

# CONSUMABLES CATALOG

Optimize your process with  
Struers consumables



# A PURE MOUNTING MATERIAL

BUY IN WEBSHOP



Optimize your hot mounting process and improve your work environment. PuriFast is a dust-free and unhazardous thermoplastic hot mounting material.

- ✓ Improve employee safety with unhazardous material
- ✓ Increase efficiency with ergonomic handling
- ✓ Achieve high reliability with a universal hot mounting material

# CONSUMABLES CATALOG

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# ANY CONSUMABLE FOR YOUR MATERIAL

As the world's leading materialographic supplier, we provide a full range of materialographic consumables and accessories, covering any type of material. All of our products are designed to ensure that you get outstanding quality, reproducibility, and usability – for efficient preparation and reliable results.

In the Struers Consumables Catalog, you can find consumables and accessories for every area of materialographic preparation:

- Cutting
- Mounting
- Grinding and Polishing
- Verification
- Accessories

## CUTTING



## MOUNTING



## GRINDING/POLISHING



## VERIFICATION





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**“We have not met a customer yet for whom we were unable to reduce their number of steps or reduce their preparation time.”**

– Helle Michaelsen, MSc, Business Solution & Application Manager, Struers

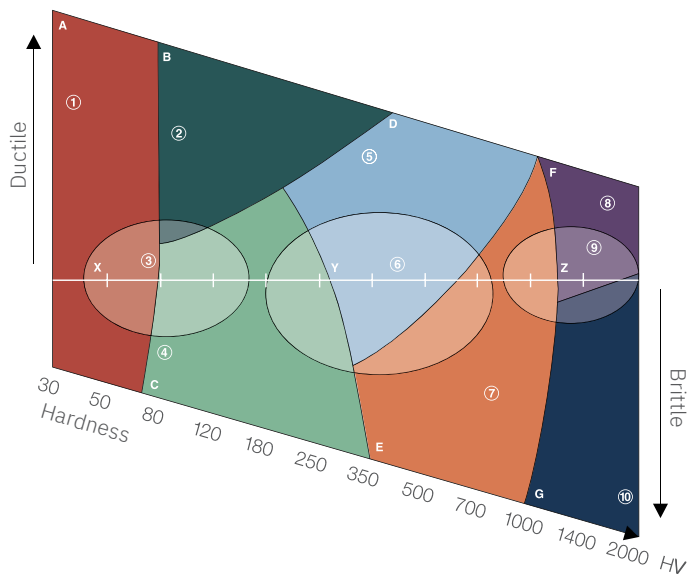


# A METHOD FOR ANY MATERIAL

## Optimize your process – minimize your waste

Are you looking for perfect results from your true structure? Or perhaps a few artifacts are acceptable as long as they do not disturb your analysis? No matter your preparation goal, we will help you optimize your grinding and polishing process – without over-processing. This means increasing the quality of your specimen up to your goal by eliminating artifacts such as deformation, edge rounding, scratches or pull-outs, while minimizing process waste with fewer, shorter steps.

## Find the optimal process for your material based on its hardness and ductility



Find the hardness of your material on the X-axis, then move up or down the Y-axis, depending on its ductility. Learn more and see optimized methods for your material at [Struers.com](https://www.struers.com)

## Take a systematic approach to accurate, reproducible results

Trial and error is neither an accurate nor efficient approach. Based on extensive academic training and hands-on experience, our materialographic experts have developed optimized methods for any material. Simply tell us your preparation goal, and we will customize our standard method to your equipment, requirements and operator capabilities, whether your focus is on quality, safety, speed, or efficiency.

A systematic approach is key to achieving accurate, repeatable results and makes troubleshooting easier. Struers also helps you minimize random errors and maximize your reproducibility. Our high quality consumables deliver the same performance every time and help to absorb sensitivity to changes in conditions. We also provide training in methods and techniques with onsite and online courses.



**Siemens reduced its titanium preparation time by more than**

 **80 %**

**“One of our colleagues, who has worked with titanium for several years in large companies, told us that these were the best specimens he had ever seen.”**

– Mikael Bergren, Laboratory Technician, Siemens Industrial Turbomachinery



# CHOOSE A PARTNER, NOT JUST A SUPPLIER

## Maximize your uptime with consumables on delivery

Reduce your risk and keep inventory costs down with our robust global supply chain. For fast, reliable delivery, we have distribution centers across the U.S., Japan, China, Germany and Denmark.

Our ISO 9001-certified LEAN production and strict quality control ensure all consumables perform as promised and contribute to a safer workplace. You can also minimize your environmental impact thanks to our ISO 14001 certification for environmental management and commitment to low-carbon shipping.

## Get total support – whatever, whenever

Grinding is just one part of the story. Our materialographic experts can help you optimize your end-to-end process through Value Stream Mapping. There are also Struers consumables and equipment for any stage in the process. These are designed to work together so you get the most out of your investment.

In fact, we are here to help you with every aspect of materialography. Whether you need to boost your skills with onsite and online training or maximize your uptime with service and support, we offer a complete solution for ensuring certainty.







**98% of consumables  
are shipped within**

**48** hrs



# CUTTING

## **Struers Cutting Consumables**

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 the parameters of the cutting process, such as cooling, rotational speed, and feed speed. In 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 center. 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 contributes to a more efficient cooling and helps to eliminate cutting debris buildup. This results in lower heat damage and less time spent in cleaning.

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



# SELECTION GUIDE FOR CUT-OFF WHEELS

Struers offers the market's most comprehensive ranges of purpose-designed cut-off wheels for materialographic sectioning. Our 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.

## How to select the correct cut-off wheel:

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.
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.

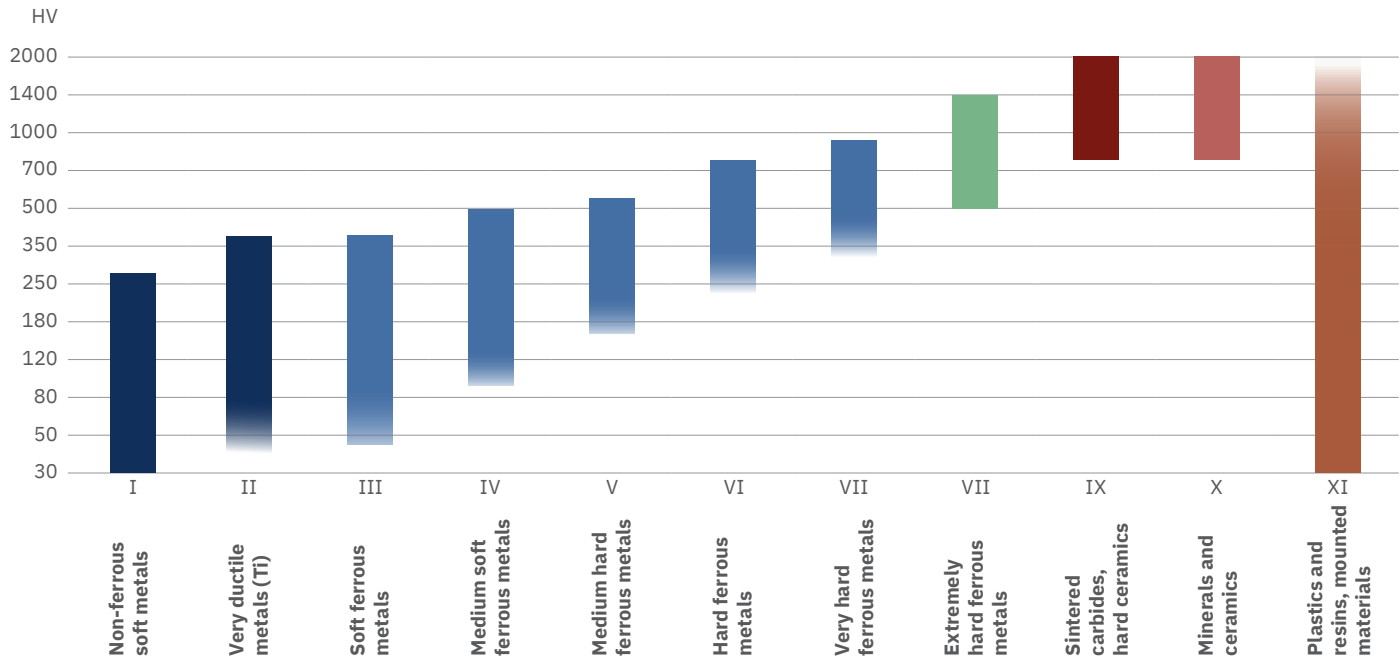


	Abrasive	Bond
●	SiC	Bakelite
●	Al <sub>2</sub> O <sub>3</sub>	Bakelite
●	CBN	Bakelite
●	Diamond	Bakelite Hard and ductile materials
●	Diamond	Metal Hard and brittle materials
●	Diamond	Metal electroplated Mounted materials, predominately resin

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/-20	350 x 2,5 x 32
Exotom/Unitom-2/-5/-50	350 x 2,5 x 32
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
Discoflan-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 4) 305 x 1.8 x 32 5) 305 x 1.5 x 32	

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.



10S51			30A51	40A51 42A51 <sup>10</sup>	50A51 52A51 <sup>10</sup>	60A51 62A51 <sup>10</sup>	B0C50	B0D51 <sup>17</sup>	MOD51 <sup>16</sup>	E0D36 <sup>3</sup>
10S43	20S43		30A 43	40A43 42A43 <sup>10</sup>	50A43 52A43 <sup>10</sup> 58A43 <sup>18</sup>	60A43 62A43 <sup>10</sup> 66A43 <sup>12</sup> 68A43 <sup>18</sup>	B0C41 <sup>1</sup>	B0D35 <sup>2</sup>	MOD35 <sup>2</sup>	E0D36 <sup>3</sup>
10S40	20S40		30A40	40A40	50A40 58A40	60A40 68A40	B0C41 <sup>1</sup>	B0D35 <sup>2</sup>	MOD35 <sup>2</sup>	E0D36 <sup>3</sup>
10S35	20S35	20A35	20A35	30A35	40A35	50A35 56A35 <sup>12</sup> 58A35 <sup>18</sup>	B0C35 <sup>6</sup>	B0D35 <sup>2</sup> B7D35 <sup>2/15</sup>	MOD35 <sup>2</sup>	E0D36 <sup>3</sup>
10S35	20S35	49A35 <sup>19</sup> 30A35	49A35 <sup>19</sup> 40A35	49A35 <sup>19</sup> 50A35 56A35 <sup>12</sup>	60A35 66A35 <sup>12</sup>	60A35 66A35 <sup>12</sup>	B0C35 <sup>6</sup>	B0D35 <sup>2</sup> B7D35 <sup>2/15</sup>	MOD35 <sup>2</sup>	E0D36 <sup>3</sup>
10S35	30S35	20A35	30A35	40A35	50A35 56A35 <sup>12</sup> 58A35 <sup>18</sup>	60A35 66A35 <sup>12</sup> 68A43 <sup>18</sup>	B0C35 <sup>6</sup>	B0D35 <sup>2</sup> B7D35 <sup>2/15</sup>	MOD35 <sup>2</sup>	E0D36 <sup>3</sup>
10S30	20S30		30A30	40A30	50A30	60A30 66A30 <sup>12</sup>	B0C31 <sup>4</sup>	B0D31 <sup>4</sup>	MOD31 <sup>5</sup>	E0D30 <sup>5</sup>
10S25	20S25	20A25	30A25 33A25 <sup>9</sup>	40A25 46A25 <sup>12</sup>	54A25 50A25 <sup>11</sup> 56A25 <sup>12</sup>	60A25 66A25 <sup>12</sup>	B0C25 <sup>7</sup>	B0D25 <sup>8</sup>	MOD25 <sup>8</sup>	E0D25
10S24	20S24		30A24	40A24	50A24	60A24				
								B4D20	M4D20	

