed with VersoCit-2 Powder. 1 l liquid corresponds to 1.5 kg powder. 1 l

ViaFix

40200067***	ViaFix Kit Acrylic cold mounting system for filling of microvias and pores. The clearest mount is obtained by using a pressure chamber. 570 g powder, 500 ml liquid and required consumables
40200068	ViaFix Powder To be mixed with ViaFix Liquid. 2.5 kg powder corresponds to 2.3 l liquid. 2.5 kg
40200069***	ViaFix Liquid To be mixed with ViaFix Powder. 1 l liquid corresponds to 1.1 kg powder. 1 l



FixiForm



FlexiForm



SeriForm

FixiForm

40300085	Two part polypropylene mounting cup for all Struers cold mounting materials. 25 mm / 1" dia. 10 pcs.
40300086	30 mm dia. 10 pcs.
40300087	1¼" dia. 10 pcs.
40300088	1½" dia. 10 pcs.
40300089	40 mm dia. 10 pcs.
40300090	50 mm / 2" dia. 10 pcs.

Flexiform

40300018	Flexible silicone rubber mounting cup for ClaroCit, DuroCit, VersoCit-2, LevoCit and ViaFix. 25 mm dia. 5 pcs.
40300019	30 mm dia. 5 pcs.
40300020	1¼" dia. 5 pcs.
40300021	1½" dia. 5 pcs.
40300092	40 mm dia. 5 pcs.

Flexiform

- 40300082 Silicone rubber mounting cup for mounting to be used especially with acrylic cold mounting resins with which it can be reused many times. It can also be used with epoxy resins. Mounts fit to specimen holder MAXDI, 02606920.
68 x 37 x 35 mm. 3 pcs.
- 40300083 Silicone rubber mounting cup for mounting to be used especially with acrylic cold mounting resins with which it can be reused many times. It can also be used with epoxy resins. Mounts fit to specimen holder MAXOT, 02606922.
90 x 50 x 35 mm. 3 pcs.
- 40300084 Silicone rubber mounting cup for mounting to be used especially with acrylic cold mounting resins with which it can be reused many times. It can also be used with epoxy resins.
120 x 60 x 45 mm. 2 pcs.

Seriform

- 40300007 Two parts polypropylene mounting cup with parallel sides for ClaroCit, VersoCit-2 and ViaFix.
25 mm dia. 10 pcs.
- 40300008 30 mm dia. 10 pcs.
- 40300009 40 mm dia. 5 pcs.



MultiClips



Fixation Clips



Taper section angle



AcryDye



EpoDye

Others

- 40300012 **Flangeform**
Mounting cup with flange. For AccuStop 30.
30 mm dia. 3 pcs.
- 40300023 **PCB-Coupon Mould**
Mould for mounting PCB-coupons. Consists of a hard part and a soft part (40300024).
1 pcs.
- 40300024 Mould for mounting PCB-coupons. Replacement soft part for 40300023.
1 pcs.
- 40300027 **MultiClips**
Multiple plastic clip for holding up to 5 small and thin specimens when mounting.
50 pcs.
- 40300026 **Fixation Clips**
Metal spring clip for holding small and thin specimens when mounting.
6 mm dia. 100 pcs.
- 40300025 9 mm dia. 100 pcs.
- 40300070 **Taper Section Angle, Aluminum**
Aluminum angle for mounting of taper sections.
50 pcs.

Others

40300071	<p>Taper Section Angle, Copper Copper angle for mounting of taper sections. 50 pcs.</p>
40300069	<p>Taper Section Angle, Steel Steel angle for mounting of taper sections. 50 pcs.</p>
40300091	<p>ProntoFix Empty Bottle Empty bottle for premixing ProntoFix Hardener and ProntoFix Accelerator. 1 bottle 500 ml, 1 label</p>
40300080	<p>Consumables Kit Disposable consumables for CitoVac. 100 dispensing tubes and one chamber protector</p>
40300030	<p>Consumables for Epovac 80 polyethylene tubes, 80 mixing cups, 80 stirrers and 2 rubber plugs</p>
40300032	<p>For mixing of cold mounting systems. 400 mixing cups and 400 stirrers</p>
05696101	<p>Mixer for mixing of Epoxy For optimal mixing of cold mounting epoxies. 1 mixer and 1 disposable propeller</p>
40300072	<p>Disposable Propeller To be used with Struers Mixer (05696101). 20 pcs.</p>
40300081	<p>AcryDye Dye for colouring of acrylic cold mounting resins: ClaroCit, DuroCit, VersoCit-2 and ViaFix. Set with 20 ml of each red, blue and yellow dye</p>
40300047	<p>Disposable Syringes Syringes for measuring of epoxy resins and hardeners. 5 ml. 100 pcs.</p>
40300048	10 ml. 100 pcs.
40300049	20 ml. 50 pcs.
40300002	<p>EpoDye Fluorescent dye for use with EpoFix, ProntoFix, Specifix, CaldoFix, ClaroCit and ViaFix. Special filters for microscope required. Mixing ratio: Epoxy resin: 1 LEpoDye: 5 g. 20 g</p>
40300076	<p>Silicone Oil Silicone release agent. 100 ml</p>



Do you master these tips & tricks when doing **Cold mounting fixation?**

There are a few but important prerequisites you must take into account before mounting. This short video will give you the important basics.

Click and find out





Grinding

Ensuring that you apply force precisely and dose correctly, we recommend that you use Struers consumables with our equipment.

That's because each machine and consumable is designed to work together to control all parameters of the grinding process, such as dosing abrasives and suspensions in the right quantity and with efficient distribution. It's the ideal way to get the most out of your investment.

MD-System

Our advanced MD-System comprises a magnetic supporting disc combined with metal-backed grinding discs and polishing cloths. Because these grinding discs uniformly remove hard and soft phases in the specimen, you get consistently high material removal rates and maximum flatness. You can also significantly reduce preparation time and costs.

Only Struers consumables are designed to get the most out of Struers equipment.

Selection Guide for MD-System Grinding Discs – Water Cooled

Description	Recommended Use	Indicative lifetime*
MD-Piano 80: Resin bonded diamond disc that provides a surface finish comparable to 80 grit SiC paper.	Plane grinding of hard materials > 150 HV range such as ferrous metals, concrete, ceramics.	100
MD-Piano 120: Resin bonded diamond disc that provides a surface finish comparable to 120 grit SiC paper.	Plane grinding of hard materials > 150 HV range such as ferrous metals, concrete, ceramics.	100
MD-Piano 220: Resin bonded diamond disc that provides a surface finish comparable to 220 grit SiC paper.	Plane grinding of hard materials > 150 HV range such as ferrous metals, concrete, ceramics.	100
MD-Piano 500: Resin bonded diamond disc that provides a surface finish comparable to 500 grit SiC paper.	Fine grinding of hard materials > 150 HV range such as ferrous metals, concrete, ceramics.	100
MD-Piano 1200: Resin bonded diamond disc that provides a surface finish comparable to 1200 grit SiC paper.	Fine grinding of hard materials > 150 HV range such as ferrous metals, concrete, ceramics.	100
MD-Piano 2000: Resin bonded diamond disc that provides a surface finish comparable to 2000 grit SiC paper.	Fine grinding of hard materials > 150 HV range such as ferrous metals, concrete, ceramics.	300
MD-Piano 4000: Resin bonded diamond disc that provides a surface finish comparable to 4000 grit SiC paper.	Fine grinding of hard materials > 150 HV range such as ferrous metals, concrete, ceramics.	300
MD-Primo 120: A metal disc with a SiC abrasive embedded in a resin bond. It provides a surface finish comparable to 120 grit SiC paper.	Plane grinding of soft materials in the 40 - 250 HV range like non-ferrous metals (aluminum, copper, etc.) and soft materials.	50
MD-Primo 220: A metal disc with a SiC abrasive embedded in a resin bond. It provides a surface finish comparable to 220 grit SiC paper.	Plane grinding of soft materials in the 40 - 250 HV range like non-ferrous metals (aluminum, copper, etc.) and soft materials.	50
MD-Molto 220: Resin bonded diamond disc that provides a surface finish comparable to 220 grit SiC paper.	Plane grinding of aluminum alloys in the 40 - 2000 HV range.	100
MD-Mezzo 220: Resin bonded diamond disc that provides a surface finish comparable to 220 grit SiC paper.	Plane grinding of titanium alloys in the 150 - 450 HV range.	100

All MD-System Grinding Discs use water for cooling just like SiC paper.
They all provide high and consistent material removal rate, and produce exceptionally flat specimens.

* 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).

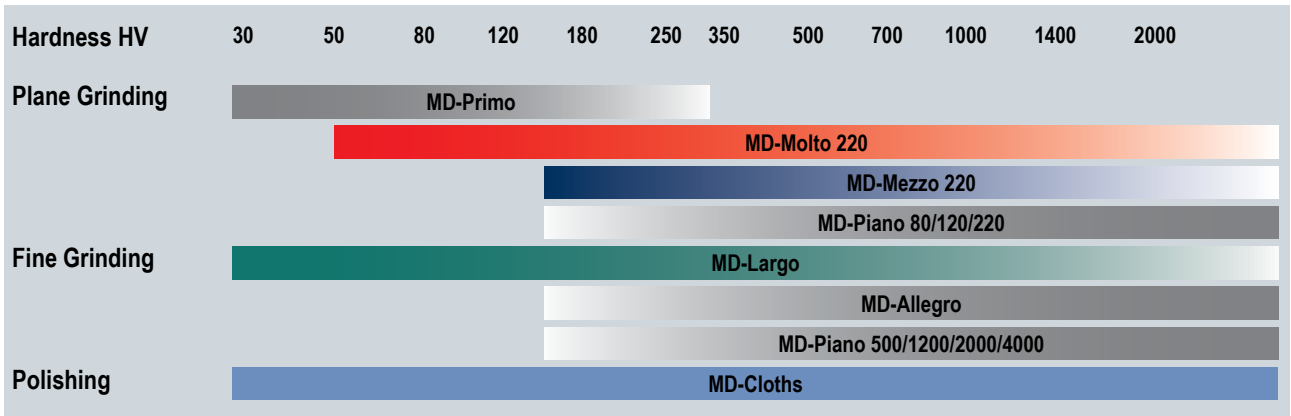
Grit / Grain size comparison*

Struers grinding papers are classified according to FEPA Standards (Federation of the European Producers of Abrasives). US Grit Numbers and those specified by FEPA and corresponding average grain diameter in microns are shown.

FEPA P (Europe)	# 80	# 120	# 180	# 220	# 320	# 500	# 800	# 1000	# 1200	# 2000	# 4000**
ANSI / CAMI (US)	# 80	# 120	# 180	# 220	# 280	# 360	# 400	# 500	# 600	# 1000	# 1200
Grain size	200 µm	125 µm	82 µm	68 µm	46 µm	30 µm	22 µm	18 µm	15 µm	10 µm	5 µm

*) Guideline values only

***) Not part of FEPA P standardization



Plane grinding: Here are the methods used by the best

Don't waste valuable time on inefficient plane grinding of your samples. This video, from one of our most popular webinars, hands you the methods used by the best.

Click and
find out





Grinding Stones



M0P15 Diamond Cup Wheel



Diamond Grinding Disc

Plane Grinding

Grinding Stones	
40800005	<p>Grinding Stone PAMST Aluminum oxide grinding stone, for plane grinding of metals on Prepamatic and Prepamatic-2. Grit 150. 200 mm (8") dia.</p>
40800177	<p>Grinding stone 6A36 #150 Aluminum oxide grinding stone, for fast plane grinding of very hard steels/steels containing many carbides on AbraPlan and MAPS. Grit 150, 356 mm dia.</p>
40800010	<p>Grinding stone 4A36 #150 Aluminum oxide grinding stone, for fast plane grinding of metals >HV 250 on AbraPlan and MAPS. Grit 150. 356 mm (14") dia.</p>
40800178	<p>Grinding stone 3A36 #150 Aluminum oxide grinding stone, for fast plane grinding of nickel -based alloys (turbine blades) and stainless steels on AbraPlan and MAPS. Grit 150, 356 mm dia.</p>
40800074	<p>Grinding stone 2S36 #150 Silicon carbide grinding stone, for fast plane grinding of non-ferrous metals on AbraPlan and MAPS. Grit 150. 356 mm (14") dia.</p>
40800181	<p>Grinding stone 6A27 #150 Aluminum oxide grinding stone, for fast plane grinding of very hard steels/steels containing many carbides on Hexamatic Grit 150, 270 mm dia.</p>
40800179	<p>Grinding stone 4A27 #150 Aluminum oxide grinding stone, for fast plane grinding of metals >HV 250 on Hexamatic. Grit 150, 270 mm dia.</p>
40800182	<p>Grinding stone 3A27 #150 Aluminum oxide grinding stone, for fast plane grinding of nickel based alloys (turbine blades) and stainless steels on Hexamatic. Grit 150, 270 mm dia.</p>
40800180	<p>Grinding stone 2S27 #150 Silicon carbide grinding stone, for fast plane grinding of non-ferrous metals on Hexamatic. Grit 150, 270 mm dia.</p>
Diamond Grinding Discs	
40800183	<p>Diamond grinding disc 8D27 #120 Resin bonded diamond grinding disc, for fast plane grinding of ceramics and sintered carbides on Hexamatic. Grit 120, 270 mm dia.</p>

Diamond Grinding Discs

40800202	<p>Diamond grinding disc 8D36 #120 Resin bonded diamond disc, grooved in a square pattern. For plane grinding of ceramics and sintered carbides on AbraPlan and MAPS Grit 120. 356 mm (14") dia.</p>
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Diamond Cup Wheels, Discoplan

40800013	<p>Diamond Cup Wheel M0P15 For grinding of hard, brittle materials on Discoplan-TS. Metal bonded. 70 µm. 150 mm (6") dia. x 31.75 mm dia.</p>
40800014	<p>Diamond Cup Wheel B0P15 For grinding of hard, ductile materials on Discoplan-TS. Resin bonded. 35 µm. 150 mm (6") dia. x 31.75 mm dia.</p>

Cup Wheels for Accutom

40800083	<p>Diamond Cup Wheel B0P10 For grinding of hard and ductile materials on Accutom-100 and Accutom-50. Resin bond. Special flange set for cup wheel (06176902 for Accutom-100 or 05016901 for Accutom-50) is required. 40 µm. 100 mm (4") dia. x 12.7 mm dia.</p>
40800082	<p>Diamond Cup Wheel M0P10 For grinding of hard and brittle materials on Accutom-100 and Accutom-50. Metal bond. Special flange set for cup wheel (06176902 for Accutom-100 or 05016901 for Accutom-50) is required. 91 µm. 100 mm (4") dia. x 12.7 mm dia.</p>
40800185	40 µm. 100 mm (4") dia. x 12.7 mm dia.
40800184	25 µm. 100 mm (4") dia. x 12.7 mm dia.
40800120	<p>SiC Cup Wheel 10P13 SiC Cup Wheel, for grinding of ductile materials on Accutom-100 and Accutom-50. Resin bond. 125 µm. 130 mm (5") dia. x 12.7 mm dia.</p>
40800199	<p>Diamond cup wheel M0P15 For grinding of hard and brittle materials on Accutom-100. Metal bond. Special flange set for cup wheel (06176902) is required. 91 µm. 150 mm (6") dia. x 12.7 mm dia.</p>
40800200	40 µm. 150 mm (6") dia. x 12.7 mm dia.