6) 350 x 1.8 x 32 7) Width = 1.3 8) Width = 1.1 9) Width = 0.8 10) Fiberglass reinforced 11) For hard and ductile materials, Ni-base alloys  
 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  
 19) Fiber reinforced

10S20	10S20	30A20	30A20	50A20	50A20	50A20	B0C20	B0D20	MOD20 <sup>13</sup> M1D20 <sup>13</sup>	E1D20
10S15	10S15	40A15 30A15	40A15 30A15	50A15	50A15	50A15	B0C15	B0D15	MOD15 M1D15	E0D15
30A13	30A13	30A13	30A13	50A13	50A13	50A13	B0C13	B0D13 <sup>13</sup>	MOD13 <sup>14</sup> M1D13 <sup>14</sup>	M1D13 <sup>14</sup>
M1D13 <sup>14</sup>	M1D13 <sup>14</sup>	B0C13 <sup>13</sup>	B0C13 <sup>13</sup>	B0C13 <sup>13</sup>	B0C13 <sup>13</sup>	B0C13 <sup>13</sup>	B0C13 <sup>13</sup>	B0D13 <sup>13</sup>	MOD13 <sup>14</sup> M1D13 <sup>14</sup>	M1D13 <sup>14</sup>
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.									MOD10 M1D10	M1D10
									MOD08 M1D08	M1D08

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

CUTTING

MOUNTING

GRINDING

POLISHING

VERIFICATION

ACCESSORIES



Premium Cut-off Wheel



Abrasive Cut-off Wheel

350 mm Abrasive Cut-off  
Wheels

## Cutting Abrasive

### 508 mm Abrasive Cut-off Wheels

40009160

**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.

40009161

**Cut-off wheel 30A51**

For cutting of medium soft ferrous metals (<HV 300). Aluminium oxide. Resin bond.  
508 mm (20") dia. x 3.5 mm x 32 mm dia., 3 pcs.

40009162

**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. Aluminium oxide. Resin bond.  
508 mm (20") dia. x 3.5 mm x 32 mm dia., 3 pcs.

40009163

**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. Aluminium oxide. Resin bond.  
Fibre reinforced  
508 mm (20") dia. x 3.5 mm x 32 mm dia., 3 pcs.

40009164

**Cut-off wheel 50A51**

For cutting of hard ferrous metals (HV 450 - 600). Aluminium oxide. Resin bond.  
508 mm (20") dia. x 3.5 mm x 32 mm dia., 3 pcs.

40009165

**Cut-off wheel 52A51**

For cutting of hard ferrous metals (HV 450 - 600). Aluminium oxide. Resin bond.  
Fibre reinforced  
508 mm (20") dia. x 3.5 mm x 32 mm dia., 3 pcs.

40009166

**Cut-off wheel 60A51**

For cutting of extra hard ferrous metals (>HV 600). Aluminium oxide. Resin bond.  
508 mm dia. x 3.5 mm x 32 mm dia. 3 pcs.

40009167

**Cut-off wheel 62A51**

For cutting of very hard ferrous metals (> HV 600). Aluminium oxide. Resin bond.  
Fibre reinforced  
508 mm (20") dia. x 3.5 mm x 32 mm dia., 3 pcs.

### 432 mm Abrasive Cut-off Wheels

40009150

**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.

40009170

**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.

### 432 mm Abrasive Cut-off Wheels

40009151	<p><b>Cut-off Wheel 30A43</b> For cutting of medium soft ferrous metals (&lt; HV 300) and for general applications. Aluminium oxide. Resin bond 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009152	<p><b>Cut-off Wheel 40A43</b> For cutting of medium hard ferrous metals (HV 200 - 500), stainless steel and general applications. Aluminium oxide. Resin bond 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009158	<p><b>Cut-off Wheel 42A43</b> For cutting of case hardened and medium hard ferrous metals (HV 200 - 700), and for stainless steel. Fibre-reinforced. Aluminium oxide. Resin bond 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009153	<p><b>Cut-off Wheel 50A43</b> For cutting of hard ferrous metals (HV 450 - 600). Aluminium oxide. Resin bond 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009154	<p><b>Cut-off Wheel 52A43</b> For cutting of hard ferrous metals (HV 450 - 600). Fibre-reinforced. Aluminium oxide. Resin bond 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009174	<p><b>Cut-off wheel, Premium 58A43</b> For high volume cutting of hard ferrous metals (HV 450-600). With spiral pattern. Aluminium oxide. Resin bond. 432 mm (17") dia. x 2.7 mm x 32 mm dia. 5 pcs.</p>
40009155	<p><b>Cut-off Wheel 60A43</b> For cutting of extra hard ferrous metals (&gt; HV 600). Aluminium oxide. Resin bond 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009156	<p><b>Cut-off Wheel 62A43</b> For cutting of extra hard ferrous metals (&gt; HV 600). Fibre-reinforced. Aluminium oxide. Resin bond 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009159	<p><b>Cut-off Wheel, Hexagonal 66A43</b> For cutting of extra hard ferrous metals (&gt;HV 600). With 3D hexagon pattern. Aluminium oxide. Resin bond 432 mm (17") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40009175	<p><b>Cut-off wheel, Premium 68A43</b> For high volume cutting of very hard ferrous metals (HV &gt;600). With spiral pattern. Aluminium oxide. Resin bond. 432 mm (17") dia. x 2.7 mm x 32 mm dia. 5 pcs.</p>

### 400 mm Abrasive Cut-off Wheels

40000104	<p><b>Cut-off wheel 10S40</b> For cutting of soft, non-ferrous metals (HV 30 - 300). Silicon carbide. Resin bond 400 mm (16") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>
40000105	<p><b>Cut-off wheel 20S40</b> For cutting of very ductile metals (e.g. titanium) (HV 70 - 400). Silicon carbide. Resin bond 400 mm (16") dia. x 3.0 mm x 32 mm dia. 5 pcs.</p>

### 400 mm Abrasive Cut-off Wheels

40000106	<b>Cut-off wheel 30A40</b> For cutting of medium soft ferrous metals (<HV 300). Aluminium oxide. Resin bond 400 mm (16") dia. x 3.0 mm x 32 mm dia. 5 pcs.
40000107	<b>Cut-off wheel 40A40</b> For cutting of medium hard ferrous metals (HV 200 - 500), stainless steel and general applications. Aluminium oxide. Resin bond 400 mm (16") dia. x 3.0 mm x 32 mm dia. 5 pcs.
40000108	<b>Cut-off wheel 50A40</b> For cutting of hard ferrous metals (HV 450 - 600). Aluminium oxide. Resin bond 400 mm (16") dia. x 3.0 mm x 32 mm dia. 5 pcs.
40000109	<b>Cut-off wheel 58A40</b> Premium Cut-off wheel. For cutting of hard ferrous metals (HV 450 - 600). With spiral pattern. Aluminium oxide. Resin bond 400 mm (16") dia. x 2.5 mm x 32 mm dia. 5 pcs.
40000110	<b>Cut-off wheel 60A40</b> For cutting of extra hard ferrous metals (> HV 600). Aluminium oxide. Resin bond 400 mm (16") dia. x 3.0 mm x 32 mm dia. 5 pcs.
40000111	<b>Cut-off wheel 68A40</b> Premium Cut-off wheel. For cutting of extra hard ferrous metals (> HV 600). With Spiral pattern. Aluminium oxide. Resin bond 400 mm (16") dia. x 2.5 mm x 32 mm dia. 5 pcs.

### 350 mm Abrasive Cut-off Wheels

40009120	<b>Cut-off Wheel 10S35</b> 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)/Labotom-20 (2.500 rpm). Silicon carbide. Resin bond 350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.
40009121	<b>Cut-off Wheel 20S35</b> For cutting of very ductile metals (e.g. titanium) (HV 70 - 400) on Axitom (1.950 rpm) and Labotom-15 (2.350 rpm)/Labotom-20 (2.500 rpm). Silicon carbide. Resin bond 350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.
40009122	<b>Cut-off Wheel 30S35</b> 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.
40009123	<b>Cut-off Wheel 20A35</b> 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). Aluminium oxide. Resin bond 350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.



## 350 mm Abrasive Cut-off Wheels

40009124	<p><b>Cut-off Wheel 30A35</b> For cutting of soft ferrous metals, steel tubes and small pieces (HV 80 - 400) on Labotom-15 (2.350 rpm) /Labotom-20 (2.500 rpm). For cutting of medium soft ferrous metals (&lt;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). Aluminium oxide. Resin bond</p> <p>350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.</p>
40009125	<p><b>Cut-off Wheel 40A35</b> For cutting of medium soft ferrous metals (&lt;HV 300) on Labotom-15 (2.350 rpm)/ Labotom--20 (2.500 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). Aluminium oxide. Resin bond</p> <p>350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.</p>
40009180	<p><b>Cut-off wheel 49A35</b> Fiber-reinforced for manual cutting of soft to medium hard ferrous metals in a range between 100-500 HV. For Labotom-15 and Labotom-20. Aluminum oxide. Resin bond</p> <p>350 mm (14") dia. x 2.2 mm x 32 mm dia. 10 pcs.</p>
40009126	<p><b>Cut-off Wheel 50A35</b> For cutting of medium hard ferrous metals (HV 200 - 500) and stainless steel on Labotom-15 (2.350 rpm) /Labotom-20 (2.500 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). Aluminium oxide. Resin bond</p> <p>350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.</p>
40009168	<p><b>Cut-off wheel 55A35</b> 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. Aluminium oxide. Resin bond</p> <p>350 mm (14") dia. x 3,0 mm x 32 mm dia. 8 pcs.</p>
40009127	<p><b>Cut-off Wheel, Hexagonal 56A35</b> For cutting of medium hard ferrous metals (HV 200 - 500) and stainless steel on Labotom-15 (2.350 rpm)/Labotom-20 (2.500 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. Aluminium oxide. Resin bond</p> <p>350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.</p>
40009172	<p><b>Cut-off wheel, Premium 58A35</b> 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. Aluminium oxide. Resin bond.</p> <p>350 mm (14") dia. x 2.2 mm x 32 mm dia. 10 pcs.</p>
40009128	<p><b>Cut-off Wheel 60A35</b> For manual cutting of hard and very hard ferrous metals (HV 300 - 800) on Labotom-15 (2.350 rpm) /Labotom-20 (2.500 rpm). For cutting of very hard ferrous metals (HV 400 - 800) on Unitom (2.775 rpm). Aluminium oxide. Resin bon</p> <p>350 mm (14") dia. x 2.5 mm x 32 mm dia. 10 pcs.</p>

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### 350 mm Abrasive Cut-off Wheels

- 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)/Labotom-20 (2.500 rpm). For cutting of very hard ferrous metals (HV 400 - 800) on Unitom (2.775 rpm). With 3-D hexagon pattern. Aluminium 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)/Labotom-20 (2.500 rpm). Suitable for high volume cutting. With spiral pattern. Aluminium 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. Aluminium 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. Aluminium 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. Aluminium 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). Aluminium 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. Aluminium 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.