Petrodisc-M

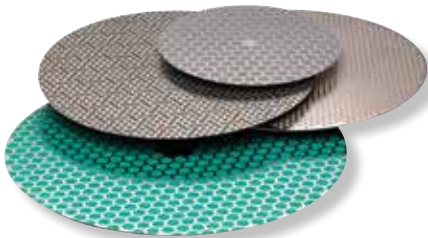
02426913	<p>Disc for one-step fine grinding of materials >HV 150, using diamonds. 230 mm (9") dia.</p>
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Others

40800045	<p>Diamond Point Diamond point for dressing tool. For Hexamatic, MAPS, AbraPlan-10/-20/-30, Prepamatic and Miniplan. 1 pcs. 5 mm dia.</p>
02606962	<p>Diamond point for dressing tool. Use 40800045 on AbraPlan-10/-20/-30 for best planeness. 1 pcs. 8 mm dia.</p>
02606901	<p>Diamond point for dressing tool, For Abraplan. 1 pcs. 8 mm dia.</p>

Others

40800044	<p>Dressing Stick Aluminum oxide stick for truing and opening of diamond and CBN cut-off wheels, diamond grinding discs and the grinding discs in the MD-System (not for use with MD-Piano 2000/4000).</p> <p>1 pcs.</p>
40800203	<p>Dressing specimen Aluminum oxide specimens for truing and opening of diamond grinding discs 8D27 and 8D36. To be clamped in specimen holder 05946906 for Hexamatic or 02606920 for AbraPlan.</p> <p>25 x 50 x 32 mm (1" x 2" x 1.25") 6 pcs.</p>
40800186	<p>Dressing Stick MD-Piano 2000/4000 Aluminum oxide stick for truing and opening of MD-Piano 2000 and 4000 diamond fine grinding discs.</p> <p>Dressing stick MD-Piano 2000/4000</p>



MD-fine Grinding Discs



MD-Mezzo Diamond Grinding Disc



MD-Molto Diamond Grinding Disc

MD Grinding

MD-Primo

40800085	<p>MD-Primo 120 Grinding disc for plane grinding of materials HV 40-250. Surface finish comparable to SiC-Paper grit 120. SiC abrasive embedded in a resin bond. For magnetic fixation on MD-Disc.</p> <p>200 mm (8") dia.</p>
40800086	250 mm (10") dia.
40800087	300 mm (12") dia.
40800118	350 mm (14") dia.
40800088	<p>MD-Primo 220 Grinding disc for plane grinding of materials HV 40-250. Surface finish comparable to SiC-Paper grit 220. SiC abrasive embedded in a resin bond. For magnetic fixation on MD-Disc.</p> <p>200 mm (8") dia.</p>
40800089	250 mm (10") dia.
40800090	300 mm (12") dia.

MD-Molto

40800187	<p>MD-Molto 220 Resin bonded diamond grinding disc for plane grinding of Aluminum alloys. Surface finish comparable to SiC Paper/Foil #220. For magnetic fixation on MD-Disc.</p> <p>200 mm (8") dia.</p>
40800188	250 mm (10") dia.
40800189	300 mm (12") dia.
40800190	350 mm (14") dia.

MD-Mezzo

40800191	MD-Mezzo 220 Resin bonded diamond grinding disc for plane grinding of titanium alloys. Surface finish comparable to SiC Paper/Foil #220. For magnetic fixation on MD-Disc. 200 mm (8") dia.
40800192	250 mm (10") dia.
40800193	300 mm (12") dia.
40800194	350 mm (14") dia.

MD-Piano

40800121	MD-Piano 80 Resin bonded diamond grinding disc for plane grinding of materials HV 150 - 2000. Surface finish comparable to SiC-Paper grit 80. For magnetic fixation on MD-Disc. 200 mm (8") dia.
40800122	250 mm (10") dia.
40800123	300 mm (12") dia.
40800124	350 mm (14") dia.
40800125	MD-Piano 120 Resin bonded diamond grinding disc for plane grinding of materials HV 150 - 2000. Surface finish comparable to SiC-Paper grit 120. For magnetic fixation on MD-Disc. 200 mm (8") dia.
40800126	250 mm (10") dia.
40800127	300 mm (12") dia.
40800128	350 mm (14") dia.
40800129	MD-Piano 220 Resin bonded diamond grinding disc for plane grinding of materials HV 150 - 2000. Surface finish comparable to SiC-Paper grit 220. For magnetic fixation on MD-Disc. 200 mm (8") dia.
40800130	250 mm (10") dia.
40800131	300 mm (12") dia.
40800132	350 mm (14") dia.
40800133	MD-Piano 500 Resin bonded diamond grinding disc for plane grinding of materials HV 150 - 2000. Surface finish comparable to SiC-Paper grit 500. For magnetic fixation on MD-Disc. 200 mm (8") dia.
40800134	250 mm (10") dia.
40800135	300 mm (12") dia.
40800136	350 mm (14") dia.
40800137	MD-Piano 1200 Resin bonded diamond grinding disc for fine grinding of materials HV 150 - 2000. Surface finish comparable to SiC-Paper grit 1200. For magnetic fixation on MD-Disc. 200 mm (8") dia.
40800138	250 mm (10") dia.
40800139	300 mm (12") dia.
40800140	350 mm (14") dia.
40800141	MD-Piano 2000 Resin bonded diamond grinding disc for ultra fine grinding of materials HV 150 - 2000. Surface finish comparable to SiC-Paper grit 2400. For magnetic fixation on MD-Disc. 200 mm (8")
40800142	250 mm (10")

MD-Piano

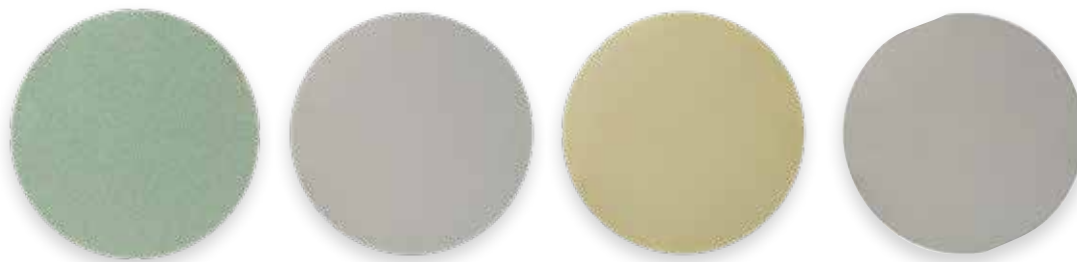
40800143	300 mm (12")
40800144	350 mm (14")
40800145	MD-Piano 4000 Resin bonded diamond grinding disc for ultra fine grinding of materials HV 150 - 2000. Surface finish comparable to SiC-Paper grit 4000. For magnetic fixation on MD-Disc. 200 mm (8")
40800146	250 mm (10")
40800147	300 mm (12")
40800148	350 mm (14")

MD-Allegro

40500134	Maintenance-free composite disc for one-step fine grinding of materials >HV 150, using diamonds. For magnetic fixation on MD-Disc. 200 mm (8") dia. 1 pc.
40500065	200 mm (8") dia. 5 pcs.
40500135	250 mm (10") dia. 1 pc.
40500066	250 mm (10") dia. 5 pcs.
40500136	300 mm (12") dia. 1 pc.
40500067	300 mm (12") dia. 5 pcs.
40500140	350 mm (14") dia. 5 pcs.

MD-Largo

40500137	Maintenance-free composite disc for one-step fine grinding of materials >HV 40, using diamonds. For ductile materials like non-ferrous metals and stainless steel, but also for brittle materials like ceramics and hard minerals. For magnetic fixation on MD-Disc. 200 mm (8") dia. 1 pc.
40500097	200 mm (8") dia. 5 pcs.
40500138	250 mm (10") dia. 1 pc.
40500098	250 mm (10") dia. 5 pcs.
40500139	300 mm (12") dia. 1 pc.
40500099	300 mm (12") dia. 5 pcs.
40500141	350 mm (14") dia. 5 pcs.



Diamond Pads

Diamond Pads

200 mm Diamond Pad

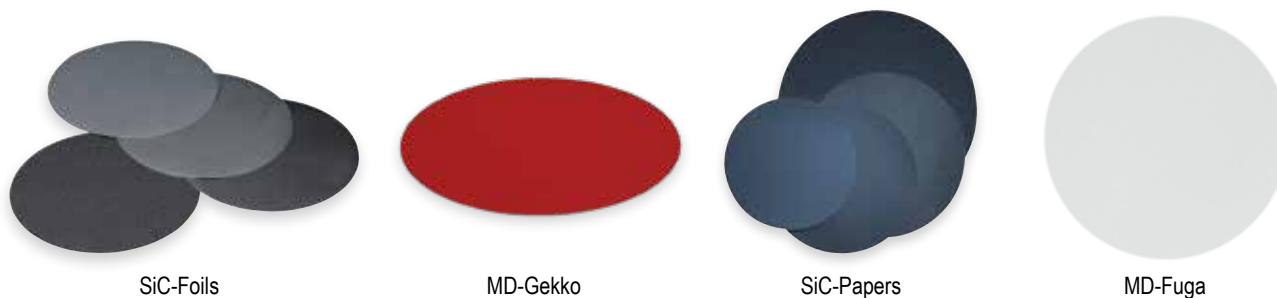
40800025	Diamond Pad Metal bonded diamond grinding pad, for grinding of hard materials (>HV 600). Self-adhesive. 250 µm. 200 mm (8") dia.
40800026	125 µm. 200 mm (8") dia.
40800027	40 µm. 200 mm (8") dia.
40800028	20 µm. 200 mm (8") dia.

250 mm Diamond Pad

40800033	Diamond Pad Metal bonded diamond grinding pad, for grinding of hard materials (>HV 600). Self-adhesive. 250 µm. 250 mm (10") dia.
40800034	125 µm. 250 mm (10") dia.
40800035	40 µm. 250 mm (10") dia.
40800036	20 µm. 250 mm (10") dia.

300 mm Diamond Pad

40800037	Diamond Pad Metal bonded diamond grinding pad, for grinding of hard materials (>HV 600). Self-adhesive. 250 µm. 300 mm (12") dia.
40800038	125 µm. 300 mm (12") dia.
40800039	40 µm. 300 mm (12") dia.
40800040	20 µm. 300 mm (12") dia.



SiC-Foils

MD-Gekko

SiC-Papers

MD-Fuga

Grinding Paper

200 mm SiC Foil

40400200	SiC Foil For wet grinding of materials (HV 30 – 800). PET foil backing, for use on MD-Gekko or Gekko PSA. Grit 80 (US #80). 200 mm (8") dia. 50 pcs.
40400201	Grit 120 (US #120). 200 mm (8") dia. 50 pcs.
40400202	Grit 180 (US #180). 200 mm (8") dia. 50 pcs.
40400203	Grit 220 (US #220). 200 mm (8") dia. 50 pcs.
40400204	Grit 320 (US #280). 200 mm (8") dia. 100 pcs.
40400205	Grit 500 (US #360). 200 mm (8") dia. 100 pcs.
40400206	Grit 800 (US #400). 200 mm (8") dia. 100 pcs.
40400207	Grit 1000 (US #500). 200 mm (8") dia. 100 pcs.
40400208	Grit 1200 (US #600). 200 mm (8") dia. 100 pcs.
40400209	For wet grinding of materials (HV 30 – 400). PET foil backing, for use on MD-Gekko or Gekko PSA. Grit 2000 (US #1000). 200 mm (8") dia. 50 pcs.
40400212	For wet grinding of materials (HV 30 – 400). Adhesive backing, for use on MD-Gekko or Gekko PSA. Grit 4000 (US #1200). 200 mm (8") dia. 50 pcs.

250 mm SiC Foil

40400220	SiC Foil For wet grinding of materials (HV 30 – 800). PET foil backing, for use on MD-Gekko or Gekko PSA. Grit 80 (US #80). 250 mm (10") dia. 50 pcs.
40400221	Grit 120 (US #120). 250 mm (10") dia. 50 pcs.
40400222	Grit 180 (US #180). 250 mm (10") dia. 50 pcs.
40400223	Grit 220 (US #220). 250 mm (10") dia. 50 pcs.
40400224	Grit 320 (US #320). 250 mm (10") dia. 100 pcs.
40400225	Grit 500 (US #360). 250 mm (10") dia. 100 pcs.
40400226	Grit 800 (US #400). 250 mm (10") dia. 100 pcs.
40400227	Grit 1000 (US #500). 250 mm (10") dia. 100 pcs.
40400228	Grit 1200 (US #600). 250 mm (10") dia. 100 pcs.
40400229	For wet grinding of materials (HV 30 – 400). PET foil backing, for use on MD-Gekko or Gekko PSA. Grit 2000 (US #1000). 250 mm (10") dia. 50 pcs.
40400232	For wet grinding of materials (HV 30 – 400). Adhesive backing, for use on MD-Gekko or Gekko PSA. Grit 4000 (US #1200). 250 mm (10") dia. 50 pcs.

300 mm SiC Foil

40400240	SiC Foil For wet grinding of materials (HV 30 – 800). PET foil backing, for use on MD-Gekko or Gekko PSA. Grit 80 (US #80). 300 mm (12") dia. 50 pcs.
40400241	Grit 120 (US #120). 300 mm (12") dia. 50 pcs.
40400242	Grit 180 (US #180). 300 mm (12") dia. 50 pcs.
40400243	Grit 220 (US #220). 300 mm (12") dia. 50 pcs.
40400244	Grit 320 (US #280). 300 mm (12") dia. 100 pcs.
40400245	Grit 500 (US #360). 300 mm (12") dia. 100 pcs.
40400246	Grit 800 (US #400). 300 mm (12") dia. 100 pcs.
40400247	Grit 1000 (US #500). 300 mm (12") dia. 100 pcs.
40400248	Grit 1200 (US #600). 300 mm (12") dia. 100 pcs.
40400249	For wet grinding of materials (HV 30 – 400). PET foil backing, for use on MD-Gekko or Gekko PSA. Grit 2000 (US #1000). 300 mm (12") dia. 50 pcs.
40400252	For wet grinding of materials (HV 30 – 400). Adhesive backing, for use on MD-Gekko or Gekko PSA. Grit 4000 (US #1200). 300 mm (12") dia. 50 pcs.

350 mm SiC Foil

40400260	SiC Foil For wet grinding of materials (HV 30 – 800). PET foil backing, for use on MD-Gekko or Gekko PSA. Grit 80 (US #80). 350 mm (14") dia. 50 pcs.
40400261	Grit 120 (US #120). 350 mm (14") dia. 50 pcs.
40400262	Grit 180 (US #180). 350 mm (14") dia. 50 pcs.
40400263	Grit 220 (US #220). 350 mm (14") dia. 50 pcs.
40400264	Grit 320 (US #280). 350 mm (14") dia. 100 pcs.
40400265	Grit 500 (US #360). 350 mm (14") dia. 100 pcs.
40400266	Grit 800 (US #400). 350 mm (14") dia. 100 pcs.
40400267	Grit 1000 (US #500). 350 mm (14") dia. 100 pcs.
40400268	Grit 1200 (US #600). 350 mm (14") dia. 100 pcs.
40400269	For wet grinding of materials (HV 30 – 400). PET foil backing, for use on MD-Gekko or Gekko PSA. Grit 2000 (US #1000). 350 mm (14") dia. 50 pcs.
40400272	For wet grinding of materials (HV 30 – 400). Adhesive backing, for use on MD-Gekko or Gekko PSA. Grit 4000 (US #1200). 350 mm (14") dia. 50 pcs.

MD-Gekko

49900047	MD-Gekko Adapter for use with SiC Foil or self adhesive consumables on the MD-System, for easy removal. For magnetic fixation on MD-Disc. 200 mm dia. 2 pcs.
49900048	250 mm dia. 2 pcs.
49900049	300 mm dia. 2 pcs.
49900050	350 mm dia. 2 pcs.
49900053	Gekko PSA Self adhesive Gekko Foil for use with SiC Foil or self adhesive consumables. To be glued on an Aluminum disc. 200 mm dia. 2 pcs.
49900054	250 mm dia. 2 pcs.

MD-Gekko

49900055 300 mm dia. 2 pcs.

200 mm SiC Paper

40400056 **Silicon Carbide Grinding Paper**
For wet grinding of materials (HV 30 - 800). Plain back.

Grit 80 (US #80). 200 mm (8") dia. 50 pcs.

40400057 Grit 120 (US #120). 200 mm (8") dia. 50 pcs.

40400058 Grit 180 (US #180). 200 mm (8") dia. 50 pcs.

40400125 Grit 220 (US #220). 200 mm (8") dia. 50 pcs.

40400008 Grit 320 (US #280). 200 mm (8") dia. 100 pcs.

40400009 Grit 500 (US #360). 200 mm (8") dia. 100 pcs.

40400010 Grit 800 (US #400). 200 mm (8") dia. 100 pcs.

40400011 Grit 1000 (US #500). 200 mm (8") dia. 100 pcs.

40400012 Grit 1200 (US #600). 200 mm (8") dia. 100 pcs.

40400181 For wet grinding of materials (HV 30 - 400). Plain back

Grit 2000 (US #1000). 200 mm (8") dia. 50 pcs.

40400013 Grit 2400 (US #1200). 200 mm (8") dia. 50 pcs.

40400014 Grit 4000 (US #1200). 200 mm (8") dia. 50 pcs.

230 mm SiC Paper

40400059 **Silicon Carbide Grinding Paper**
For wet grinding of materials (HV 30 - 800). Plain back.

Grit 80 (US #80). 230 mm (9") dia. 50 pcs.

40400060 Grit 120 (US #120). 230 mm (9") dia. 50 pcs.

40400061 Grit 180 (US #180). 230 mm (9") dia. 50 pcs.

40400126 Grit 220 (US #220). 230 mm (9") dia. 50 pcs.

40400019 Grit 320 (US #280). 230 mm (9") dia. 100 pcs.

40400020 Grit 500 (US #360). 230 mm (9") dia. 100 pcs.

40400021 Grit 800 (US #400). 230 mm (9") dia. 100 pcs.

40400022 Grit 1000 (US #500). 230 mm (9") dia. 100 pcs.

40400023 Grit 1200 (US #600). 230 mm (9") dia. 100 pcs.

40400024 For wet grinding of materials (HV 30 - 400). Plain back.

Grit 2400 (US #1200). 230 mm (9") dia. 50 pcs.

40400025 Grit 4000 (US #1200). 230 mm (9") dia. 50 pcs.

40400183 Grit 2000 (US #1000). 230 mm (9") dia. 50 pcs.

250 mm SiC Paper

40400065 **Silicon Carbide Grinding Paper**
For wet grinding of materials (HV 30 - 800). Plain back.

Grit 80 (US #80). 250 mm (10") dia. 50 pcs.

40400066 Grit 120 (US #120). 250 mm (10") dia. 50 pcs.

40400067 Grit 180 (US #180). 250 mm (10") dia. 50 pcs.

40400127 Grit 220 (US #220). 250 mm (10") dia. 50 pcs.

40400069 Grit 320 (US #280). 250 mm (10") dia. 100 pcs.

40400070 Grit 500 (US #360). 250 mm (10") dia. 100 pcs.

40400071 Grit 800 (US #400). 250 mm (10") dia. 100 pcs.

40400072 Grit 1000 (US #500). 250 mm (10") dia. 100 pcs.

250 mm SiC Paper

40400073	Grit 1200 (US #600). 250 mm (10") dia. 100 pcs.
40400185	For wet grinding of materials (HV 30 - 400). Plain back. Grit 2000 (US #1000). 250 mm (10") dia. 50 pcs.
40400026	Grit 2400 (US #1200). 250 mm (10") dia. 50 pcs.
40400027	Grit 4000 (US #1200). 250 mm (10") dia. 50 pcs.

305 mm SiC Paper

40400062	Silicon Carbide Grinding Paper For wet grinding of materials (HV 30 - 800). Plain back. Grit 80 (US #80). 305 mm (12") dia. 50 pcs.
40400063	Grit 120 (US #120). 305 mm (12") dia. 50 pcs.
40400064	Grit 180 (US #180). 305 mm (12") dia. 50 pcs.
40400128	Grit 220 (US #220). 305 mm (12") dia. 50 pcs.
40400032	Grit 320 (US #280). 305 mm (12") dia. 100 pcs.
40400033	Grit 500 (US #360). 305 mm (12") dia. 100 pcs.
40400034	Grit 800 (US #400). 305 mm (12") dia. 100 pcs.
40400035	Grit 1000 (US #500). 305 mm (12") dia. 100 pcs.
40400036	Grit 1200 (US #600). 305 mm (12") dia. 100 pcs.
40400187	For wet grinding of materials (HV 30 - 400). Plain back. Grit 2000 (US #1000). 305 mm (12") dia. 50 pcs.
40400037	Grit 2400 (US #1200). 305 mm (12") dia. 50 pcs.
40400038	Grit 4000 (US #1200). 305 mm (12") dia. 50 pcs.

MD-Fuga

49900021	Metal disc with an adhesive layer for holding plain grinding papers. Can be used repeatedly. For magnetic fixation on MD-Disc. 200 mm (8") dia. 5 pcs.
49900022	250 mm (10") dia. 5 pcs.
49900023	300 mm (12") dia. 5 pcs.

Adhesives for Grinding Paper

49900006	Adhesive Discs Double-sided adhesive discs for easy adhesion of plain grinding papers on grinding/polishing discs. Can be used repeatedly. 200 mm (8") dia. 10 pcs.
49900007	230 mm (9") dia. 10 pcs.
49900015	250 mm (10") dia. 10 pcs.
49900008	300 mm (12") dia. 10 pcs.

Other Grinding Paper

40400041	Silicon Carbide Grinding Paper For wet grinding of materials (HV 30 - 800) on Lunn-Major and Lunn-Labor. Roll. Plain back. Grit 220 (US #220). 18 m x 7.5 cm
40400042	Grit 320 (US #280). 20 m x 7.5 cm
40400043	Grit 500 (US #360). 20 m x 7.5 cm
40400044	Grit 1000 (US #500). 25 m x 7.5 cm



Diamond film

Abrasive Film

Diamond Film	
40400180	For polishing with TriPod polishing fixture. PET foil backing. 0.1 μm . 200 mm (8") dia. 5 pcs.
40400179	0.5 μm . 200 mm (8") dia. 5 pcs.
40400178	1 μm . 200 mm (8") dia. 5 pcs.
40400177	3 μm . 200 mm (8") dia. 5 pcs.
40400176	6 μm . 200 mm (8") dia. 5 pcs.
40400175	9 μm . 200 mm (8") dia. 5 pcs.
40400174	15 μm . 200 mm (8") dia. 5 pcs.
40400173	30 μm . 200 mm (8") dia. 5 pcs.
Aluminum Oxide Film	
40400172	For polishing with TriPod polishing fixture. PET foil backing. 0.05 μm . 200 mm (8") dia. 50 pcs.
40400170	0.3 μm . 200 mm (8") dia. 50 pcs.
40400169	1 μm . 200 mm (8") dia. 50 pcs.







Polishing

Removing deformation and obtaining a highly reflective surface requires different abrasives and polishing cloths with different resilience.

And the ideal way to ensure premium polishing performance is to use Struers consumables with our equipment.

That's because each machine and consumable is designed to work together to control all parameters of the polishing process – helping you get the most out of your investment.

Choose your cloth, diamond grain size and lubricant depending on the material you're polishing. Whether you're interested in Oxide Polishing or Diamond Polishing, Struers has what you need.

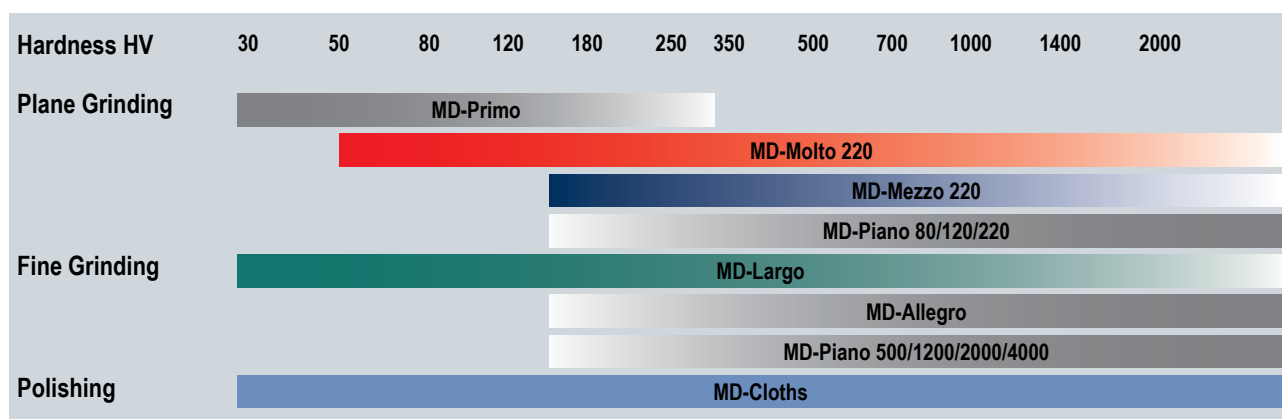
DiaPro efficiency

DiaPro is a line of diamond suspensions specially developed for extra-high performance and efficiency - reducing preparation times by 30% on average. Each DiaPro suspension has been developed and optimised for a specific surface, delivering exceptional planeness, edge retention and reproducibility.

Only Struers consumables are designed to get the most out of Struers equipment.

Selection Guide for MD-Polishing Cloth

Cloth	Characteristics	Recommended use	Abrasive range	Resilience	Hardness
MD-Plan	Coated, woven polyester	Fine grinding of soft metals Pre-polishing of hard materials	15 - 3 μm	Very low	Hard
MD-Pan	Impregnated, non-woven technical textile	Fine grinding of soft metals Pre-polishing of hard and brittle materials	15 - 1 μm	Very low	Hard
MD-Sat	Woven acetate	Fine grinding and polishing of ferrous metals, non-ferrous metals, coatings and plastics	9 - 1 μm	Medium	Hard
MD-Dur	Satin woven natural silk	Fine grinding and polishing of ferrous metals, non-ferrous metals, coatings and plastics	9 - 1 μm	Medium	Hard
MD-Dac	Satin woven acetate	Polishing of all materials	9 - 3 μm	Medium	Hard
MD-Mol MD-Mol APS	Taffeta woven 100 % wool	Polishing of ferrous and non-ferrous metals and polymers APS for Automatic Preparation Systems	$\leq 3 \mu\text{m}$	High	Soft
MD-Plus	Synthetic nap	One step polishing for sintered carbides and steels	$\leq 3 \mu\text{m}$	High	Soft
MD-Floc	Synthetic nap	Polishing of all materials	$\leq 3 \mu\text{m}$	Very high	Very soft
MD-Nap	Synthetic short nap	Final polishing of all materials	$\leq 1 \mu\text{m}$	Very high	Very soft
MD-Chem / MD-Chem NonStick	Porous neoprene	Final polishing of all materials		High	Soft



Metalogram Instructions

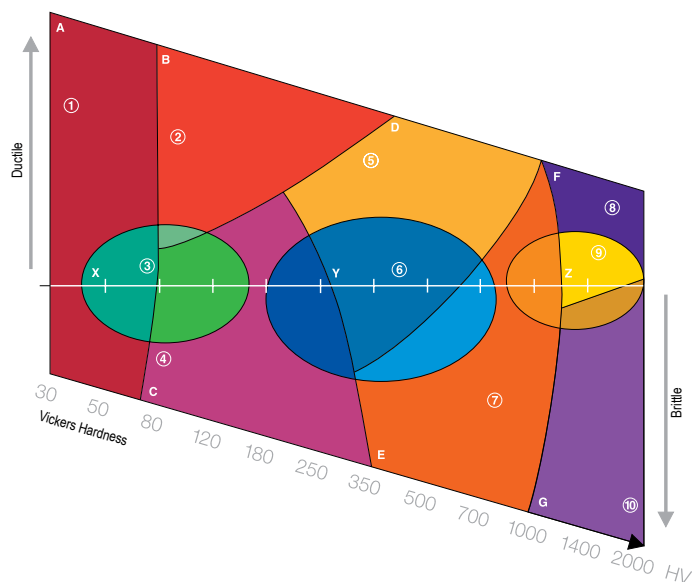
The Metalogram is our way of creating generic methods based on the two parameters, ductility and hardness.

The selection of a preparation method in the Metalogram depends on these two properties:

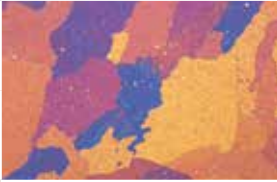








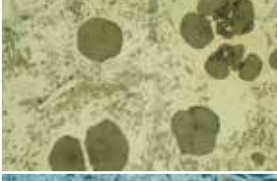











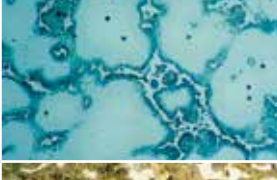








- Hardness: the easiest attribute to measure but is not sufficient information about a material to find the correct preparation method.
- Ductility: the ability of a material to deform plastically and is far more important. How does a material actually respond to mechanical abrasion? Is it easily deformed, or do we get cracks and pull-outs during preparation?