## 250 mm Abrasive Cut-off Wheels

40009103	<p><b>Cut-off Wheel 20A25</b> For cutting of soft ferrous metals, steel tubes and small pieces (HV 80 - 400). Aluminium oxide. Resin bond 250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.</p>
40009104	<p><b>Cut-off Wheel 30A25</b> For cutting of medium soft ferrous metals (&lt;HV 300) and for general applications. Aluminium oxide. Resin bond 250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.</p>
40009105	<p><b>Cut-off Wheel 33A25</b> Thin (0.8 mm) cut-off wheel for delicate cutting of medium soft ferrous metals (&lt;HV 300). Aluminium oxide. Resin bond 250 mm (10") dia. x 0.8 mm x 32 mm dia. 10 pcs.</p>
40009106	<p><b>Cut-off Wheel 40A25</b> For cutting of medium hard ferrous metals (HV 200 - 500), stainless steel and general applications. Aluminium oxide. Resin bond 250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.</p>
40009107	<p><b>Cut-off Wheel Hexagonal 46A25</b> For cutting of medium hard ferrous metals (HV 200 - 500), stainless steel and general applications. With 3D hexagon pattern. Aluminium oxide. Resin bond 250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.</p>
40009108	<p><b>Cut-off Wheel 50A25</b> For cutting of hard and ductile ferrous metals and Ni-based alloys (HV 450 - 600). Aluminium oxide. Resin bond 250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.</p>
40009112	<p><b>Cut-off Wheel 54A25</b> 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. Aluminium oxide. Resin bond 250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.</p>
40009109	<p><b>Cut-off Wheel, Hexagonal 56A25</b> For cutting of hard ferrous metals (HV 450 - 600) and for softer ferrous metals with diameters above 50 mm (2"). With 3D hexagon pattern. Aluminium oxide. Resin bond 250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.</p>
40009110	<p><b>Cut-off Wheel 60A25</b> For cutting of extra hard ferrous metals (&gt;HV 600). Aluminium oxide. Resin bond 250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.</p>
40009111	<p><b>Cut-off Wheel, Hexagonal 66A25</b> For cutting of extra hard ferrous metals (&gt;HV 600). With 3D hexagon pattern. Aluminium oxide. Resin bond 250 mm (10") dia. x 1.5 mm x 32 mm dia. 10 pcs.</p>

## 235 mm Abrasive Cut-off Wheels

40009134	<p><b>Cut-off Wheel 10S24</b> For cutting of soft, non-ferrous metals (HV 30 - 300). Silicon carbide. Resin bond 235 mm (9") dia. x 1.5 mm x 22 mm dia. 10 pcs.</p>
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### 235 mm Abrasive Cut-off Wheels

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

### Dia./CBN Cut-off Wheels

- 40000096 **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.
- 40000095 **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.
- 40000094 **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.
- 40000077 **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.
- 40000036 **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.
- 40000093 **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.
- 40000082 **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.
- 40000075 **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.

**Dia./CBN Cut-off Wheels**

40000035	<b>Diamond Cut-off Wheel B0D31</b> For cutting of sintered carbides and ceramics (> HV 800). Resin bond 305 mm (12") dia. x 1.8 mm x 32 mm dia.
40000081	<b>Diamond Cut-off Wheel E0D30</b> For cutting of mounted samples and components containing resin or plastic. Electroplated 300 mm (12") dia. x 1.5 mm x 32 mm dia.
40000034	<b>Diamond Cut-off Wheel M0D25</b> For cutting of ceramics (> HV 800) and minerals. Metal bond, high concentration 250 mm (10") dia. x 1.1 mm x 32 mm dia.
40000033	<b>Diamond Cut-off Wheel B0D25</b> For cutting of sintered carbides and ceramics (> HV 800). Resin bond 254 mm (10") dia. x 1.1 mm x 32 mm dia.
40000080	<b>Diamond Cut-off Wheel E0D25</b> For cutting of mounted samples and components containing resin or plastic. Electroplated 250 mm (10") dia. x 1.5 mm x 32 mm dia.
40000079	<b>CBN Cut-off Wheel B0C41</b> 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.
40000078	<b>CBN Cut-off Wheel B0C35</b> 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.
40000076	<b>CBN Cut-off Wheel B0C31</b> 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.
40000018	<b>CBN Cut-off Wheel B0C25</b> 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	<b>Diamond Cut-off Wheel M4D20</b> 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	<b>Diamond Cut-off Wheel B4D20</b> 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.

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*Cooli Additive**Bandfilter paper*

## Others

49900065	<b>Filter tube 100 l</b> 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
06166901	<b>Bandfilter paper</b> Width: 500 mm. For use with Coolimat-200 bandfilter (06161116)
05766914	Bandfilter paper for use with band filter (057663xx). Width: 45 cm Roll with 90 m
06526901	Width: 500 mm. For use with Coolimat-2000 with bandfilter. Includes 4 x rolls, each length 100 m. Filter paper roll
05766915	<b>Paper for Static Filter</b> 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	<b>Filter paper</b> For Accutom-10 and Accutom-100 100 pcs.
49900001	<b>Disposable Liners</b> 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 (Coolimat 200, 06161X16) 5 pcs.



Cut-off Wheels



Diamond Precision Cut-off Wheels

## Cutting Precision

### 200 mm Abrasive Cut-off Wheels

40000092	<b>Cut-off Wheel 10S20</b> For cutting of soft non-ferrous metals (HV 70 - 400). For Secotom. SiC. Resin bond 200 mm (8") dia. x 0.8 mm x 22 mm dia. 5 pcs.
40000087	<b>Cut-off Wheel 30A20</b> For cutting of medium hard ferrous metals (< HV 500). For Secotom. Aluminium oxide. Resin bond 200 mm (8") dia. x 0.8 mm x 22 mm dia. 5 pcs.
40000086	<b>Cut-off Wheel 50A20</b> For cutting of hard ferrous metals (> HV 500). For Secotom. Aluminium oxide. Resin bond 200 mm (8") dia. x 0.8 mm x 22 mm dia. 5 pcs.

### Abrasive prec. Cut-off Wheels

40000103	<b>Cut-off Wheel 10S15</b> For cutting of soft non-ferrous metals (HV 30 - 400). For Secotom-10/-15/-50/-6/-20/-60 and 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.
40000102	<b>Cut-off Wheel 30A15</b> For cutting of medium soft ferrous metals (<HV 300) and for general applications. For Secotom-10/-15/-50/-6/-20/-60 and Accutom-100/-10/-50/-5/-2. Aluminium oxide. Resin bond 150 mm (6") dia. x 0.5 mm x 12.7 mm dia. 5 pcs.
40000101	<b>Cut-off Wheel 40A15</b> For cutting of medium hard ferrous metals (HV 200 - 500), stainless steel and general applications. For Secotom-10/-15/-50/-6/-20/-60 and Accutom-100/-10/-50/-5/-2. Aluminium oxide. Resin bond 150 mm (6") dia. x 0.5 mm x 12.7 mm dia. 5 pcs.
40000100	<b>Cut-off Wheel 50A15</b> For cutting of hard ferrous metals (HV 500 - 800) and for specimens with relatively large dimensions. For Secotom-10/-15/-50/-6/-20/-60 and Accutom-100/-10/-50/-5/-2. Aluminium oxide. Resin bond 150 mm (6") dia. x 0.5 mm x 12.7 mm dia. 5 pcs.

### Abrasive prec. Cut-off Wheels

- 40000045 **Cut-off Wheel 30A13**  
For cutting of medium hard ferrous metals (< HV 500). For Accutom and Secotom. Aluminium oxide. Resin bond  
125 mm (5") dia. x 0.5 mm x 12.7 mm dia. 5 pcs.
- 40000044 **Cut-off Wheel 50A13**  
For cutting of hard ferrous metals (> HV 500). For Accutom and Secotom. Aluminium oxide. Resin bond  
125 mm (5") dia. x 0.5 mm x 12.7 mm dia. 5 pcs.

### Dia./CBN prec. Cut-off Wheels

- 40000084 **Diamond Cut-off Wheel MOD20**  
For cutting of ceramics and minerals (> HV 800). Can be used with manual cutting table. For Secotom. 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. 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/-6/-20/-60. 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. 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 MOD15**  
For cutting of ceramics and minerals (> HV 800). For Secotom-10/-15/-50/-6/-20/-60 and Accutom-100/-10/-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/-6/-20/-60 and Accutom-100/-10/-50/-5. Metal bond, low concentration  
152 mm (6") dia. x 0.4 mm x 12.7 mm dia.
- 40000055 **Diamond Cut-off Wheel B0D15**  
For cutting of sintered carbides and ceramics (> HV 800). For Secotom-10/-15/-50/-6/-20/-60 and Accutom-100/-10/-50/-5. Resin bond  
152 mm (6") dia. x 0.8 mm x 12.7 mm dia.
- 40000089 **Diamond Cut-off Wheel E0D15**  
For cutting of mounted samples and components containing resin or plastic. For Secotom and Accutom-100/-10/-50/-5. Electroplated, multi-layer.  
150 mm (6") dia. x 0.4 mm x 12.7 mm dia.