Description of the Metalogram

The x-axis represents the hardness in Vickers. The values are not shown in a linear way because the variety of preparation methods for softer materials is greater than for hard ones. The shape of the Metalogram results from soft materials generally being more ductile and hard materials usually being more brittle.



Preparation Methods Overview

			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-A 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

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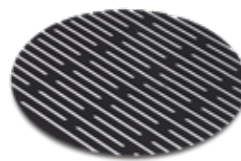
TEST BLOCKS



MD-Polishing Cloths



DP-Nap



MD-Chem NonStick

MD-Polishing Cloths

MD-Plan

40500086	Polishing cloth for fine grinding of soft metals and pre-polishing of hard materials. Coated woven polyester. For magnetic fixation on MD-Disc. 200 mm (8") dia. 5 pcs.
40500087	250 mm (10") dia. 5 pcs.
40500088	300 mm (12") dia. 5 pcs.
40500147	350 mm (14") dia. 5 pcs.

MD-Pan

40500157	Polishing cloth for fine grinding of soft metals and pre-polishing of hard and brittle materials. Impregnated non-woven technical textile. For magnetic fixation on MD-Disc. 200 mm (8") dia. 5 pcs.
40500158	250 mm (10") dia. 5 pcs.
40500159	300 mm (12") dia. 5 pcs.
40500160	350 mm (14") dia. 5 pcs.

MD-Sat

40500406	Polishing cloth for fine grinding and polishing of ferrous and non-ferrous metals, coatings and plastics. Is used for diamond with particle size 9 - 3 μm . Woven acetate. For magnetic fixation on MD-Disc. 200 mm (8") dia. 5 pcs.
40500407	250 mm (10") dia. 5 pcs.
40500408	300 mm (12") dia. 5 pcs.

MD-Dur

40500074	Polishing cloth for fine grinding and polishing of ferrous metals, non-ferrous metals, coatings, plastics. Satin woven natural silk. For magnetic fixation on MD-Disc. 200 mm (8") dia. 5 pcs.
40500075	250 mm (10") dia. 5 pcs.
40500076	300 mm (12") dia. 5 pcs.
40500149	350 mm (14") dia. 5 pcs.

MD-Dac

40500071	Polishing cloth for polishing of all materials. Is used for diamond with particle size 9 - 3 μm . Satin woven acetate. For magnetic fixation on MD-Disc. 200 mm (8") dia. 5 pcs.
40500095	250 mm (10") dia. 5 pcs.
40500073	300 mm (12") dia. 5 pcs.
40500150	350 mm (14") dia. 5 pcs.

MD-Mol

40500077	Polishing cloth for polishing of ferrous and non-ferrous metals and polymers. Taffeta woven 100 % wool. For magnetic fixation on MD-Disc. 200 mm (8") dia. 5 pcs.
40500078	250 mm (10") dia. 5 pcs.
40500079	300 mm (12") dia. 5 pcs.
40500152	350 mm (14") dia. 5 pcs.

MD-Mol APS

40500155	Polishing cloth to be used on automatic preparation systems for polishing of ferrous and non-ferrous metals and polymers. Taffeta woven 100 % wool. For magnetic fixation on MD-Disc. 300 mm (12") dia. 5 pcs.
40500156	350 mm (14") dia. 5 pcs.

MD-Plus

40500089	Polishing cloth for one step polishing of sintered carbides and steels. Synthetic nap. For magnetic fixation on MD-Disc. 200 mm (8") dia. 5 pcs.
40500090	250 mm (10") dia. 5 pcs.
40500091	300 mm (12") dia. 5 pcs.
40500151	350 mm (14") dia. 5 pcs.

MD-Floc

40500403	Polishing cloth for polishing of all materials. Synthetic nap. For magnetic fixation on MD-Disc. 200 mm (8") dia. 5 pcs.
40500404	250 mm (10") dia. 5 pcs.
40500405	300 mm (12") dia. 5 pcs.
40500419	350 mm (14") dia. 5 pcs.

MD-Nap

40500080	Polishing cloth for final polishing of all materials. Short synthetic nap. For magnetic fixation on MD-Disc. 200 mm (8") dia. 5 pcs.
40500081	250 mm (10") dia. 5 pcs.
40500082	300 mm (12") dia. 5 pcs.
40500153	350 mm (14") dia. 5 pcs.

MD-Chem

40500092	Polishing cloth for final polishing of all materials. Porous neoprene. For magnetic fixation on MD-Disc. 200 mm (8") dia. 5 pcs.
40500093	250 mm (10") dia. 5 pcs.
40500094	300 mm (12") dia. 5 pcs.
40500154	350 mm (14") dia. 5 pcs.

MD-Chem NonStick

40500410	Polishing cloth for final polishing of all materials. Porous neoprene with grooves to prevent adhesion of large specimens. For magnetic fixation on MD-Disc. 300 mm (12") dia. 5 pcs.
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DP/OP-Polishing Cloths



OP-Nat



MD-Rondo

DP/OP-Polishing Cloths

DP-Plan

40500200	Polishing cloth for fine grinding of soft metals and pre-polishing of hard materials. Is used for diamond with particle size 15 - 3 μm . Coated, woven polyester. Self-adhesive. 200 mm (8") dia. 5 pcs.
40500201	250 mm (10") dia. 5 pcs.
40500202	300 mm (12") dia. 5 pcs.

DP-Pan

40500161	Polishing cloth for fine grinding of soft metals and pre-polishing of hard and brittle materials. Impregnated non-woven technical textile. Self-adhesive. 200 mm (8") dia. 5 pcs.
40500162	250 mm (10") dia. 5 pcs.
40500163	300 mm (12") dia. 5 pcs.

DP-Sat

40500216	Polishing cloth for fine grinding and polishing of ferrous and non-ferrous metals, coatings and plastics. Is used for diamond with particle size 9 - 3 μm . Woven acetate. Self-adhesive. 200 mm (8") dia. 5 pcs.
40500217	250 mm (10") dia. 5 pcs.
40500218	300 mm (12") dia. 5 pcs.

DP-Dur

40500208	Polishing cloth for fine grinding and polishing of ferrous and non-ferrous metals, coatings and plastics. Is used for diamond with particle size 9 - 1 μm . Satin woven natural silk. Self-adhesive. 200 mm (8") dia. 5 pcs.
40500209	250 mm (10") dia. 5 pcs.
40500210	300 mm (12") dia. 5 pcs.

DP-Dac

40500212	Polishing cloth for polishing of all materials. Is used for diamond with particle size 9 - 3 μm . Satin woven acetate. Self-adhesive. 200 mm (8") dia. 5 pcs.
40500213	250 mm (10") dia. 5 pcs.
40500214	300 mm (12") dia. 5 pcs.

DP-Mol

40500220	Polishing cloth for polishing of ferrous and non-ferrous metals and polymers. Taffeta woven 100 % wool. Self-adhesive. 200 mm (8") dia. 5 pcs.
40500221	250 mm (10") dia. 5 pcs.
40500222	300 mm (12") dia. 5 pcs.

DP-Plus

40500224	Polishing cloth for one step polishing of sintered carbides and steels. Synthetic nap. Self-adhesive. 200 mm (8") dia. 5 pcs.
40500225	250 mm (10") dia. 5 pcs.
40500226	300 mm (12") dia. 5 pcs.

DP-Floc

40500228	Polishing cloth for polishing of all materials. Synthetic nap. Self-adhesive. 200 mm (8") dia. 5 pcs.
40500229	250 mm (10") dia. 5 pcs.
40500230	300 mm (12") dia. 5 pcs.

DP-Nap

40500232	Polishing cloth for final polishing of all materials. Short synthetic nap. Self-adhesive. 200 mm (8") dia. 5 pcs.
40500233	250 mm (10") dia. 5 pcs.
40500234	300 mm (12") dia. 5 pcs.

OP-Felt

40500300	Polishing cloth for polishing of ferrous and non-ferrous metals. Is used for alumina with particle size $\leq 9 \mu\text{m}$. Thick wool felt. Self-adhesive. 200 mm (8") dia. 5 pcs.
40500301	250 mm (10") dia. 5 pcs.
40500302	300 mm (12") dia. 5 pcs.

OP-Nat

40500304	Polishing cloth for polishing of ferrous metals. Is used for alumina with particle size $\leq 9 \mu\text{m}$. Woven wool felt. Self-adhesive. 200 mm (8") dia. 5 pcs.
40500305	250 mm (10") dia. 5 pcs.
40500306	300 mm (12") dia. 5 pcs.

OP-Chem

40500308	Polishing cloth for final polishing of all materials. Is used for oxide polishing with particle size $< 1 \mu\text{m}$. Porous neoprene. Self-adhesive. 200 mm (8") dia. 5 pcs.
40500309	250 mm (10") dia. 5 pcs.
40500310	300 mm (12") dia. 5 pcs.

MD-Rondo

40503000	Adapter disc for application of self-adhesive consumables to MD-Disc. 200 mm (8") dia. 5 pcs.
40503001	250 mm (10") dia. 5 pcs.
40503002	300 mm (12") dia. 5 pcs.
40503082	350 mm (14") dia. 5 pcs.



Diamond products



DiaPro

Diamond Products

DiaPro

40600375	DiaPro Pan 15 μm For high-performance materialographic pre-polishing on MD-Pan and DP-Pan. Stable diamond suspension containing a unique mixture of high-performance diamonds and cooling lubricant. Apply DiaPro to achieve the correct level of lubrication. 500 ml
40600376	5 l
40600369	DiaPro Allegro/Largo 9 μm For high-performance materialographic fine grinding on MD-Allegro and MD-Largo. Stable diamond suspension containing a unique mixture of high-performance diamonds and cooling lubricant. Apply DiaPro to achieve the correct level of lubrication. 500 ml
40600370	5 l

DiaPro	
40600385	<p>DiaPro Plan 9 µm For high-performance materialographic fine grinding on MD-Plan and DP-Plan. Stable diamond suspension containing a unique mixture of high-performance diamonds and cooling lubricant. Apply DiaPro to achieve the correct level of lubrication.</p> <p>500 ml</p>
40600386	5 l
40600377	<p>DiaPro Sat 6 µm For high-performance materialographic polishing on MD-Sat and DP-Sat. Stable diamond suspension containing a unique mixture of high-performance diamonds and cooling lubricant. Apply DiaPro to achieve the correct level of lubrication.</p> <p>500 ml</p>
40600378	5 l
40600391	<p>DiaPro Largo 3 µm For high-performance materialographic polishing on MD-Largo. Stable diamond suspension containing a unique mixture of high-performance diamonds and cooling lubricant. Apply DiaPro to achieve the correct level of lubrication.</p> <p>500 ml</p>
40600392	5 l
40600379	<p>DiaPro Mol B 3 µm For high-performance materialographic polishing of hard materials (>150 HV) on MD-Mol and DP-Mol. Stable diamond suspension containing a unique mixture of high-performance diamonds and cooling lubricant. Apply DiaPro to achieve the correct level of lubrication.</p> <p>500 ml</p>
40600380	5 l
40600393	<p>DiaPro Mol R 3 µm For high-performance materialographic polishing of soft materials (<150 HV) on MD-Mol and DP-Mol. Stable diamond suspension containing a unique mixture of high-performance diamonds and smearing lubricant. Apply DiaPro to achieve the correct level of lubrication.</p> <p>500 ml</p>
40600394	5 l
40600395	<p>DiaPro Dur 3 µm For high-performance materialographic polishing on MD-Dur and DP-Dur. Stable diamond suspension containing a unique mixture of high-performance diamonds and cooling lubricant. Apply DiaPro to achieve the correct level of lubrication.</p> <p>500 ml</p>
40600396	5 l
40600371	<p>DiaPro Dac 3 µm For high-performance materialographic polishing on MD-Dac and DP-Dac. Stable water-based diamond suspension containing a unique mixture of high-performance diamonds and cooling lubricant. Apply DiaPro to achieve the correct level of lubrication.</p> <p>500 ml</p>
40600372	5 l
40600387	<p>DiaPro Plus 3 µm For high-performance materialographic polishing on MD-Plus and DP-Plus. Stable diamond suspension containing a unique mixture of high-performance diamonds and cooling lubricant. Apply DiaPro to achieve the correct level of lubrication.</p> <p>500 ml</p>
40600388	5 l

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DiaPro

40600389	<p>DiaPro Floc 3 µm For high-performance materialographic polishing on MD-Floc and DP-Floc. Stable diamond suspension containing a unique mixture of high-performance diamonds and cooling lubricant. Apply DiaPro to achieve the correct level of lubrication.</p> <p>500 ml</p>
40600390	5 l
40600381	<p>DiaPro Dur 1 µm For high-performance materialographic polishing on MD-Dur and DP-Dur. Stable diamond suspension containing a unique mixture of high-performance diamonds and cooling lubricant. Apply DiaPro to achieve the correct level of lubrication.</p> <p>500 ml</p>
40600382	5 l
40600373	<p>DiaPro Nap B 1 µm For high-performance materialographic polishing of hard materials (>150 HV) on MD-Nap and DP-Nap. Stable water-based diamond suspension containing a unique mixture of high-performance diamonds and cooling lubricant. Apply DiaPro to achieve the correct level of lubrication.</p> <p>500 ml</p>
40600374	5 l
40600397	<p>DiaPro Nap R 1 µm For high-performance materialographic polishing of soft materials (<150 HV) on MD-Nap and DP-Nap. Stable diamond suspension containing a unique mixture of high-performance diamonds and smearing lubricant. Apply DiaPro to achieve the correct level of lubrication.</p> <p>500 ml</p>
40600398	5 l
40600383	<p>DiaPro Nap ¼ µm For high-performance materialographic polishing on MD-Nap and DP-Nap. Stable diamond suspension containing a unique mixture of high-performance diamonds and cooling lubricant. Apply DiaPro to achieve the correct level of lubrication.</p> <p>500 ml</p>
40600384	5 l



DP-Suspension P



DP-Suspension M



DP-Suspension A

DP-Suspension P

40600229	<p>Stable water-based polycrystalline diamond suspension in pump bottle for manual application. To be used in combination with DP-Lubricants. Lubricants ensure correct cooling and smearing of the material surface.</p> <p>1 µm. 125 ml</p>
40600228	3 µm. 125 ml
40600227	6 µm. 125 ml

DP-Suspension P

40600364 High performance diamond product containing exclusively polycrystalline diamonds. Stable suspension, designed for automatic dosing machines.

0.1 µm. 500 ml

40600363 ¼ µm. 500 ml

40600297 ¼ µm. 2.5 l

40600362 1 µm. 500 ml

40600251 1 µm. 2.5 l

40600342 1 µm. 5 l

40600361 3 µm. 500 ml

40600250 3 µm. 2.5 l

40600341 3 µm. 5 l

40600360 6 µm. 500 ml

40600249 6 µm. 2.5 l

40600340 6 µm. 5 l

40600359 9 µm. 500 ml

40600248 9 µm. 2.5 l

40600339 9 µm. 5 l

40600358 15 µm. 500 ml

40600247 15 µm. 2.5 l

DP-Suspension M

40600357 High performance diamond product containing monocrystalline diamonds. Stable suspension, designed for automatic dosing machines.

1 µm. 500 ml

40600256 1 µm. 2.5 l

40600346 1 µm. 5 l

40600356 3 µm. 500 ml

40600255 3 µm. 2.5 l

40600345 3 µm. 5 l

40600355 6 µm. 500 ml

40600254 6 µm. 2.5 l

40600344 6 µm. 5 l

40600354 9 µm. 500 ml

40600253 9 µm. 2.5 l

40600343 9 µm. 5 l

40600353 15 µm. 500 ml

40600252 15 µm. 2.5 l

DP-Suspension A

40600352*** High performance diamond product containing polycrystalline diamonds. Alcohol based. Water content < 0.5 % w/w. For highest efficiency in materiallographic polishing of water sensitive materials. Stable suspension.

¼ µm. 500 ml

40600351*** 1 µm. 500 ml

40600350*** 3 µm. 500 ml

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DP-Suspension A

40600349*** High performance diamond product containing M+ diamonds. Alcohol based. Water content < 0.5 % w/w. For highest efficiency in materiallographic fine grinding and polishing of water sensitive materials. Stable suspension.

6 µm. 500 ml

40600348*** 9 µm. 500 ml

40600347*** 15 µm. 500 ml



DiaDuo



DP-Spray, M and P



DP-Stick P



DP-Paste P

DiaDuo

40600036

DiaDuo-2

All-purpose diamond suspension for materiallographic fine grinding and polishing. Diamond suspension and cooling lubricant combined into one product. Does not contain solvents

1 µm. White. 500 ml

40600041 1 µm. White. 5 l

40600037 3 µm. Blue. 500 ml

40600042 3 µm. Blue. 5 l

40600038 6 µm. Yellow. 500 ml

40600043 6 µm. Yellow. 5 l

40600039 9 µm. Grey. 500 ml

40600044 9 µm. Grey. 5 l

40600040 15 µm. Green. 500 ml

40600045 15 µm. Green. 5 l

DP-Spray P

40600144*** High performance diamond product containing exclusively polycrystalline diamonds. In spray can
1/4 µm. 150 ml

40600145*** 1 µm. 150 ml

40600146*** 3 µm. 150 ml

40600147*** 6 µm. 150 ml

40600148*** 9 µm. 150 ml

40600149*** 15 µm. 150 ml

40600150*** 35 µm. 150 ml

DP-Spray M

40600151*** High performance diamond product containing monocrystalline diamonds. In spray can.

1 µm. 150 ml

40600152*** 3 µm. 150 ml

40600153*** 6 µm. 150 ml

40600154*** 9 µm. 150 ml

40600155*** 15 µm. 150 ml

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DP-Stick P	
40600313	Diamond wax in stick applicator. To be used in combination with DP-Lubricants. Lubricants ensure correct cooling and lubricating of the material surface ¼ µm. 24 g
40600312	1 µm. 24 g
40600311	3 µm. 24 g
40600310	6 µm. 24 g
40600309	9 µm. 24 g
40600308	15 µm. 24 g

DP-Paste P	
40600028	High performance diamond product containing exclusively polycrystalline diamonds. In cartridge ¼ µm. 10 g
40600027	1 µm. 10 g
40600026	3 µm. 10 g
40600025	6 µm. 10 g
40600024	9 µm. 10 g
40600023	15 µm. 10 g

DP-Paste M	
40600020	High performance diamond product containing monocrystalline diamonds. In cartridge ¼ µm. 10 g
40600019	1 µm. 10 g
40600018	3 µm. 10 g
40600017	6 µm. 10 g
40600016	9 µm. 10 g
40600015	15 µm. 10 g



DP-Lubricant Green



DP-Lubricant Blue



DP-Lubricant Purple



DP-Lubricant Red



DP-Lubricant Brown



DP-Lubricant Yellow

DP-Lubricant	
40700023	DP-Lubricant Green Cooling and lubricating agent for fine grinding and diamond polishing of most materials. Water based 1 l
40700024	5 l
40700055	10 l
40700005***	DP-Lubricant Blue Cooling and lubricating agent for fine grinding and diamond polishing of most materials. Alcohol-based with ethanediol 1 l
40700006***	5 l
40700056***	10 l

DP-Lubricant

40700059***	DP-Lubricant Purple Cooling and lubricating agent for fine grinding and diamond polishing of most materials. Alcohol-based with propylene glycol 1 l
40700060***	5 l
40700061***	10 l
40700070	DP-Lubricant Red Lubricating agent for fine grinding and diamond polishing of softer materials. Oil in water emulsion 1 l
40700071	5 l
40700072	10 l
40700028***	DP-Lubricant Brown Cooling and lubricating agent for fine grinding and diamond polishing of water sensitive materials. Alcohol-based with polyethylene glycol 1 l
40700069***	DP-Lubricant Yellow Lubricating agent for fine grinding and diamond polishing of softer water sensitive materials. Alcohol-based 1 l

Others

40700031	Dosing Gun For dosing a specific amount of all diamond suspensions and lubricants. Non-aerosol pressurized dosing bottle 500 ml
40700068	Pump Bottle For manual dispensing of diamond suspension or lubricant 150 ml
40700032	Squeeze Bottle For manual dosing of diamond suspension or lubricant 250 ml

Avoid deformation and severe scratches when preparing soft and ductile copper and copper alloys

Get recommendations for how to avoid mechanical deformation using fine grits, soft cloths and chemically assisted final polishing.

Click and
find out





OP-S NonDry



OP-S



AP-A Powder

Final Polishing

OP-S NonDry

40700064	Non-drying colloidal silica suspension for final polishing. Suitable for mixing with chemical reagents for polishing of resistant materials. Ready to use. For preparing on pure non-ferrous metals the regular OP-S is recommended. 0.25 µm. 1 l
40700065	0.25 µm. 5 l

OP-S

40700000	Standard colloidal silica suspension for final polishing. Suitable for mixing with chemical reagents for polishing of resistant materials. Ready to use. 0.25 µm. 1 l
40700001	0.25 µm. 5 l

OP-U NonDry

40700066	Non-drying colloidal silica suspension for final polishing of all materials. Ready to use 0.04 µm. 1 l
40700067	0.04 µm. 5 l

OP-U

40700002	Standard colloidal silica suspension for final polishing of all materials. Ready to use. 0.04 µm. 1 l
40700003	0.04 µm. 5 l

OP-A

40700021	Acidic alumina suspension for final polishing of low- and high-alloy steels, nickel-base alloys and ceramics. Concentrated 0.1 µm. 500 ml
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AP-Products

40700049	AP-A Powder Agglomerated alpha alumina powder for polishing. To be mixed with demineralized water before use 0.3 µm. 1 kg
40700048	1 µm. 1 kg
40700047	5 µm. 1 kg

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AP-Products

40700041	AP-D Powder Deagglomerated gamma alumina powder for polishing. To be mixed with demineralized water before use 0.05 µm. 1 kg
40700040	Deagglomerated alpha alumina powder for polishing. To be mixed with demineralized water before use 0.1 µm. 1 kg
40700039	0.3 µm. 1 kg
40700038	1 µm. 1 kg

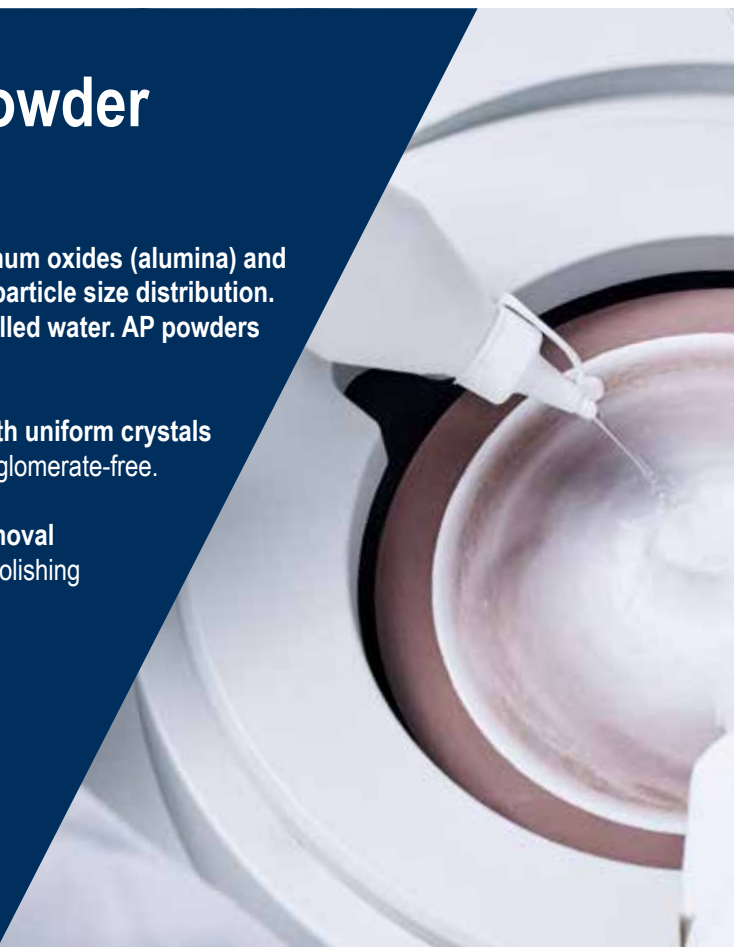
Our Popular AP Powder for Final Polishing

AP powders are based on ultra-pure aluminum oxides (alumina) and consist of uniform particles with a narrow particle size distribution. The powders can easily be mixed with distilled water. AP powders are available in two forms:

AP-D deagglomerated: Ultrafine surface with uniform crystals
Alumina of premium polishing abrasive are agglomerate-free.

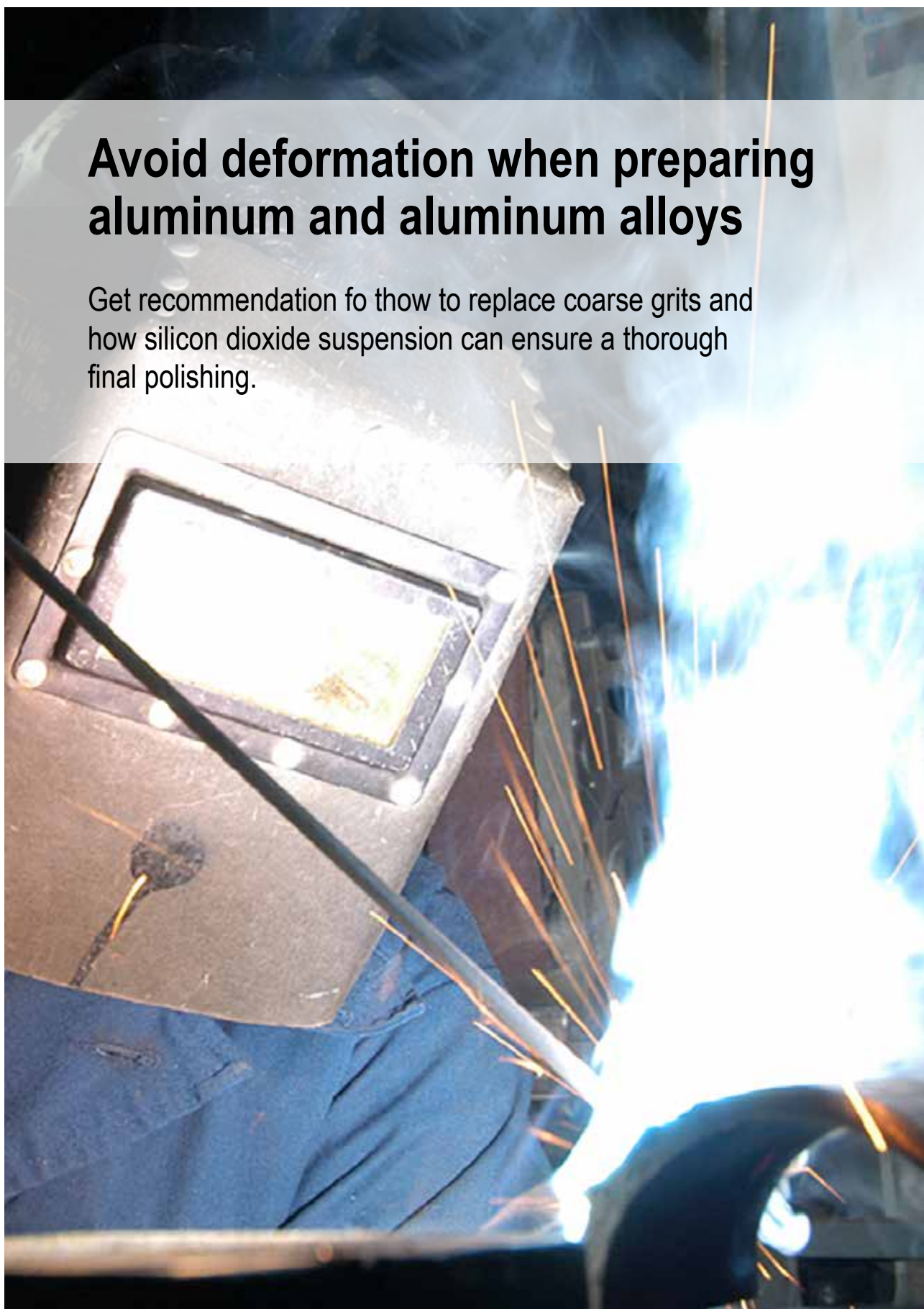
AP-A agglomerated: Faster initial stock removal
Alumina's are easily broken down during the polishing process while still providing faster initial stock removal.

Go to e-shop



Avoid deformation when preparing aluminum and aluminum alloys

Get recommendation fo thow to replace coarse grits and how silicon dioxide suspension can ensure a thorough final polishing.



Click and find out





Special Applications

Struers manufactures a complete range of equipment and consumables for controlled material removal, electrolytic preparation, non-destructive preparation and mineralogy.

In this section you will find equipment and consumables for:

- Controlled material removal
- Electrolytic preparation
- Non-Destructive testing
- Mineralogy

Only Struers consumables are designed to get the most out of Struers equipment.