\*\*\* Hazardous goods fee per shipment

Find Safety Data Sheets (SDS) on [struers.com](http://struers.com)**Dia./CBN prec. Cut-off Wheels**

40000038	<p><b>Diamond Cut-off Wheel MOD13</b> For cutting of ceramics and minerals (&gt; HV 800). For Secotom-10/-15/-50/-6/-20/-60, 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><b>Diamond Cut-off Wheel M1D13</b> For cutting of hard and brittle materials. For Minitom, Accutom and Secotom. Metal bond, low concentration. Metal bond, low concentration 127 mm (5") dia. x 0.4 mm x 12.7 mm dia.</p>
40000039	<p><b>Diamond Cut-off Wheel B0D13</b> For cutting of sintered carbides and ceramics (&gt; HV 800). For Secotom-10/-15/-50/-6/-20/-60, 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><b>Diamond Cut-off Wheel MOD10</b> For precision cutting of ceramics and minerals. For Secotom-10/-15/-50/-6/-20/-60, 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><b>Diamond Cut-off Wheel M1D10</b> For cutting of hard and brittle materials. For Minitom, Accutom and Secotom. Metal bond, low concentration 102 mm (4") dia. x 0.3 mm x 12.7 mm dia.</p>
40000041	<p><b>Diamond Cut-off Wheel MOD08</b> For high precision cutting of very small specimens. Mainly recommended for ceramics and minerals. For Secotom-10/-15/-50/-6/-20/-60, 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><b>Diamond Cut-off Wheel M1D08</b> For cutting of hard and brittle materials. For Accutom and Secotom. Metal bond, low concentration 76 mm (3") dia. x 0.15 mm x 12.7 mm dia.</p>
40000074	<p><b>CBN Cut-off Wheel B0C20</b> For cutting of extremely hard ferrous metals (HV 500 - 1400). For Secotom-10/-15/-50/-60/-20/-60. Resin bond, high concentration 203 mm (8") dia. x 0.9 mm x 22 mm dia.</p>
40000073	<p><b>CBN Cut-off Wheel B0C15</b> For cutting of extremely hard ferrous metals (HV 500 - 1400). For Secotom-10/-15/-50/-6/-20/-60 and Accutom-100/-50/-10/-5 Resin bond, high concentration 152 mm (6") dia. x 0.8 mm x 12.7 mm dia.</p>
40000040	<p><b>CBN Cut-off Wheel B0C13</b> For cutting of extremely hard ferrous metals (HV 500 - 1400). For Secotom-10/-15/-50/-6/-20/-60, 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>

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## Other Cutting Consumables

Additive	
49900068	<p><b>Corrozip-Cu</b> 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.</p> <p>1 l Additive for Cooling Systems</p>
49900069	5 l Additive for Cooling Systems
49900072	<p><b>Cooli Additive Plus</b> High performance cutting additive for recirculation water. Additive to improve cutting and cooling properties and protect the machine from corrosion. Recommended concentration: 4%</p> <p>4 L</p>
49900071	1 L
49900073	<p><b>Cooli Additive</b> 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%</p> <p>4 L</p>
49900074	1 L
49900070	<p><b>Water-free Cutting Fluid</b> For cutting of water-sensitive materials on Accutom-5/-50/-10/-100 or Secotom-10/-15/-50/-6/-20/-60. Special pump tube (Cat. No. 05996921) required on Accutom-10/-100 and Secotom-15/-50/-6/-20/-60</p> <p>5 l</p>
49900040***	<p><b>Unitclean</b> For cleaning of Recirculation Cooling Units to stop attack of micro-organisms and remove unpleasant odours</p> <p>1 l</p>



**BUY IN WEBSHOP**



# THREE TIMES AS MANY CUTS

with Cooli Additive Plus

- ✓ A safe work environment  
No allergens, free of boric acid
- ✓ Pre-dosed bottles ready to use
- ✓ Three times as many cuts  
In case-hardened steel
- ✓ Up to 30% more cuts  
Optimized for aluminum alloy



# MOUNTING

## Struers Mounting Consumables

No matter what your application is, you'll find a Struers mounting material 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 to achieve an efficient work process.

### Hot Mounting

If you need high quality, uniform size, and short process times, our hot mounting solutions are ideal.

Simply place the specimen and mounting material in the mounting press cylinder. To ensure premium mounting performance, we encourage you to use our hot mounting materials with our mounting presses. That's because the machines are designed to control all parameters of the mounting process, such as the cooling and heating cycle and dosing. In that way, you get the most out of your investment.




## Cold Mounting






Our cold mounting material protects brittle and fragile specimens during the preparation process, and delivers high quality mounts for microscopic inspection. Struers epoxy range delivers high quality impregnation of your pours specimens without compromising on speed.

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



# HOT MOUNTING SELECTION GUIDE

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

DuroFast	LevoFast	PolyFast	PuriFast	MultiFast
				
Epoxy with mineral filler	Melamine with mineral and glass filler	Bakelite with carbon filler	Polypropylene with wood and mineral 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 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	General used for soft to medium hard materials	Routine examination of soft to medium hard materials. Color coding
Thermosetting	Thermosetting	Thermosetting	Thermoplastic	Thermosetting
.	.	.	...	...
...	...	..	.	...
Low	High	High	High	Medium
180	180	180	150 - 180	180
20	25	20	25	25
3,5	3,5	3,5	3	3
325	250	250	250	250
2	2	1.5	2	2
High	High	High	High	High
5.5	5.5	5	5	5
For hard materials Excellent edge retention	For soft to medium hard materials. Excellent edge retention	SEM examination	Unclassified, no hazardous components For soft to medium hard materials. Perfect as backing	Routine examination of soft to medium hard materials. Suitable as backing

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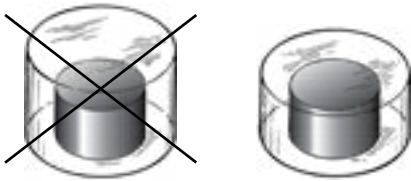
# HOT MOUNTING HOW TO OPTIMIZE THE PROCESS TIME

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

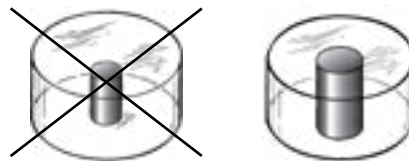
One of the factors limiting both the heating and cooling times is the relatively low heat conductivity

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:

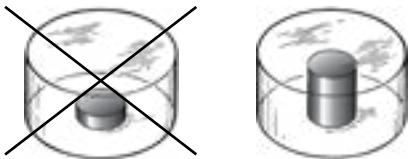
**The amount of resin is optimized:**



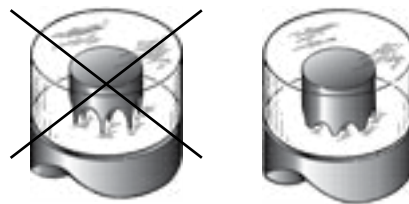
**Choose smallest possible mounting cylinder:**



**A relatively high instead of a low specimen 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 and LevoFast with PuriFast, MultiFast and CitoFast**

DuroFast or LevoFast can be used with PuriFast, MultiFast or CitoFast as backing material. Add approx. 1/3 of DuroFast/LevoFast to make the

preparation surface and then complete the mount with 2/3 of the backing material. Use CitoFast for fast mounting.

## **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. Mount release agent, AntiStick cannot be used with PuriFast.

## **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

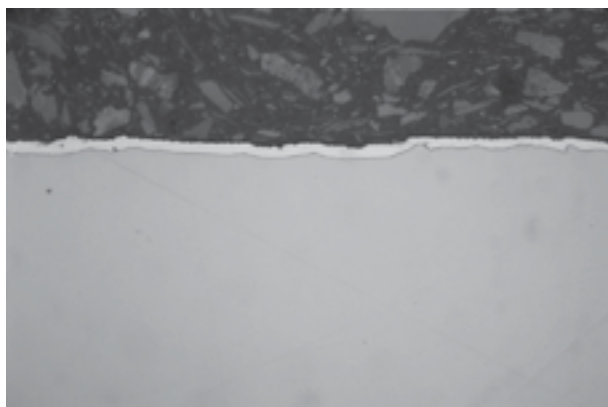
To obtain the best results the specimens must be clean, dry and free from grease. If necessary, clean with alcohol or another suitable degreasing fluid.

### Preheating

For porous and/or pressure sensitive specimens, such as minerals, electronic parts etc., it is advantageous to soften the mounting material by heating, before applying pressure. Preheating is also useful when using thermoplastic materials i.e. ClaroFast and PuriFast.

We recommend applying pressure for the last minute only to protect the specimen. If the total heating time is i.e. 8 minutes, preheating should be set to 7 minutes at 0 bar and hereafter 1 minutes at 100 - 350 bar according to the properties of the specimens.

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.



Polished zinc coating, Mounted in PolyFast 1000 x

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).

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 mounting materials. This is useful when dealing with temperature sensitive materials. For PuriFast the heating time is unchanged using 150 °C or 180 °C.

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

### Porous Specimens

Thermoplastic mounting material, (ClaroFast and PuriFast), penetrate into porous specimens. The best results are obtained by initially preheating the material (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 materials, (ClaroFast and PuriFast), should be used. The best results are obtained by initially preheating the materials (see Pre-heating).

**For very pressure sensitive specimens, hot compression mounting should be avoided. Use Struers cold mounting materials 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. Add ½ - 1 minute to the heating time for the first mount to heat the cylinder.
- 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 mounting material in the tables has been adjusted to result in a final height of the mounts of approx. 20 mm (0.8”).
- If several mounting materials are combined in one mount, use the process parameters for the mounting materials 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
	PuriFast	20	3	150 - 180	300	2	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
	PuriFast	25	3	150 - 180	250	2	High	5
	MultiFast	25	3	180	250	2	High	5

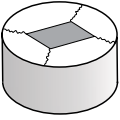
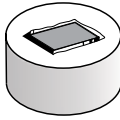
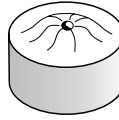
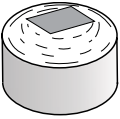
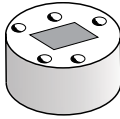

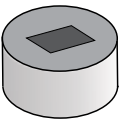
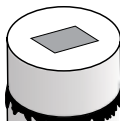
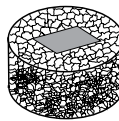
Cylinder dia.	Resin		Heating			Cooling		Time
	Type	Quantity	Time	Temp.	Pressure	Time	Rate	Total time
1½"		[ml]	[min]	[°C]	[bar]	[min]		[min]
	ClaroFast	20	4	180	350	6.5	Low	10.5
	CitoFast	25	2.5	180	300	1	High	3.5
	ConduFast	20	3.5	180	250	1.5	High	5
	DuroFast	20	4	180	325	2	High	6
	LevoFast	25	3.5	180	250	2	High	5.5
	PolyFast	20	3.5	180	250	1.5	High	5
	PuriFast	25	3.5	150 - 180	250	2	High	5.5
	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
	PuriFast	40	4.5	150 - 180	250	2.5	High	7
	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
	PuriFast	45	4	150 - 180	250	2.5	High	6.5
	MultiFast	45	4	180	250	2.5	High	6.5

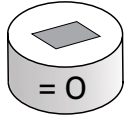
Cylinder dia.	Resin		Heating			Cooling		Time
	Type	Quantity	Time	Temp.	Pressure	Time	Rate	Total time
50 mm / 2"		[ml]	[min]	[°C]	[bar]	[min]		[min]
	ClaroFast	55	5	180	250	8.5	Low	13.5
	CitoFast	65	3.5	180	250	2	High	5.5
	ConduFast	65	4	180	250	2	High	6
	DuroFast	70	5.5	180	250	3	High	8.5
	LevoFast	75	6	180	250	3	High	9
	PolyFast	55	5.5	180	250	2	High	7.5
	PuriFast	70	6	150 - 180	250	4	High	10
	MultiFast	70	6	180	250	4	High	10

# HOT MOUNTING TROUBLE SHOOTING GUIDE

General Problems					
<p><b>Radial Cracking</b></p> 	<p><b>Cause:</b> Insufficient distance between specimen edge/corner and cylinder wall, or specimen has sharp corners</p> <p><b>Solution:</b> 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><b>Shrinkage</b></p> 	<p><b>Cause:</b> Incorrect choice of resin.</p> <p><b>Solution:</b> Re-mount a new specimen using a resin with a lower linear shrinkage value.</p>	<p><b>Blistering</b></p> 	<p><b>Cause:</b> Insufficient heating time.</p> <p><b>Solution:</b> Increase heating time, or increase process temperature.</p> <p><b>Cause:</b> Overcured surface.</p> <p><b>Solution:</b> Decrease process temperature.</p> <p><b>Cause:</b> Entrapped gas within mount.</p> <p><b>Solution:</b> Preheat resin.</p>
<p><b>Bulging</b></p> 	<p><b>Cause:</b> Insufficient cooling.</p> <p><b>Solution:</b> Increase cooling time.</p>	<p><b>Porosity</b></p> 	<p><b>Cause:</b> Excessive temperature.</p> <p><b>Solution:</b> Reduce process temperature.</p>	<p><b>Voiding within large mounts</b></p> 	<p><b>Cause:</b> Insufficient heating time.</p> <p><b>Solution:</b> Increase heating time.</p> <p><b>Cause:</b> Excessive temperature.</p> <p><b>Solution:</b> Reduce process temperature.</p> <p><b>Cause:</b> Insufficient force/pressure.</p> <p>Increase mounting force/pressure.</p>
<p><b>Dull Surface Finish</b></p> 	<p><b>Cause:</b> Insufficient heating time.</p> <p><b>Solution:</b> Increase heating time.</p>	<p><b>Adhesion between mount and rams</b></p> 	<p><b>Cause:</b> Insufficient application of mould release agent. Except for PuriFast. Release agent cannot be used with PuriFast.</p> <p><b>Solution:</b> 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><b>Cause:</b> Insufficient heating time.</p> <p><b>Solution:</b> Increase heating time.</p> <p><b>Cause:</b> Excessive force/pressure.</p> <p><b>Solution:</b> Decrease mounting force/pressure.</p>	<p><b>Individual Grains Visible on Mount*</b></p> 	<p><b>Cause:</b> Resin has cured without force/pressure.</p> <p><b>Solution:</b> Increase force/pressure during heating cycle.</p> <p><b>Cause:</b> Insufficient heating time.</p> <p><b>Solution:</b> Increase the heating time and/or temperature.</p> <p>*Thermosetting resins only</p> <p>** For PuriFast are the individual grains always visible.</p>

### ConduFast Problems

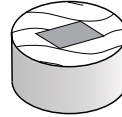
#### Lack of conductivity



**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

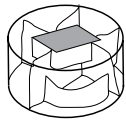


**Cause:** Insufficient amount of ClaroFast, (refer to Helpful Hints).  
**Solution:** Re-mount a new specimen using a larger amount of ClaroFast.

**Cause:** Excessive grinding time.  
**Solution:** Re-mount with a new specimen.

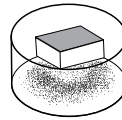
### ClaroFast Problems

#### Internal cracking



**Cause:** Excessive cooling rate.  
**Solution:** Reduce the cooling rate

#### “Cottonball” effect in centre of mount



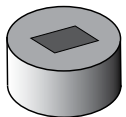
**Cause:** Excessive cooling rate.  
**Solution:** Reduce the cooling rate.

**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

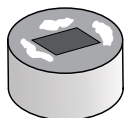
#### The mounts turn dark after preparation



**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

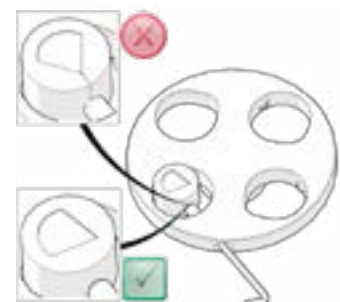


**Cause:** Insufficient heating time.  
**Solution:** Increase heating time and/or temperature



### PuriFast problem

#### Cracking specimens when clamping in specimen holder

**Cause:** Specimen clamped with too much force.  
**Solution:** Use max. 1.5 N or tighten the screw until it touches the mount and then turn the Allen key 2 sides (120 °) Make attention not to have a sharp edge on the specimen where the screw is clamped into the mount.  
If a PuriFast mount cracks it can be reprocessed to obtain a perfect mount.





# COLD MOUNTING SELECTION GUIDE FOR ACRYLICS

Material	VersoCit-2	ClaroCit
		
<b>Curing time</b>	10 min.	20 min.
<b>Shrinkage</b> from 1-4 (1 is best)	****	***
<b>Application</b>	<b>For routine examination</b> <ul style="list-style-type: none"> <li>• Routine examination of soft to medium hard materials</li> </ul>	<b>For extraordinarily clear mounts</b> <ul style="list-style-type: none"> <li>• For universal use</li> <li>• Target preparation</li> </ul>
<b>Mixing ratio weight recommended</b>	Liquid: 2 parts Powder: 3 parts	Liquid: 6 parts Powder: 10 parts
<b>Mixing ratio volume</b>	Liquid: 1 part Powder: 2 parts	Liquid: 2 parts Powder: 5 parts
<b>Mixing time</b>	30 s	1 ½ min.
<b>Potlife</b>	3 min.	1 ½ min.
<b>Colour</b>	Dull yellowish, partly transparent	Colourless, clear (extremely clear when cured under pressure)
<b>Can be coloured with EpoDye</b>		X
<b>Peak temperature</b>	100 °C / 212 °F	90 °C / 194 °F
<b>Hardness</b>	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.
*	**	***
<p><b>Fast curing and no shrinkage</b></p> <ul style="list-style-type: none"> <li>• For medium hard and hard ferrous metals and other hard materials – including ceramics, carbides etc.</li> <li>• For specimens where protection of layers is important e.g. coated specimens</li> <li>• Excellent edgeretention and planeness</li> </ul>	<p><b>Good edge-retention and planeness</b></p> <ul style="list-style-type: none"> <li>• For non-ferrous metals and soft ferrous metals</li> <li>• Low shrinkage</li> <li>• Low peak temperature</li> </ul>	<p><b>For vias and microvias</b></p> <ul style="list-style-type: none"> <li>• Excellent for filling of microvias</li> </ul> <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
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
		
<b>Curing time</b>	1 ½ hour in oven at 75 °C / 167 °F <sup>1)</sup>	3 ½ hours in oven at 50 °C / 122 °F <sup>1)</sup>
<b>Shrinkage</b> from 1-4 (1 is best)	*	*
<b>Application</b>	<b>For all-round vacuum impregnation</b> <ul style="list-style-type: none"> <li>• Short curing time</li> <li>• Low viscosity</li> <li>• Relatively hard after curing</li> </ul>	<b>Extremely good adhesion</b> <ul style="list-style-type: none"> <li>• Relative fast curing time</li> <li>• Very clear colourless mounts</li> <li>• Cures in oven or Drybox</li> </ul>
<b>Mixing ratio weight recommended</b>	Resin: 25 parts Hardener: 7 parts	Resin: 2.5 parts Curing Agent: 1 parts
<b>Mixing ratio volume</b>	Resin: 31 parts Hardener: 10 parts	Resin: 10.5 parts Curing Agent: 5 part
<b>Mixing time</b>	5 min.	3 min.
<b>Potlife</b>	> 60 min.	> 60 min.
<b>Colour</b>	Clear, transparent Refractive index: ND = 1.561	Clear, transparent Refractive index: ND = 1.573
<b>Can be coloured with EpoDye</b>	X	X
<b>Peak temperature</b>	170 °C / 338 °F	100 °C / 212 °F
<b>Hardness</b>	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. **																
*		*																
<p><b>For vacuum impregnation - low viscosity</b></p> <ul style="list-style-type: none"> <li>• Can be used on all types of specimens</li> <li>• Extremely low curing temperature – Very good for heat sensitive specimens</li> <li>• Superior penetration of cracks and pores</li> <li>• Excellent adhesion</li> </ul>	<p><b>For mounting and preparing specimens the same day</b></p> <ul style="list-style-type: none"> <li>• Suitable for vacuum impregnation</li> <li>• Excellent adhesion</li> <li>• Superior penetration of cracks and pores</li> </ul>	<p><b>DIAMETER OF CUP (mm) (")</b> ***</p> <table border="1"> <thead> <tr> <th></th> <th>Ø25 Ø1.00</th> <th>Ø30 Ø1.25</th> <th>Ø40 Ø1.50</th> </tr> </thead> <tbody> <tr> <td>&lt;23 &lt;73.4</td> <td>Dark Blue</td> <td>Dark Blue</td> <td>Dark Purple</td> </tr> <tr> <td>23-27 73.4-80.6</td> <td>Dark Blue</td> <td>Dark Purple</td> <td>Orange</td> </tr> <tr> <td>&gt;27 &gt;80.6</td> <td>Dark Purple</td> <td>Orange</td> <td>Orange</td> </tr> </tbody> </table> <p><b>RECOMMENDATIONS</b></p> <ul style="list-style-type: none"> <li>Dark Blue: Curing not possible in less than 4 hours</li> <li>Dark Purple: Accelerated system</li> <li>Orange: Standard system</li> </ul>		Ø25 Ø1.00	Ø30 Ø1.25	Ø40 Ø1.50	<23 <73.4	Dark Blue	Dark Blue	Dark Purple	23-27 73.4-80.6	Dark Blue	Dark Purple	Orange	>27 >80.6	Dark Purple	Orange	Orange
	Ø25 Ø1.00	Ø30 Ø1.25	Ø40 Ø1.50															
<23 <73.4	Dark Blue	Dark Blue	Dark Purple															
23-27 73.4-80.6	Dark Blue	Dark Purple	Orange															
>27 >80.6	Dark Purple	Orange	Orange															
Resin: 25 parts Hardener: 3 parts	Resin: 20 parts Hardener: 5.3 part	Resin: 20 parts Hardener: 4.2 parts Accelerator: 1.1 parts																
Resin: 15 parts Hardener: 2 parts	Resin: 20 parts Hardener: 5.3 part	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 40 mm cups and the room temperature is between 23-27°, it is recommended to use the ProntoFix accelerator.