Sample Chair



ViaKit Caps



Electrolyte

Controlled Material Removal

TargetSystem Consumables

05756914	<p>30 mm dia. Sample Chair 30 mm dia. adapter for cross-sectioning on TargetMaster. To be inserted into TargetGrip (05756916). Max. specimen size 23 x 20.5 mm. Disposable.</p> <p>30 mm dia. 50 pcs.</p>
05756908	<p>40 mm dia. Sample Chair 40 mm dia. adapter for cross-sectioning on TargetMaster. To be inserted into TargetGrip (05756901). Max. specimen size 29 x 20.5 mm. Disposable.</p> <p>40 mm dia. 50 pcs.</p>
05756917	<p>40 mm Elevated Sample Chair 40 mm Adapter for cross-sectioning (disposable), 50 pcs. External sample platform for use with TargetX. Max sample size ca 5x15mm. Use of this sample chair requires modification of TargetMaster.</p>
05756912	<p>Mould Insert Mould insert for use with 40 mm dia. mount cups. Max specimen size 35 x 20 mm.</p> <p>40 mm dia. 50 pcs.</p>
05756907	<p>Resin Barrier Metal labels to be used together with Sample chair (05756908 and 05756914).</p> <p>50 pcs.</p>

ViaKit/-Basic Consumables

40300056	<p>ViaKit End Caps End caps for use with ViaKit Mounting Rings (40300055).</p> <p>250 pcs.</p>
40300057	<p>ViaKit Positioning Pins Positioning pins, 1.98 mm dia., length 43 mm. Suitable for use with ViaKit and AccuStop-40/Flangeform.</p> <p>500 pcs.</p>

Electrolytes

Electrolytes	
40900008***	<p>Electrolyte A2 For electrolytic polishing of steel, stainless steel, Aluminum and Aluminum alloys, nickel alloys, tin and titanium. All-round electrolyte for LectroPol-, Polectrol and Movipol-.</p> <p>1 l</p>
40900011***	<p>Electrolyte A3 For electrolytic polishing of molybdenum, titanium, zirconium and vanadium. For LectroPol-, Polectrol, Movipol- and Tenupol-.</p> <p>1 l</p>
40900032***	<p>Electrolyte D2 Electrolyte for copper and copper alloys. For LectroPol-, Polectrol, Movipol- and Tenupol-.</p> <p>1 l</p>



Flapper Wheel



Polishing Cloths



Transcopy kit

Non-destructive Testing

Grinding	
40800053	<p>Flapper Wheel For coarse grinding with TransPol.</p> <p>Grit 80. 40 mm (1½") dia. x 10 mm, shaft 6 mm dia. 5 pcs.</p>
40400049	<p>Silicon Carbide Paper Silicon carbide grinding paper, for grinding on Transpol-2 and Transpol. Self-adhesive.</p> <p>Grit 60. 32 mm (1¼") dia. 100 pcs.</p>
40400129	Grit 120. 32 mm (1¼") dia. 100 pcs.
40400130	Grit 240. 32 mm (1¼") dia. 100 pcs.
40400131	Grit 500. 32 mm (1¼") dia. 100 pcs.
Polishing Cloth	
40500040	<p>DP-Dur Cloth for diamond polishing. For use with Transpol. Satin woven silk. Self-adhesive.</p> <p>32 mm (1¼") dia. 25 pcs.</p>
40500041	<p>DP-Mol Cloth for diamond polishing. For use with Transpol. Woven wool. Self-adhesive.</p> <p>32 mm (1¼") dia. 25 pcs.</p>
40500042	<p>DP-Nap Cloth for diamond polishing. For use with Transpol. Short synthetic nap. Self-adhesive.</p> <p>32 mm (1¼") dia. 25 pcs.</p>

Polishing Cloth

- 40500043 **OP-Felt**
Cloth for oxide polishing. For use with Transpol. Thick felt. Self-adhesive.
32 mm (1¼") dia. 25 pcs.
- 40500145 **DP-Dac**
Cloth for diamond polishing. For Transpol-2 and Transpol. Satin woven acetate. Self-adhesive.
32 mm (1¼") dia. 25 pcs.
- 03926904 **Polishing Chamber**
Flexible type. For MoviPol-3 and -5.
50 pcs.

Transcopy

- 40900090*** **Transcopy Kit**
For making replica of polished and etched surfaces. Self-adhesive reflective Transcopy Replica Foil creates a permanent replication of microstructures, cracks and defects for future analysis in the laboratory.
50 pcs. 20 x 30 mm replica foils, 40 ml liquid, spray nozzle, pipette and microscope slides
- 40900092*** **Transcopy Liquid**
For Transcopy Replica Foils (40900091)
40 ml
- 40900091 **Transcopy Replica Foils**
Reflective metallographic replica foils. Self-adhesive. Foil thickness app. 280-300 µm. Transcopy Liquid (40900092) is ordered separately.
20 x 30 mm. 50 pcs.



RepliSet 50 ml Cartridges

- 40900069 **RepliSet-F1**
Replication system. Particularly useful for replicating horizontal or sloping surfaces in low temperature conditions or where rapid results are required. Fluid rapid curing compound with working life of 0.5 - 1 min. and curing time of 4 min. at 25° C. Dispensing gun (40900066) and static-mixing nozzles (40900088) are ordered separately.
1 cartridge of 50 ml
- 40900047 5 cartridges of 50 ml
- 40900068 **RepliSet-F5**
Replication system. General-purpose material. Particularly useful for replicating horizontal or sloping surfaces in normal or high temperature conditions. Fluid fast curing compound with working life of 5 min. and curing time of 18 min. at 25° C. Dispensing gun (40900066) and static-mixing nozzles (40900088) are ordered separately.
1 cartridge of 50 ml
- 40900046 5 cartridges of 50 ml

RepliSet 50 ml Cartridges

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40900071 **RepliSet-T1**
Replication system. Particularly useful for replicating vertical or overhead surfaces in low temperature conditions or where rapid results are required. Thixotropic rapid curing compound with working life of 0.5 - 1 min. and curing time of 4 min. at 25° C. Dispensing gun (40900066) and static-mixing nozzles (40900088) are ordered separately.

1 cartridge of 50 ml

40900049 5 cartridges of 50 ml

40900070 **RepliSet-T3**
Replication system. General-purpose material. Particularly useful for replicating vertical or overhead surfaces in normal or high temperature conditions. Thixotropic fast curing compound with working life of 3 min. and curing time of 10 min. at 25° C. Dispensing gun (40900066) and static-mixing nozzles (40900088) are ordered separately.

1 cartridge of 50 ml

40900048 5 cartridges of 50 ml

40900078 **RepliSet-GF1**
Replication system especially for comparator macroscopy and metrology. Particularly useful for replicating horizontal or sloping surfaces and filling holes. Fluid rapid curing compound with working life of 0.5 - 1 min. and curing time of 4 min. at 25° C. Dispensing gun (40900066) and static-mixing nozzles (40900088) are ordered separately.

1 cartridge of 50 ml

40900076 5 cartridges of 50 ml

40900079 **RepliSet-GT1**
Replication system especially for comparator macroscopy and metrology. Particularly useful for replicating vertical or overhead surfaces. Thixotropic rapid curing compound with working life of 0.5 - 1 min. and curing time of 4 min. at 25° C. Dispensing gun (40900066) and static-mixing nozzles (40900088) are ordered separately.

1 cartridge of 50 ml

40900077 5 cartridges of 50 ml

RepliSet 265 ml Cartridges

40900050 **RepliSet-F5**
Replication system. General-purpose material. Particularly useful for replicating horizontal or sloping surfaces in normal or high temperature conditions. Fluid fast curing compound with working life of 5 min. and curing time of 18 min. at 25°C. Dispensing gun (40900065) and static-mixing nozzles (40900056) are ordered separately

2 cartridges of 265 ml

40900051

RepliSet-F1

Replication system. Particularly useful for replicating horizontal or sloping surfaces in low temperature conditions or where rapid results are required. Fluid rapid curing compound with working life of 0.5 - 1 min. and curing time of 4 min. at 25° C. Dispensing gun (40900065) and static-mixing nozzles (40900056) are ordered separately

2 cartridges of 265 ml

40900052

RepliSet-T3

Replication system. General-purpose material. Particularly useful for replicating vertical or overhead surfaces in normal or high temperature conditions. Thixotropic fast curing compound with working life of 3 min. and curing time of 10 min. at 25° C. Dispensing gun (40900065) and static-mixing nozzles (40900056) are ordered separately

2 cartridges of 265 ml

RepliSet 265 ml Cartridges

- 40900053 **RepliSet-T1**
Replication system. Particularly useful for replicating vertical or overhead surfaces in low temperature conditions or where rapid results are required. Thixotropic rapid curing compound with working life of 0.5 - 1 min. and curing time of 4 min. at 25° C. Dispensing gun (40900065) and static-mixing nozzles (40900056) are ordered separately
2 cartridges of 265 ml

RepliFix

- 40900084 **RepliFix-2**
Specially formulated hand mixed fast curing two-part silicone rubber. Bonds to RepliSet. Particularly useful in combination with RepliSet for producing a rigid backing. It can be used directly for moulding of surface shape for profile measurement. For low temperature conditions or where rapid results are required. Working life of 2-3 min. and curing time of 10 min. at 25° C.
250 g RepliFix-2, Yellow, 250 g RepliFix-2, Blue, protective gloves
- 40900086 **RepliFix-20**
Specially formulated hand mixed two-part silicone rubber. Bonds to RepliSet. Particularly useful in combination with RepliSet for producing a rigid backing. It can be used directly for moulding of surface shape for profile measurement. For high temperature conditions or for taking replicas of complicated geometry or large areas. Working life of 20 min. and curing time of 60 min. at 25° C.
250 g RepliFix-20, Yellow, 250 g RepliFix-20, Blue, protective gloves

Static-mixing Nozzles

- 40900088 For RepliSet replication compound in 50 ml cartridges.
35 pcs.
- 40900056 For RepliSet replication compound in 265 ml cartridges
10 pcs.

Backing Material, Nozzle Tips

- 40900087 **Backing Slides**
For RepliSet replication system. A flexible plastic slide, which bonds to the replica and ensures a flat back to the replica. For levelling of replicas to assist microscopic examination, as dimensional support for metrology and for well-ordered labelling, transport and storage of RepliSet replicas.
26 x 76 x 1 mm, 50 pcs.
- 40900064 58 x 40 x 1 mm, 50 pcs.
- 40900062 **Backing Paper**
For RepliSet replication system. Bonds to the replica and facilitates labelling, handling and the levelling of replicas to assist microscopic examination.
60 x 70 mm. 100 pcs.
- 40900063 For RepliSet replication system. Bonds to the replica and facilitates labelling, handling and the levelling of replicas to assist microscopic examination. For cutting up to the required size.
A4 (210 x 297 mm). 10 pcs.
- 40900089 **Nozzle Tips**
For replicating flat surfaces using RepliSet (particularly with RepliSet-T types). Fishtail spreaders, 10 mm width. To be mounted on 50 ml static-mixing nozzle (40900088).
30 pcs.
- 40900060 For replicating small holes using RepliSet. Luer needle, app. 1 mm dia., 30-38 mm long. Reusable several times. To be mounted on 50 ml static-mixing nozzle (40900088)
10 pcs.

Backing Material, Nozzle Tips

40900061

For replicating larger holes using RepliSet. Flexible hose, 6 mm dia., 100 mm long. Reusable several times. To be mounted on 50 ml static-mixing nozzle (40900088).
10 pcs.



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Selection Guide for RepliSet Compound

Surface facing	Temperature of surface	Working life	Recommended compound
Horizontal, sloping	> 20°C	Normal	RepliSet-F5
		Short	RepliSet-F1/GF1
	< 20°C	Normal	
Vertical, overhead	> 20°C	Normal	RepliSet-T3
		Short	RepliSet-T1/GT1
	< 20°C	Normal	



Silicon Carbide Powder



Eukitt



Cast Iron Disc

Mineralogy

Silicon Carbide Powder

40701023	For lapping mineralogical or ceramic specimens. To be used on cast iron lapping disc. Grit 120 (FEPA F). 500 g
40701024	Grit 220 (FEPA F). 500 g
40701025	Grit 320 (FEPA F). 500 g
40701026	Grit 400 (FEPA F). 500 g
40701027	Grit 600 (FEPA F). 500 g
40701028	Grit 800 (FEPA F). 500 g
40701029	Grit 1000 (FEPA F). 300 g
40701030	Grit 1200 (FEPA F). 300 g

Glass Slides

80100001	Standard Slides Standard Slides for thin sections, with ground edges. 1.2 - 1.5 mm thick. 27 x 46 mm. 100 pcs.
40701018	28 x 48 mm. 100 pcs.
40701020	Microcover Glass To be used for covering thin sections. 24 x 32 mm. 100 pcs.

Adhesives

41000005	TriPod Wax Removable resin for mounting of specimens on TriPod Sample Mounts. 1 stick
41000004***	Eukitt Removable resin for fixation of cover glass on thin sections. 500 ml



Adhesive Tape



Tape Kit



Disposable Bowl Liner

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General Purpose

Others	
49900044	<p>Adhesive Tape To be used with specimen holder MAXAD (02606950), MAXSO (02606926), MAXSA (02606928), MAXON (02606927) or MAXAN (02606929). Double-sided adhesive tape in roll. 38 mm wide. 25 m</p>
49900012***	<p>Protecting Lacquer For protecting the specimen surface. 400 ml. In spray can</p>
49900027	<p>Cleaner For heavy duty cleaning. Solopol (Krestopol). 4 tubes of 250 ml</p>
49900000	<p>Concentrated Soap Solution To be used in Hexamatic, Prepamatic, TargetMaster, MAPS and for ultrasonic cleaning. 1 l</p>
40900043	<p>Engraver Tip Tungsten carbide tipped point for Engraver. 1 pc.</p>
40900041	<p>Tape Kit - TenuPol For electrolytic blanking of 3 mm / 2.3 mm specimens to be electrolytically thinned for TenuPol. 1 roll of tape and 1 hole punch</p>
49900052	<p>Disposable Bowl Liner For Tegramin-30 and -25. 5 pcs.</p>
49900056	<p>For Tegramin-20 5 pcs.</p>
49900041	<p>For TegraPol-11, -15 and LaboPol-1, -2, -4, -5, -6. 5 pcs</p>
49900061	<p>For LaboPol-20. 5 pcs.</p>
49900062	<p>For LaboPol-30/-60. 5 pcs.</p>
49900067	<p>For AbraPol-30. 3 pcs.</p>
49900033	<p>Protection caps Plastic caps for cylindrical specimens or mounts. 25 mm dia. 100 pcs.</p>
49900034	<p>30 mm dia. 100 pcs.</p>
49900035	<p>40 mm dia. 100 pcs.</p>
49900036	<p>50 mm dia. 100 pcs.</p>
49900063	<p>1¼" dia. 100 pcs.</p>



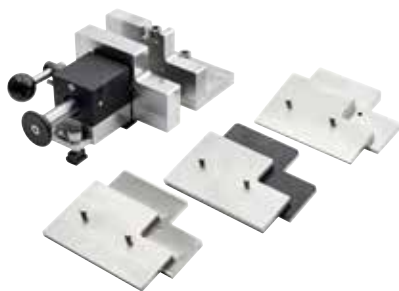
Accessories

Struers offers a wide variety of tools and accessories, all developed with the main purpose of providing easier handling and more accurate specimen preparation.