CUTTING

MOUNTING

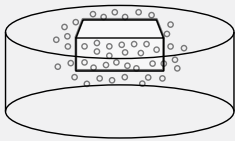
GRINDING

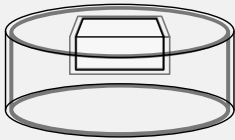
POLISHING

VERIFICATION

ACCESSORIES

# COLD MOUNTING TROUBLE SHOOTING GUIDE

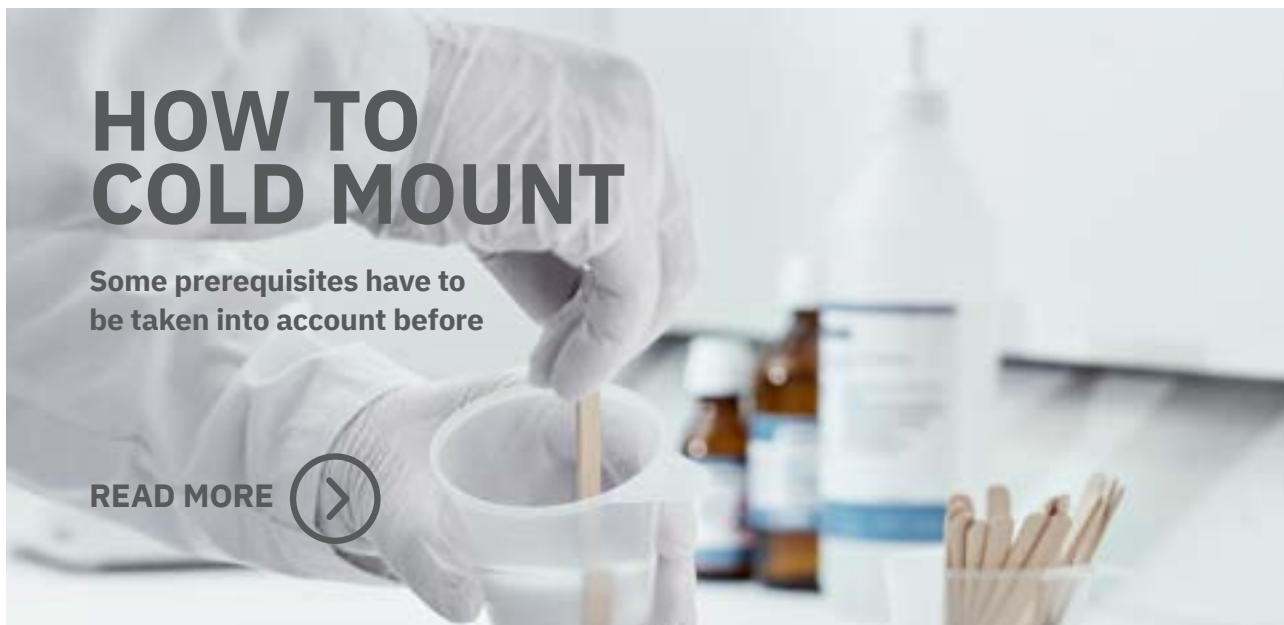
Problem	Cause	Solution
<b>Air bubbles along the sides of the specimen</b>    The system creates too many bubbles – generation of excessive heat	Lab temperature > 23°C	<ul style="list-style-type: none"> <li>Uncover the mount during curing</li> <li>Use Struers DryBox to increase airflow</li> <li>Use a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

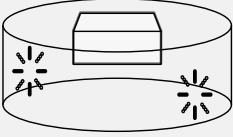
Problem	Cause	Solution
<b>High shrinkage</b>  	Too high temperature during curing	<ul style="list-style-type: none"> <li>Use Struers DryBox to increase airflow</li> </ul>
	Insufficient degreasing of specimen	<ul style="list-style-type: none"> <li>Clean and degrease specimens prior to mounting</li> </ul>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

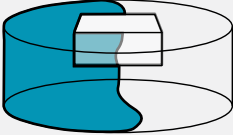
## HOW TO COLD MOUNT

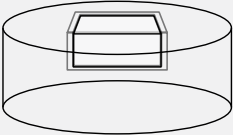
Some prerequisites have to be taken into account before

READ MORE



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

Problem	Cause	Solution
<b>Indraft/suction at the bottom of the specimen</b>  	Too high temperature during curing	<ul style="list-style-type: none"> <li>Use Struers DryBox to increase airflow</li> </ul>
	Specimen/ProntoFix volume ratio < 20% < 10% for metallic specimen (Too small specimen)	<ul style="list-style-type: none"> <li>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</li> </ul>

Problem	Cause	Solution
<b>Gap between ProntoFix and specimen</b>  	Too high temperature during curing	<ul style="list-style-type: none"> <li>Use Struers DryBox to increase airflow</li> </ul>
	Insufficient degreasing of specimen	<ul style="list-style-type: none"> <li>Clean and degrease specimens prior to mounting</li> </ul>
	Specimen/ProntoFix volume ratio < 20% < 10% for metallic specimen (Too small specimen)	<ul style="list-style-type: none"> <li>Use Struers DryBox to increase airflow</li> </ul>
	Too much hardener in relation to resin	<ul style="list-style-type: none"> <li>Mix resin and hardener in the correct ratio</li> </ul>



ClaroFast



LevoFast



PuriFast Natural, Red and Green Color

## 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

**MultiFast Black**

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

**PuriFast**

40100082	<b>PuriFast</b> Dust-free environmentally friendly hot mounting material. Polypropylene with wood and mineral filler. Thermoplastic. Natural color. 2.5 kg
----------	--

40100083	7.5 kg
40100084	30 kg (2x 15 kg)
40100085	90 kg (6x 15 kg)

40100086	<b>PuriFast Green</b> Dust-free environmentally friendly hot mounting material. Polypropylene with wood and mineral filler. Thermoplastic. Green. 2.5 kg
----------	--

40100087	7.5 kg
40100088	30 kg (2x 15 kg)
40100089	90 kg (6x 15 kg)

40100090	<b>PuriFast Red</b> Dust-free environmentally friendly hot mounting material. Polypropylene with wood and mineral filler. Thermoplastic. Red. 2.5 kg
----------	--

40100091	7.5 kg
40100092	30 kg (2x 15 kg)
40100093	90 kg (6x 15 kg)

**Others**

40300043	<b>AntiStick</b> Mould release agent. Stearate powder in applicator 8 g
----------	---

\*\*\* Hazardous goods fee per shipment

Find Safety Data Sheets (SDS) on [struers.com](http://struers.com)

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

\*\*\* Hazardous goods fee per shipment

Find Safety Data Sheets (SDS) on [struers.com](https://www.struers.com)**SpeciFix**

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

**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

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**DuroCit**

- 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

40300093	Flexible silicone rubber mounting cup for ClaroCit, DuroCit, VersoCit-2, LevoCit and ViaFix 25 mm dia. 5 pcs.
40300094	30 mm dia. 5 pcs.
40300095	1¼" dia. 5 pcs.
40300096	1½" dia. 5 pcs.
40300092	40 mm dia. 5 pcs.
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

## Others

40300012	<b>Flangeform</b> Mounting cup with flange. For AccuStop 30 30 mm dia. 3 pcs.
40300023	<b>PCB-Coupon Mould</b> 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	<b>MultiClips</b> Multiple plastic clip for holding up to 5 small and thin specimens when mounting 50 pcs.
40300026	<b>Fixation Clips</b> Metal spring clip for holding small and thin specimens when mounting 6 mm dia. 100 pcs.
40300025	9 mm dia. 100 pcs.
40300070	<b>Taper Section Angle, Aluminium</b> Aluminium angle for mounting of taper sections 50 pcs.
40300071	<b>Taper Section Angle, Copper</b> Copper angle for mounting of taper sections 50 pcs.
40300069	<b>Taper Section Angle, Steel</b> Steel angle for mounting of taper sections 50 pcs.
40300091	<b>ProntoFix Empty Bottle</b> Empty bottle for premixing ProntoFix Hardener and ProntoFix Accelerator 1 bottle 500 ml, 1 label
40300080	<b>Consumables Kit</b> Disposable consumables for CitoVac 100 dispensing tubes and one chamber protector
40300030	Consumables for Epovac 80 polyethylene tubes, 80 mixing cups, 80 stirrers and 2 rubber plugs
40300032	For mixing of cold mounting systems 400 mixing cups and 400 stirrers
05696101	<b>Mixer for mixing of Epoxy</b> For optimal mixing of cold mounting epoxies 1 mixer and 1 disposable propeller



EpoDye

### Others

40300072	<b>Disposable Propeller</b> To be used with Struers Mixer (05696101) 20 pcs.
40300047	<b>Disposable Syringes</b> Syringes for measuring of epoxy resins and hardeners 5 ml. 100 pcs.
40300048	10 ml. 100 pcs.
40300049	20 ml. 50 pcs.
40300002	<b>EpoDye</b> Fluorescent dye for use with EpoFix, ProntoFix, SpeciFix, CaldoFix, ClaroCit and ViaFix. Special filters for microscope required. 20 g
40300076	<b>Silicone Oil</b> Silicone release agent 100 ml



# GRINDING

## **Reproducible Result - Time After Time**

Whatever your material and whatever your preparation goal is, discover new opportunities to optimize your grinding process. Struers helps you to achieve a plane specimen and eliminate artifacts as efficiently as possible based on a systematic approach to improve your methods with high quality consumables that add value to your process.

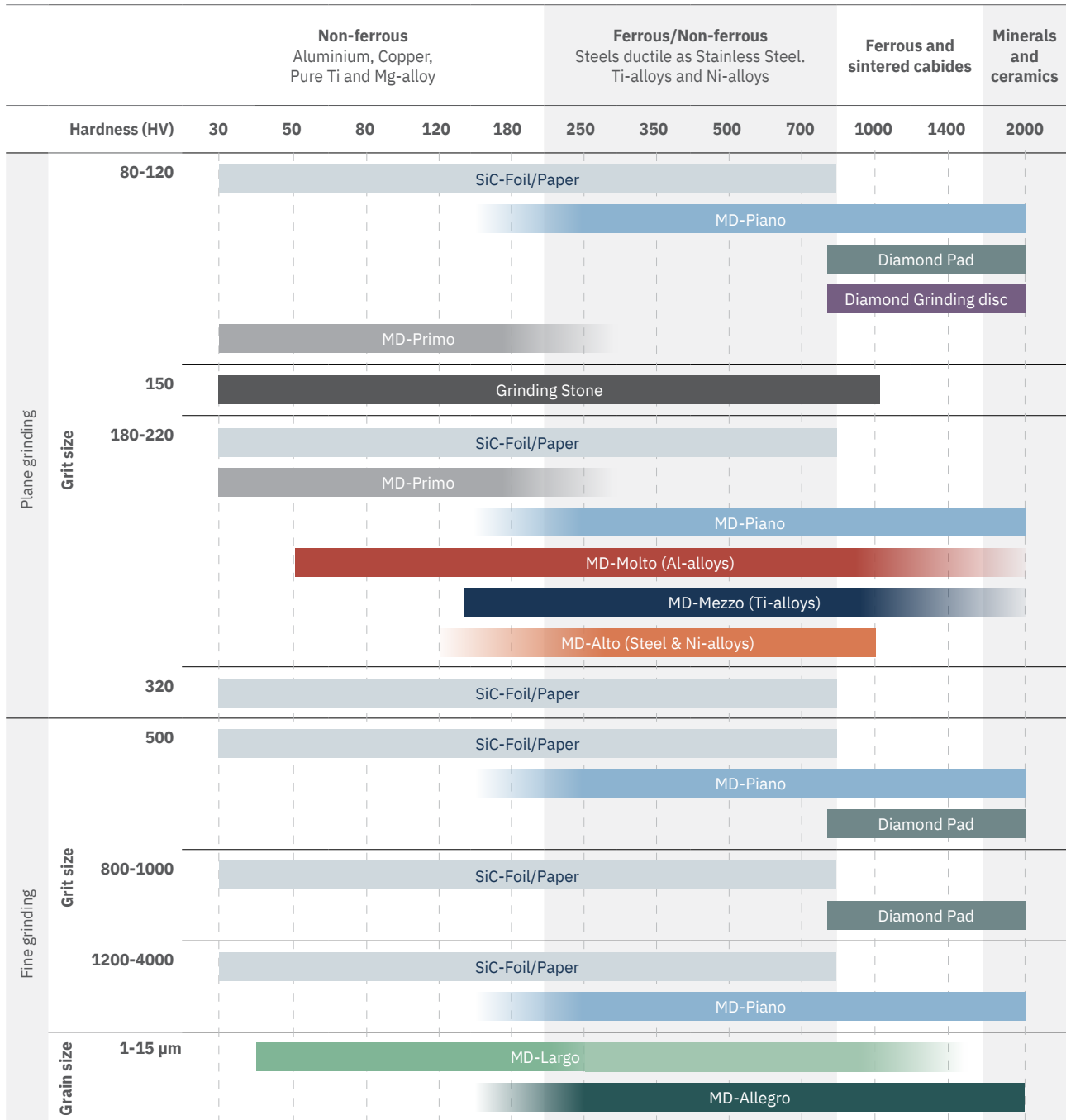
## **MD-System**

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.**



## Whatever your need, there is a Struers grinding solution for you





		<b>Application area</b>	<b>Hardness range</b>	<b>Grinding stone or disc</b>	<b>Grit size (FEPA F)</b>	<b>Abrasive and bond</b>
High removal plane grinding		Non-ferrous metals	40-250 HV	2S27	# 150	Resin bonded silicon carbide
		Non-ferrous metals	40-250 HV	2S36	# 150	Resin bonded silicon carbide
		Stainless steel and nickel-based alloys	150-500 HV	3A27	# 150	Resin bonded aluminum oxide
		Stainless steel and nickel-based alloys	150-500 HV	3A36	# 150	Resin bonded aluminum oxide
		Medium hard ferrous metals	250-700 HV	4A27	# 150	Resin bonded aluminum oxide
		Medium hard ferrous metals	250-700 HV	4A36	# 150	Resin bonded aluminum oxide
		Hard steels or steels containing many carbides	500-800 HV	6A27	# 150	Resin bonded aluminum oxide
		Hard steels or steels containing many carbides	500-800 HV	6A36	# 150	Resin bonded aluminum oxide





## TECHNICAL DATA

### Grinding Stones and Diamond Grinding Disc

Cooling media	Run-in time - pre-dressing needed	Maintenance of the surface	Stone/Disc diameter sizes / Equipment
Water	None	Dressing with diamond dresser (on the equipment)	270 mm / Hexamatic
Water	None	Dressing with diamond dresser (on the equipment)	356 mm / AbraPlan
Water	None	Dressing with diamond dresser (on the equipment)	270 mm / Hexamatic
Water	None	Dressing with diamond dresser (on the equipment)	356 mm / AbraPlan
Water	None	Dressing with diamond dresser (on the equipment)	270 mm / Hexamatic
Water	None	Dressing with diamond dresser (on the equipment)	356 mm / AbraPlan
Water	None	Dressing with diamond dresser (on the equipment)	270 mm / Hexamatic
Water	None	Dressing with diamond dresser (on the equipment)	356 mm / AbraPlan

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		<b>Application area</b>	<b>Hardness range</b>	<b>Grinding stone or disc</b>	<b>Grit size (FEPA F)</b>	<b>Abrasive and bond</b>
High removal plane grinding		Ceramics and sintered carbides	>800 HV	8D27	# 120	Resin bonded diamonds
		Ceramics and sintered carbides	>800 HV	8D36	# 120	Resin bonded diamonds
		Metal and general applications	250-700 HV	PAMST	# 150	Resin bonded aluminum oxide



## TECHNICAL DATA

### Grinding Stones and Diamond Grinding Disc

Cooling media	Run-in time - pre-dressing needed	Maintenance of the surface	Stone/Disc diameter sizes / Equipment
Water	None	Dressing with Aluminum oxide specimens (to be clamped into a specimen holder)	270 mm / Hexamatic
Water	None	Dressing with Aluminum oxide specimens (to be clamped into a specimen holder)	356 mm / AbraPlan
Water	None	Dressing with diamond dresser (on the equipment)	200 mm / Prepamatic & Prepamatic-2

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		<b>Application area</b>	<b>Hardness range</b>	<b>MD surface</b>	<b>Finish comparable to SiC Paper or Foil # size (FEPA P)</b>	<b>Abrasive and bond</b>
Plane grinding		Ferrous metals & hard materials	150-2000 HV	MD-Piano (3 grits)	80, 120, 220	Embedded resin bonded diamonds
		Non-ferrous metals and soft materials	40-250 HV	MD-Primo (2 grits)	120, 220	Embedded resin bonded SiC
		Stainless steel & nickel-based alloys	120-1000 HV	MD-Alto	220	Resin bonded aluminum oxide
		Titanium alloys and hard materials containing titanium	150-2000 HV	MD-Mezzo	220	Embedded resin bonded diamonds
		Aluminum alloys and hard materials containing aluminum	50-2000 HV	MD-Molto	220	Embedded resin bonded diamonds
Fine grinding		Ferrous metals & hard materials	150-2000 HV	MD-Piano (2 grits)	500, 1200	Embedded resin bonded diamonds
		Materials harder than 150 HV	>150 HV	MD-Allegro	500	Suspension/spray 15-6 µm
		Ferrous metals & hard materials	150-2000 HV	MD-Piano (2 grits)	2000, 4000	Embedded resin bonded diamonds
		Soft materials & composites with soft matrix	40-1500 HV	MD-Largo	1200	Suspension/spray 9-3 µm



## TECHNICAL DATA

### MD grinding

Cooling media	Run-in time – pre-dressing needed	Maintenance of the surface	Indicative lifetime per surface (Number of SiC Papers or Foils)	Surface diameter sizes
Water	None	Dressing with sintered alumina stick from time to time	100	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"
Water	None	Dressing with sintered alumina stick from time to time	100	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"*
Water	None	None for most materials. Diamond dressing tool available if needed	50	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"
Water	None	Dressing with sintered alumina stick from time to time	100	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"
Water	None	Dressing with sintered alumina stick from time to time	100	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"
Water	None	Dressing with sintered alumina stick from time to time	100	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"
Lubricant / suspension / All-in-One	None	None	>100	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"
Water	None	Dedicated sintered alumina stick. Dress from time to time.	300	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"
Lubricant / suspension / All-in-One	None	None	>100	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"

\* MD-Primo 120

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		<b>Application area</b>	<b>Hardness range</b>	<b>Surface</b>	<b>Grain sizes available</b>	<b>Abrasive and bond</b>
Plane grinding		Ceramics, sintered carbides and very hard, ferrous metals	>600 HV	Diamond Pad	250 µm	Metal bonded diamonds
		Ceramics, sintered carbides and very hard, ferrous metals	>600 HV	Diamond Pad	125 µm	Metal bonded diamonds
Fine grinding		Minerals, ceramics, sintered carbides and very hard ferrous metals	>600 HV	Diamond Pad	40 µm	Metal bonded diamonds
		Minerals, ceramics, sintered carbides and very hard ferrous metals	>600 HV	Diamond Pad	20 µm	Metal bonded diamonds

## Adaptor for magnetic disc

	<b>Adaptor</b>	<b>Description</b>	<b>Surface diameter sizes</b>
	MD-Rondo	Adapter for use with self adhesive consumables on the MD-disc. For easy exchange of consumables.	200 mm / 8" 250 mm / 10" 300 mm / 12"



## TECHNICAL DATA

### Diamond Pads – Self adhesive grinding surfaces

Cooling media	Run-in time – pre-dressing needed	Maintenance of the surface	Indicative lifetime per surface (Number of of SiC Paper or Foil)	Surface diameter sizes
Water	None	None	>100	200 mm / 8" 250 mm / 10" 300 mm / 12"
Water	None	None	>100	200 mm / 8" 250 mm / 10" 300 mm / 12"
Water	None	None	>100	200 mm / 8" 250 mm / 10" 300 mm / 12"
Water	None	None	>100	200 mm / 8" 250 mm / 10" 300 mm / 12"

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		<b>Application area</b>	<b>Hardness range</b>	<b>Surface</b>	<b>Grain sizes available (FEPA P)</b>
<b>Silicon Carbide Grinding Foil</b>					
Plane grinding		All materials	30 - 800 HV	SiC Foil	80, 120, 180, 220, 320
		All materials	30 - 800 HV	SiC Foil	500, 800, 1000, 1200
Fine grinding		All materials	30 - 400 HV	SiC Foil	2000, 4000*
<b>Silicon Carbide Grinding Paper</b>					
Plane grinding		All materials	30 - 800 HV	SiC Paper	80, 120, 180, 220, 320
		All materials	30 - 800 HV	SiC Paper	500, 800, 1000, 1200
Fine grinding		All materials	30 - 400 HV	SiC Paper	2000, 2400*, 4000*

\*not a part of FEPA P





# TECHNICAL DATA

## Silicon Carbide Grinding Foils and Papers

Ab abrasive	Backing material	Cooling media	Run-in time – pre-dressing needed	Surface diameter sizes
Adhesive bonded SiC grains	PET foil	Water	None	200 mm / 8” 250 mm / 10” 300 mm / 12” 350 mm / 14”
Adhesive bonded SiC grains	PET foil	Water	None	200 mm / 8” 250 mm / 10” 300 mm / 12” 350 mm / 14”
Adhesive bonded SiC grains	PET foil	Water	None	200 mm / 8” 250 mm / 10” 300 mm / 12” 350 mm / 14”
Adhesive bonded SiC grains	Plain paper	Water	None	200 mm / 8” 230 mm / 9” 250 mm / 10” 305 mm / 12”
Adhesive bonded SiC grains	Plain paper	Water	None	200 mm / 8” 230 mm / 9” 250 mm / 10” 305 mm / 12”
Adhesive bonded SiC grains	Plain paper	Water	None	200 mm / 8” 230 mm / 9” 250 mm / 10” 305 mm / 12”

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## SiC Foil adaptors

	Adaptor	Description	Surface diameter sizes
<b>MD-Disc</b>	MD-Gekko 	Adaptor for use with SiC Foils on the MD-Disc. For easy exchange of consumables	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"
<b>Aluminum preparation disc</b>	Gekko PSA 	Self adhesive foil for use with SiC Foils. To be glued onto the Aluminum disc	200 mm / 8" 250 mm / 10" 300 mm / 12"
<b>Wet grinding disc</b> Aluminum disc with retention ring	Cannot be used		

## Grit / Grain size comparison

These are guideline values only. Grit sizes are defined as a range and not a single value. FEPA is the Federation of European Producers of Abrasives. ANSI is the American National Standards Institute. Struers grinding paper / foil follows the FEPA P standard while grinding stones and similar follow the Fepa F standard.