In this section you will find accessories for:

- Cutting - Clamping tools
- Mounting
- Grinding and polishing
- Automatic cleaning
- Non-Destructive testing

Only Struers accessories are designed to get the most out of Struers equipment.



Quick clamping tool



Bolt clamping tool

Good cutting results start with a good clamping solution. In this section, we have included an extract of the best selling Struers clamping tools. More tools and accessories are available, and Struers also offers customized solutions.

Contact your local Struers office to learn how we can help you.

Cutting

Clamping Tools

05036915

Vertical Clamping Tool

For clamping irregularly shaped workpieces on the cutting table. Suitable for all machines with 8 mm T-slots. Clamping height is adjustable up to 58 mm. Complete with operating key and one flat clamping shoe.

For 8 mm T-slots

05116905

For clamping irregularly shaped workpieces on the cutting table. Suitable for all machines with 10 mm T-slots. Clamping height is adjustable up to 58 mm. Complete with operating key and one flat clamping shoe.

For 10 mm T-slots

05046904

For clamping irregularly shaped workpieces on the cutting table. Suitable for all machines with 12 mm T-slots. Clamping height is adjustable up to 105 mm. Complete with operating key and one flat clamping shoe.

For 12 mm T-slots

05116910

Riser Block

For elevating vertical clamping tool (05116905) when clamping high workpieces. To increase the clamping height by 60 mm.

For 10 mm T-slots

05116911

Swivel Shoes

Set of 4 multi-shaped swivel shoes for vertical clamping tool (05046904, 05116905 or 05036915).

05046906

Arm Extension

For extending arm of Vertical Clamping Tool (05036915, 05046904 and 05116905).

05046905

For elevating vertical clamping tool (05046904) when clamping high workpieces. To increase the clamping height by 74 mm.

For 12 mm T-slots

05876906

Turntable clamping tool

0-90 degree turntable for angular cutting. For use with various 12 mm T-slot clamping tools. Table height 42 mm. Table size 220 x 205 mm.

For 12 mm T-slots

06316919

Clamping set tool kit 10 mm

Universal tools for T-slot type cutting tables For supporting and clamping of irregular shaped work pieces.

For 10 mm T-slots

Clamping Tools

06316920	<p>Clamping set tool kit 12 mm Universal tools for T-slot type cutting tables For supporting and clamping of irregular shaped work pieces. For 12 mm T-slots</p>
06316901	<p>Adjustable support for cylindrical parts Can be used for both longitudinal and cross sections. Easy to move and position on the cutting table. Can be adjusted for all different diameters. For 10-12 mm T-slots</p>
06316913	<p>Quick Clamping Tool For securing the workpiece close to the cut-off wheel. Complete with backstop. Easily exchangeable jaws can be ordered separately. Right. For 8 mm T-slots. Jaw movement 50 mm</p>
06316915	Right. For 10 mm T-slots. Jaw movement 50 mm
06316912	Left. For 10 mm T-slots. Jaw movement 50 mm
06316916	Right. For 12 mm T-slots. Jaw movement 60 mm
06316914	Left. For 12 mm T-slots. Jaw movement 60 mm
06316918	<p>Quick Clamping Tool with short stroke For securing the workpiece on the right side of the cut-off wheel. Suitable for all machines with 10 mm T-slots. Complete with backstop. Jaw movement: 12 mm. Jaw height: 58 mm. Right. For 10 mm T-slots</p>
06316917	Left. For 10 mm T-slots
06316921	<p>Low Quick Clamping Tool For retaining the workpiece on the right side of the cut-off wheel. Suitable for all machines with 10 mm T-slots. Complete with backstop. Jaw movement: 50 mm. Jaw height: 42 mm. For 10 mm T-slots</p>
06316922	<p>Vertical Quick Clamping Tool For securing the workpiece on the left side of the cut-off wheel. Suitable for Labotom-5/-15, Discotom-10 and Discotom-100. Max height of workpiece: 50 mm. For 10 mm T-slots</p>
06316907	<p>Base plate clamping tool Designed to clamp small or odd-sized workpieces close to the cut-off wheel. Complete with tools for installation in T-slots and grooved jaws. Prism, Extended and Rubber jaws available as accessories. Right. For 8 mm T-slots. Jaw movement 60 mm</p>
06316906	Right. For 10 mm T-slots. Jaw movement 125 mm
06316905	Left. For 10 mm T-slots. Jaw movement 125 mm
06316909	Right. For 12 mm T-slots. Jaw movement 240 mm
06316908	Left. For 12 mm T-slots. Jaw movement 250 mm
06316926	<p>Bolt clamping tool For longitudinal sectioning of bolts and fasteners. With ruler for easy positioning of the workpiece. Suitable for Secotom-15/-50. Clamping range 4-22 mm diameter. A tungsten carbide guide prevents the cut-off wheel from moving to the either side. Including screws, 3 pcs. 1 mm and 3 pcs. 0.5 mm shims. For 8 mm T-slots</p>
06316904	<p>Pinch-reduction clamping tool Tool that reduces pinching of the cut-off wheel when cutting workpieces with internal stress. Complete set with two jaw blocks (left+right), back stops and spanners. For 10 mm T-slots</p>
06316903	For 12 mm T-slots

Clamping Tools

05046912	Chain Spanner For clamping irregularly shaped workpieces. Complete with anchor block and operating key. For 12 mm T-slots
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EasyDoser



Wupty

Mounting

Dosing Units for Hot Mounting

05796902	EasyDoser Manual dosing unit for hot mounting presses. For Struers 1 kg hot mounting resins.
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Cold Mounting Accessories

05696901	Wupty Tool for pressing mounts out of FixiForm. Wupty can only be used with FixiForm, as we use the handles to secure it while pressing the mount out.
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Grinding and Polishing

Acc. for LaboPol

06206924	Wet Grinding Disc with cone Aluminum disc with retention ring. For use on LaboPol-20 with plain back silicon carbide paper. With cone for easy replacement. 200 mm (8") dia.
06206932	Aluminum, cone-type disc with retention ring. For use on LaboPol-30/-60 with plain back silicon carbide paper. 230 mm dia.
06206918	250 mm (10") dia.
06206919	305 mm (12") dia.

Advanced Grinding/Polishing

Acc. for Tegramin and LaboPol

06086401	MD-Disc with cone MD-Disc for use on Tegramin-20 and LaboPol-20. With cone for easy replacement. 200 mm (8") dia.
06086402	MD-Disc for use on Tegramin-25 and LaboPol-30/-60. With cone for easy replacement. 250 mm (10") dia.
06086403	MD-Disc for use on Tegramin-30 and LaboPol-30/-60. With cone for easy replacement. 300 mm (12") dia.

Acc. for Tegramin and LaboPol

06086404	Aluminum disc with cone Aluminum disc for use on Tegramin-20 and LaboPol-20. With cone for easy replacement. 200 mm (8") dia.
06086405	Aluminum disc for use on Tegramin-25 and LaboPol-30/-60. With cone for easy replacement. 250 mm (10") dia.
06086406	Aluminum disc for use on Tegramin-30 and LaboPol-30/-60. With cone for easy replacement. 300 mm (12") dia.



MD-Disc with cone



MD-Disc with driving pins



Wet Grinding Disc with driving pins

Automatic Preparation

MD-Disc with driving Pins

02426920	Magnetic fixation disc for MD-System products. 200 mm (8") dia.
02426919	250 mm (10") dia.
02426918	300 mm (12") dia.
02426933	350 mm (14") dia.

Preparation Disc, driving Pins

02426935	Wet Grinding Disc with driving pins Aluminum disc with retention ring. For use with plain back silicon carbide paper. 200 mm (8") dia.
02426936	230 mm (9") dia.
02426915	250 mm (10") dia.
02426909	305 mm (12") dia.
03756902	Aluminum Disc with driving Pins For use with adhesive backed consumables. 200 mm (8") dia.
02426907	250 mm (10") dia.
02426906	300 mm (12") dia.
40800113	Magnetic Foil To be attached on standard Aluminum preparation disc to transform it into a magnetic disc for the MD-System. Self-adhesive. 200 mm (8") dia.
40800114	250 mm (10") dia.
40800115	300 mm (12") dia.

Automatic Cleaning

06236920	<p>Levelling tool Levelling tool for adjusting retention rings on individual specimens for Lavamin. For round specimens from 25 - 50 mm dia.</p>
06236921	<p>Applicator for retention rings To apply and adjust retention rings for use with Lavamin. For specimens 25 mm / 1" dia.</p>
06236922	For specimens 30 mm / 1¼" dia.
06236923	For specimens 40 mm / 1½" dia.
06236924	For specimens 50 mm / 2" dia.
06236910	<p>Retention Rings To retain individual specimens in specimen mover plates for cleaning in Lavamin. 15 pcs. For specimens 25 mm / 1" dia.</p>
06236911	For specimens 30 mm / 1¼" dia.
06236912	For specimens 40 mm / 1½" dia.
06236913	For specimens 50 mm / 2" dia.
06236925	<p>Rubber mat To keep small and light specimens in place, for Tegramin-25, TegraForce and RotoForce specimen mover plates. For use with Lavamin. For 140 mm dia. specimen mover plates</p>
06236926	<p>To keep small and light specimens in place, for Tegramin-30 specimen mover plates. For use with Lavamin. For 160 mm dia. specimen mover plates</p>

Controlled Material Removal

TriPod

04386921	<p>Parallel Section Sample Mounts 12.5 mm stainless steel sample mount for TriPod Polishing Fixture-P (04386201). 10 pcs.</p>
04386922	12.5 mm Aluminum sample mount for TriPod Polishing Fixture-P (04386201) 10 pcs.
04386923	<p>Cross Section Sample Mounts 12.5 mm stainless steel sample mount for TriPod Polishing Fixture-X (04386202). 10 pcs.</p>
04386924	12.5 mm Aluminum sample mount for TriPod Polishing Fixture-X (04386202). 10 pcs.
04386925	<p>TriPod Supports Teflon feet for support of TriPod Polishing Fixture-X/-P. 04386202 or 04386201. 2 pcs.</p>



Case



Dispensing Gun

Non-destructive Testing

Others

40900065

Dispensing Gun

Hand-operated dispensing gun for RepliSet

For 265 ml cartridges

40900066

For 50 ml cartridges

40900067

Case

Aluminum carrying case for transporting the 50 ml RepliSet system. Foam rubber inserts have room for all necessities for field applications: 1 Dispensing gun, 5 new cartridges and 2 cartridges in use, 2 x 35 pcs. static-mixing nozzles, nozzle tips, backing paper, cleaning fluid and finished replicas. The content is ordered separately.

L x d x h = 445 x 155 x 330 mm



MD-Concert Concertino



MD-Storage Cabinet



Table unit

General Purpose

Engraver

00146121

For marking of specimens. Complete with 2 different engraving needles.

1 x 110 V / 50-60 Hz

00146133

1 x 220 V / 50-60 Hz

Laboratory Furniture

05306101

MD-Concert

Storage cabinet for 9 MD preparation surfaces in 300 mm (12"), 250 mm (10") or 200 mm (8") dia.

05306102

MD-Concertino

Storage cabinet for 7 MD preparation surfaces in 200 mm (8") dia.

05666001

Storage Cabinet MEDCU

For 10 MD preparation surfaces in 350 mm (14") dia.

235 x 380 x 395 mm (h x w x d)

06266101

Table unit

For Discotom and Labotom cut-off machines. With compartment for recirculation cooling unit, drawer for tools and shelves for cut-off wheels.

Width: 930 mm, depth: 950 mm, height: 800 mm.

06266901

Extension for table unit

Can be mounted on both right and left hand side.

Width: 400 mm, depth 950 mm





Test Blocks

Predictable hardness testing quality can only be achieved with confidence using a hardness tester that is correctly maintained and that has been calibrated according to internationally accredited calibration standards.

We recommend you verify the calibration of your equipment on a regular basis ensuring reproducibility and reliability of your hardness testing results.

Brinell Test blocks – with or without Certificate

The Brinell hardness test is used for larger samples in materials with a coarse or inhomogeneous grain structure. Before performing the Brinell hardness test, the surface of the sample must be prepared.

We recommend you verify the calibration of your equipment on a regular basis ensuring reproducibility and reliability of your hardness testing results.

It must be either:

Machined – Ground – Lapped – Polished

Brinell	Load Factor	Hardness						
		40	70	100	150	170	200	250
HBW 1/30	HB30			056483002	056483003	056483004	056483005	056483006
HBW 2.5/187.5				056482402	056482403	056482404	056482405	056482406
HBW 5/750				056481502	056481503	056481504	056481505	056481506
HBW 10/3000				056481002	056481003	056481004	056481005	056481006
HBW 1/10	HB10	056483100	056483101	056483102	056483103	056483104	056483105	
HBW 2.5/62.5		056482500	056482501	056482502	056482503	056482504	056482505	
HBW 5/250			056481601	056481602	056481603	056481604	056481605	
HBW 10/1000			056481201	056481202	056481203	056481204	056481205	
HBW 1/5	HB5	056483200	056483201	056483202				
HBW 2.5/31.25		056482600	056482601	056482602				
HBW 5/125		056482100	056482101	056482102				
HBW 10/500			056481301	056481302				
HBW 1/2.5	HB2.5	056483300						
HBW 2.5/15.625		056482700						
HBW 5/62.5		056482200						

Brinell (Heavy load)

All blocks will be supplied within ± 15 HB of the nominal value.

Block size: 150 mm x 125 mm x 16 mm thickness.

Brinell (light load)

All blocks will be supplied within ± 15 HB of the nominal value.

Block size: 64 mm diameter x 15 mm thickness.

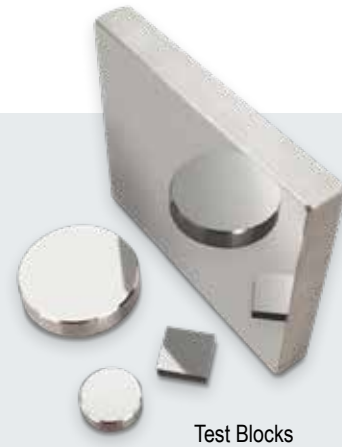
Add a C for Certificate. Example: : 056481005 without certificate and 056481005C with Certificate included.

Test block material:

Black = Steel

Blue = Aluminum

Please contact your local Struers representative, if you wish to add additional calibration and grid on the test block.



Test Blocks

300	350	400	450	500	550	600	650
056483007	056483008	056483009	056483010	056483011	056483012	056483013	056483014
056482407	056482408	056482409	056482410	056482411	056482412	056482413	056482414
056481507	056481508	056481509	056481510	056481511	056481512	056481513	056481514
056481007	056481008	056481009	056481010	056481011	056481012	056481013	056481014

Vickers Test blocks – with or without Certificate

The Vickers hardness test is suitable for a wide range of applications, including micro hardness testing. The required surface condition for the Vickers hardness test depends on the load used.

Macro test blocks (loads higher than 1 kgf)

– Surface should be ground

Micro test blocks (loads below or equal to 1 kgf)

– Surface should be mechanically polished or electropolished

Steel and copper

– At least 3 diagonal widths between indentations

Lead, zinc and aluminum

– At least 6 diagonal widths between indentations

We recommend you verify the calibration of your equipment on a regular basis ensuring reproducibility and reliability of your test block results.

Vickers	Hardness									
Test method	40	70	100	150	200	250	300	350	400	450
HV0.010	056484000	056484001	056484002	056484003	056484005	056484006	056484007	056484008	056484009	056484010
HV0.025	056484100	056484101	056484102	056484103	056484105	056484106	056484107	056484108	056484109	056484110
HV0.050	056484200	056484201	056484202	056484203	056484205	056484206	056484207	056484208	056484209	056484210
HV0.1	056484300	056484301	056484302	056484303	056484305	056484306	056484307	056484308	056484309	056484310
HV0.2	056484400	056484401	056484402	056484403	056484405	056484406	056484407	056484408	056484409	056484410
HV0.3	056484500	056484501	056484502	056484503	056484505	056484506	056484507	056484508	056484509	056484510
HV0.5	056484600	056484601	056484602	056484603	056484605	056484606	056484607	056484608	056484609	056484610
HV1	056484700	056484701	056484702	056484703	056484705	056484706	056484707	056484708	056484709	056484710
HV2	056485000	056485001	056485002	056485003	056485005	056485006	056485007	056485008	056485009	056485010
HV3	056485100	056485101	056485102	056485103	056485105	056485106	056485107	056485108	056485109	056485110
HV5	056485200	056485201	056485202	056485203	056485205	056485206	056485207	056485208	056485209	056485210
HV10	056485300	056485301	056485302	056485303	056485305	056485306	056485307	056485308	056485309	056485310
HV20	056485400	056485401	056485402	056485403	056485405	056485406	056485407	056485408	056485409	056485410
HV30	056485500	056485501	056485502	056485503	056485505	056485506	056485507	056485508	056485509	056485510
HV50	056485600	056485601	056485602	056485603	056485605	056485606	056485607	056485608	056485609	056485610
HV100	056485700	056485701	056485702	056485703	056485705	056485706	056485707	056485708	056485709	056485710

Vickers, Micro

All blocks will be supplied within ± 25 HV of the nominal value.

Block size: 30 mm diameter x 10 mm thickness.

Vickers, Macro

All blocks will be supplied within ± 25 HV of the nominal value.

Block size: 64 mm diameter x 15 mm thickness.

Test block material:

Black = Steel

Blue = Aluminum

Please contact your local Struers representative, if you wish to add additional calibration and grid on the test block.



Test Blocks

500	550	600	650	700	750	800	850	900	950	1000	1050	1100
056484011	056484012	056484013	056484014	056484015	056484016	056484017	056484018	056484019	056484020	056484021	056484022	056484023
056484111	056484112	056484113	056484114	056484115	056484116	056484117	056484118	056484119	056484120	056484121	056484122	056484123
056484211	056484212	056484213	056484214	056484215	056484216	056484217	056484218	056484219	056484220	056484221	056484222	056484223
056484311	056484312	056484313	056484314	056484315	056484316	056484317	056484318	056484319	056484320	056484321	056484322	056484323
056484411	056484412	056484413	056484414	056484415	056484416	056484417	056484418	056484419	056484420	056484421	056484422	056484423
056484511	056484512	056484513	056484514	056484515	056484516	056484517	056484518	056484519	056484520	056484521	056484522	056484523
056484611	056484612	056484613	056484614	056484615	056484616	056484617	056484618	056484619	056484620	056484621	056484622	056484623
056484711	056484712	056484713	056484714	056484715	056484716	056484717	056484718	056484719	056484720	056484721	056484722	056484723
056485011	056485012	056485013	056485014	056485015	056485016	056485017	056485018	056485019	056485020	056485021	056485022	
056485111	056485112	056485113	056485114	056485115	056485116	056485117	056485118	056485119	056485120	056485121	056485122	
056485211	056485212	056485213	056485214	056485215	056485216	056485217	056485218	056485219	056485220	056485221	056485222	
056485311	056485312	056485313	056485314	056485315	056485316	056485317	056485318	056485319	056485320	056485321	056485322	
056485411	056485412	056485413	056485414	056485415	056485416	056485417	056485418	056485419	056485420	056485421	056485422	
056485511	056485512	056485513	056485514	056485515	056485516	056485517	056485518	056485519	056485520	056485521	056485522	
056485611	056485612	056485613	056485614	056485615	056485616	056485617	056485618	056485619	056485620	056485621	056485622	
056485711	056485712	056485713	056485714	056485715	056485716	056485717	056485718	056485719	056485720	056485721	056485722	

CUTTING

MOUNTING

GRINDING

POLISHING

SPECIAL APPLICATIONS

ACCESSORIES

TEST BLOCKS

Knoop Test blocks – with or without Certificate

The Knoop hardness test is an alternative to the Vickers test in the micro hardness testing range. Before application of the Knoop hardness test, you must prepare the surface of the material to be tested.

We recommend you verify the calibration of your equipment on a regular basis ensuring reproducibility and reliability of your hardness testing results.

The Knoop hardness test is used for micro hardness testing (loads below or equal to 1 kgf) and so the surface of the sample material should be highly polished or electropolished before testing is performed.

Knoop	Hardness								
	40	70	100	150	200	250	300	350	400
HK0.001	056487000	056487001	056487002	056487003	056487005	056487006	056487007	056487008	056487009
HK0.005	056487100	056487101	056487102	056487103	056487105	056487106	056487107	056487108	056487109
HK0.010	056487200	056487201	056487202	056487203	056487205	056487206	056487207	056487208	056487209
HK0.025	056487300	056487301	056487302	056487303	056487305	056487306	056487307	056487308	056487309
HK0.050	056487400	056487401	056487402	056487403	056487405	056487406	056487407	056487408	056487409
HK0.1	056487500	056487501	056487502	056487503	056487505	056487506	056487507	056487508	056487509
HK0.2	056487600	056487601	056487602	056487603	056487605	056487606	056487607	056487608	056487609
HK0.3	056487700	056487701	056487702	056487703	056487705	056487706	056487707	056487708	056487709
HK0.5	056487800	056487801	056487802	056487803	056487805	056487806	056487807	056487808	056487809
HK1	056487900	056487901	056487902	056487903	056487905	056487906	056487907	056487908	056487909

Knoop

All blocks will be supplied within ± 25 HK of the nominal value.

Block size: 30 mm diameter x 10 mm thickness.

Add a C for Certificate. Example: 056487005 without certificate and 056487005C with Certificate included.

Test block material:

Black = Steel

Blue = Aluminum

Please contact your local Struers representative, if you wish to add additional calibration and grid on the test block.



Test Blocks

450	500	550	600	650	700	750	800	850	900	950	1000
056487010	056487011	056487012	056487013	056487014	056487015	056487016	056487017	056487018	056487019	056487020	056487021
056487110	056487111	056487112	056487113	056487114	056487115	056487116	056487117	056487118	056487119	056487120	056487121
056487210	056487211	056487212	056487213	056487214	056487215	056487216	056487217	056487218	056487219	056487220	056487221
056487310	056487311	056487312	056487313	056487314	056487315	056487316	056487317	056487318	056487319	056487320	056487321
056487410	056487411	056487412	056487413	056487414	056487415	056487416	056487417	056487418	056487419	056487420	056487421
056487510	056487511	056487512	056487513	056487514	056487515	056487516	056487517	056487518	056487519	056487520	056487521
056487610	056487611	056487612	056487613	056487614	056487615	056487616	056487617	056487618	056487619	056487620	056487621
056487710	056487711	056487712	056487713	056487714	056487715	056487716	056487717	056487718	056487719	056487720	056487721
056487810	056487811	056487812	056487813	056487814	056487815	056487816	056487817	056487818	056487819	056487820	056487821
056487910	056487911	056487912	056487913	056487914	056487915	056487916	056487917	056487918	056487919	056487920	056487921

CUTTING

MOUNTING

GRINDING

POLISHING

SPECIAL APPLICATIONS

ACCESSORIES

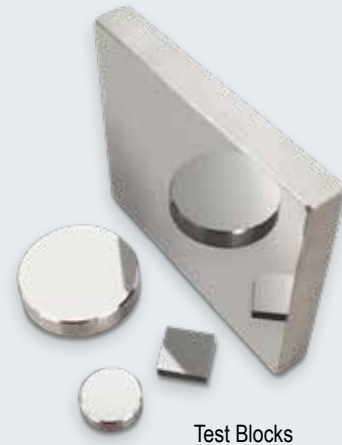
TEST BLOCKS

Rockwell Test blocks – with or without Certificate

Rockwell	Regular Scales								
Test Method	Hardness								
HRC	20 056486000	25 056486001	30 056486002	35 056486003	40 056486004	45 056486005	50 056486006	55 056486007	60 056486008
HRA	60 056486020	63 056486021	65 056486022	68 056486023	70 056486024	73 056486025	76 056486026	78 056486027	81 056486028
HRA	22 056486140	26 056486141	31 056486142	35 056486143	40 056486144	45 056486145	47 056486146	50 056486147	53 056486148
HRD	40 056486040	44 056486041	48 056486042	52 056486043	56 056486044	60 056486045	64 056486046	67 056486047	71 056486048
HRB	20 056486120	30 056486121	40 056486122	50 056486123	60 056486124	70 056486125	75 056486126	80 056486127	85 056486128
HRE	75 056486160	81 056486161	87 056486162	93 056486163	100 056486164				
HRF	74 056486170	80 056486171	86 056486172	91 056486173	97 056486174	100 056486175			
HRG	33 056486182	41 056486183	49 056486184	58 056486185	66 056486186	74 056486187	83 056486188		
HRH	94 056486190	98 056486191							
HRK	47 056486201	56 056486202	65 056486203	73 056486204	81 056486205	86 056486206	91 056486207	95 056486208	99 056486209
HRL	92 056486280	118 056486281	123 056486282						
HRM	67 056486290	107 056486291	118 056486292						
HRP	86 056486300	94 056486301	112 056486302						
HRR	105 056486310	123 056486311	126 056486312						
HRS	115 056486320	117 056486321	123 056486322						
HRV	107 056486330	109 056486331	120 056486332						

Rockwell	Superficial Scales								
Test Method	Hardness								
HR15N	72 056486061	75 056486062	78 056486063	81 056486064	83 056486065	85 056486066	88 056486067	90 056486068	91 056486069
HR30N	46 056486081	50 056486082	55 056486083	59 056486084	64 056486085	68 056486086	73 056486087	77 056486088	80 056486089
HR45N	25 056486101	31 056486102	37 056486103	43 056486104	49 056486105	55 056486106	61 056486107	66 056486108	70 056486109
HR15T	67 056486220	70 056486221	73 056486222	77 056486223	80 056486224	83 056486225	85 056486226	86 056486227	88 056486228
HR30T	29 056486240	36 056486241	43 056486242	49 056486243	56 056486244	63 056486245	66 056486246	69 056486247	73 056486248
HR45T	12 056486261	22 056486262	32 056486263	43 056486264	48 056486265	53 056486266	58 056486267	63 056486268	68 056486269
HR15W	84 056486340	87 056486341	94 056486342						
HR30W	67 056486350	73 056486351	87 056486352						
HR45W	50 056486360	59 056486361	80 056486362						
HR15X	92 056486370	93 056486371	96 056486372						
HR30X	82 056486380	84 056486381	92 056486382						
HR45X	72 056486390	76 056486391	85 056486392						
HR15Y	95 056486400	96 056486401	98 056486402						
HR30Y	90 056486410	91 056486411	95 056486412						
HR45Y	85 056486420	87 056486421	94 056486422						

63 056486009	65 056486010	67 056486011	68 056486012	69 056486013	70 056486014
83 056486029	84 056486030	85 056486031			
55 056486149	59 056486150	62 056486151			
73 056486049	74 056486050	77 056486051			
90 056486129	95 056486130	100 056486131			



Test Blocks

The Rockwell hardness test is a fast method, making it ideal for quick hardness testing. Rockwell hardness testing do not use optical measurement meaning sample reflectiveness is not needed. Rockwell hardness testing can therefore be used on non-prepared surfaces

We recommend you verify the calibration of your equipment on a regular basis ensuring reproducibility and reliability of your hardness testing results.

Rockwell

Test blocks HRC, HRA, HRD, HR15N, HR30N, HR45N will be supplied within ± 2 HR of the nominal value.

All other blocks will be supplied within ± 4 HR of the nominal value.

Block size: 64 mm diameter x 15 mm thickness.

Add a C for Certificate. Example: 056486004 without certificate and 056486004C with Certificate included.

Test block material:

Black = Steel

Blue = Aluminum

Please contact your local Struers representative, if you wish to add additional calibration and grid on the test block.

92 056486070	93 056486071	
82 056486090	83 056486091	
72 056486110	74 056486111	
90 056486229	91 056486230	93 056486231
76 056486249	80 056486250	

Hardness testing:

7 how-to videos to master hardness testing



In a series of YouTube videos, you will have the most frequent “how-to” topics in hardness testing answered.

Discover the topics and learn how to improve your hardness testing skills on our Duramin hardness testers.

Show me
the videos



Can You Get Even Better?

New applications are emerging that help quality control departments deliver greater certainty, with shorter lead times and better documentation. Can you improve your quality control?

Industries are accelerating. Production times are getting shorter, production lines are moving faster, and companies are looking to drive down costs wherever they can. For quality control departments, this means running shorter lead times and making faster changeovers between products – while delivering even better certainty and documentation. This is where Struers can help.

As the world's leading expert in materialographic solutions, we help companies like yours improve product quality across the entire product life cycle, from R&D to quality control and failure analysis.

Where can you improve?

Materialographic preparation involves many different processes and it can be difficult to keep an eye on all of the factors that define quality, efficiency and effectiveness. Our industry experts can help you:

- Speed up your preparation processes
- Reduce time spent waiting for samples
- Decrease rework
- Improve accuracy
- Reduce time spent on alignment and handling
- Reduce your dependency on specific skills
- Improve your health and safety processes

A tailored solution

Of course, we understand that every quality control department is different. So, we work closely with you to analyse your current set-up and look for areas to improve. From re-thinking your entire process flow to minor process adjustments, we can help you improve your reliability and repeatability, while increasing speed and reducing costs.

Contact your local Struers office to learn how we can help you, or find out more at www.struers.com



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Ensuring Certainty

With offices and affiliates in 24 countries and a presence in more than 50 countries worldwide, Struers is the world's leading materialographic solution supplier. We are dedicated to enabling our customers to ensure certainty in all aspects of materialographic preparation and testing as well as material hardness testing – wherever they are in the world. Struers offers a complete range of equipment, consumables, service and training programmes – all supported by the most comprehensive knowledge base, global applications support and a certified global service set-up.

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