Grain size	200 µm	125 µm	82 µm	68 µm	46 µm
FEPA P (Europe)	P80	P120	P180	P220	P320
FEPA F (Europe)	F80	F100	F150	F180	F240
ANSI/UAMA (US)*	#80	#120	#180	#220	#280

\* ANSI standard B74.18



# TECHNICAL DATA

## Silicon Carbide Grinding Foils and Papers

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### SiC Paper adaptors

	Adaptor	Description	Surface diameter sizes
<b>MD-Disc</b>	MD-Fuga 	Metal disc with an adhesive layer for holding SiC Paper. Ensuring magnetic fixation on MD-Disc. For easy exchange of consumables	200 mm / 8" 250 mm / 10" 300 mm / 12"
<b>Aluminum preparation disc</b>	Adhesive Disc 	Double-sided adhesive discs for easy adhesion of SiC paper onto the Aluminum disc	200 mm / 8" 230 mm / 9" 250 mm / 10" 300 mm / 12"
<b>Wet grinding disc</b> Aluminum disc with retention ring	Can be used directly		

30 µm	22 µm	18 µm	15 µm	7 µm	4 µm
P500	P800	P1000	P1200	P2000	P4000
F320	F360	F400	F500	F800	F1200
#320	#360	#400	#500	#800	#1200



Grinding Stones



MOP15 Diamond Cup Wheel



Diamond Grinding Disc

## High Removal Plane Grinding

### Grinding Stones

40800005	<p><b>Grinding Stone PAMST</b> Aluminium oxide grinding stone, for plane grinding of metals on Prepamatic and Prepamatic-2 Grit 150. 200 mm (8") dia.</p>
40800177	<p><b>Grinding stone 6A36 #150</b> Aluminium 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><b>Grinding stone 4A36 #150</b> Aluminium oxide grinding stone, for fast plane grinding of metals &gt;HV 250 on AbraPlan and MAPS. Grit 150. 356 mm (14") dia.</p>
40800178	<p><b>Grinding stone 3A36 #150</b> Aluminium 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><b>Grinding stone 2S36 #150</b> 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><b>Grinding stone 6A27 #150</b> Aluminium 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><b>Grinding stone 4A27 #150</b> Aluminium oxide grinding stone, for fast plane grinding of metals &gt;HV 250 on Hexamatic Grit 150, 270 mm dia.</p>
40800182	<p><b>Grinding stone 3A27 #150</b> Aluminium 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><b>Grinding stone 2S27 #150</b> Silicon carbide grinding stone, for fast plane grinding of non-ferrous metals on Hexamatic Grit 150, 270 mm dia.</p>

## Diamond Grinding Discs

- 40800202 **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.
- 40800183 **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.

## Diamond Cup Wheels

- 40800013 **Diamond Cup Wheel MOP15**  
For grinding of hard, brittle materials on Discoplan-TS. Metal bonded  
70 µm. 150 mm (6") dia. x 31.75 mm dia.
- 40800014 **Diamond Cup Wheel BOP15**  
For grinding of hard, ductile materials on Discoplan-TS. Resin bonded  
35 µm. 150 mm (6") dia. x 31.75 mm dia.

## Cup Wheels

- 40800083 **Diamond Cup Wheel BOP10**  
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.
- 40800082 **Diamond Cup Wheel MOP10**  
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.
- 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 **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.
- 40800199 **Diamond cup wheel MOP15**  
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.
- 40800200 40 µm. 150 mm (6") dia. x 12.7 mm dia.

## Petrodisc-M

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



*MD Fine Grinding Surfaces*



*MD-Mezzo  
Diamond Grinding Surface*



*MD-Molto  
Diamond Grinding Surface*

## Magnetic Grinding Discs (MD)

<b>MD-Piano</b>	
40800121	<b>MD-Piano 80</b> Resin bonded diamond grinding surface 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	<b>MD-Piano 120</b> Resin bonded diamond grinding surface 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	<b>MD-Piano 220</b> Resin bonded diamond grinding surface 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	<b>MD-Piano 500</b> Resin bonded diamond grinding surface 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	<b>MD-Piano 1200</b> Resin bonded diamond grinding surface 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.

**MD-Piano**

40800139	300 mm (12") dia.
40800140	350 mm (14") dia.
40800141	<b>MD-Piano 2000</b> Resin bonded diamond grinding surface 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")
40800143	300 mm (12")
40800144	350 mm (14")
40800145	<b>MD-Piano 4000</b> Resin bonded diamond grinding surface 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-Alto**

40800204	<b>MD-Alto 180</b> Resin bonded aluminum oxide grinding surface for plane grinding of ductile materials as stainless steel & nickel-based alloys. Surface finish comparable to SiC-Paper grit 220 (FEPA P). For magnetic fixation on MD-Disc 200 mm (8") dia. 2 pcs.
40800205	250 mm (10") dia. 2 pcs.
40800206	300 mm (12") dia. 2 pcs.
40800207	350 mm (14") dia. 2 pcs.

**MD-Molto**

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

**MD-Mezzo**

40800191	<b>MD-Mezzo 220</b> Resin bonded diamond grinding surface 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.

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**MD-Primo**

40800085	<b>MD-Primo 120</b> Grinding surface 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 200 mm (8") dia.
40800086	250 mm (10") dia.
40800087	300 mm (12") dia.
40800118	350 mm (14") dia.
40800088	<b>MD-Primo 220</b> Grinding surface 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 200 mm (8") dia.
40800089	250 mm (10") dia.
40800090	300 mm (12") dia.

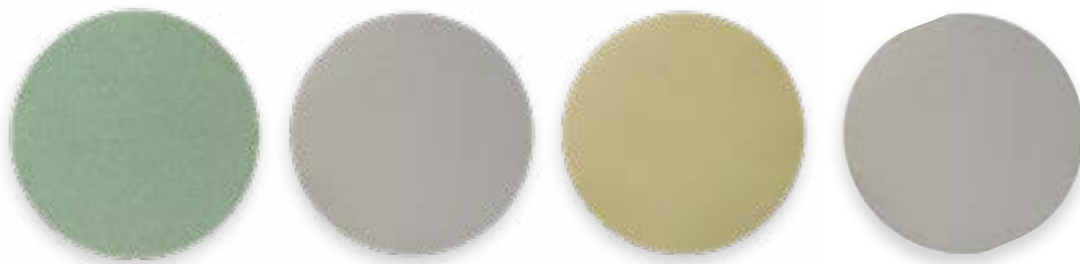
**MD-Allegro**

40500134	Maintenance-free composite surface 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 surface 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

### 300 mm Diamond Pad

40800037	<b>Diamond Pad</b> 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.

### 250 mm Diamond Pad

40800033	<b>Diamond Pad</b> 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.

### 200 mm Diamond Pad

40800025	<b>Diamond Pad</b> 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.



SiC Foils



MD-Gekko



SiC Papers



MD-Fuga

## Silicon Carbide (SiC) Grinding Foils and Papers

### 350 mm SiC Foil

40400260	<b>SiC Foil</b> 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.

### 300 mm SiC Foil

40400240	<b>SiC Foil</b> 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.

### 300 mm SiC Foil

- 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.

### 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.

### 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.

## MD-Gekko

49900047	<b>MD-Gekko</b> 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	<b>Gekko PSA</b> Self adhesive Gekko Foil for use with SiC Foil or self adhesive consumables. To be glued on an aluminium disc. 200 mm dia. 2 pcs.
49900054	250 mm dia. 2 pcs.
49900055	300 mm dia. 2 pcs.

## 305 mm SiC Paper

40400062	<b>Silicon Carbide Grinding Paper</b> 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 #1000). 305 mm (12") dia. 50 pcs.
40400038	Grit 4000 (US #1200). 305 mm (12") dia. 50 pcs.

## 250 mm SiC Paper

40400065	<b>Silicon Carbide Grinding Paper</b> 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.
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.

## 250 mm SiC Paper

40400026	Grit 2400 (US #1000). 250 mm (10") dia. 50 pcs.
40400027	Grit 4000 (US #1200). 250 mm (10") dia. 50 pcs.

## 230 mm SiC Paper

40400059	<b>Silicon Carbide Grinding Paper</b> 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.
40400183	For wet grinding of materials (HV 30 - 400). Plain back Grit 2000 (US #1000). 230 mm (9") dia. 50 pcs.
40400024	Grit 2400 (US #1000). 230 mm (9") dia. 50 pcs.
40400025	Grit 4000 (US #1200). 230 mm (9") dia. 50 pcs.

## 200 mm SiC Paper

40400056	<b>Silicon Carbide Grinding Paper</b> 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 #1000). 200 mm (8") dia. 50 pcs.
40400014	Grit 4000 (US #1200). 200 mm (8") 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	<b>Adhesive Discs</b> 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	<b>Silicon Carbide Grinding Paper</b> 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 Polishing Film

### Diamond Film

40400179	For polishing with TriPod polishing fixture. PET foil backing 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.
40400173	30 µm. 200 mm (8") dia. 5 pcs.

### Aluminium 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.

## Other Grinding Consumables

Others Dressing	
40800045	<p><b>Diamond Point</b> 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>
40800044	<p><b>Dressing Stick</b> Aluminium 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) 1 pcs.</p>
40800186	<p>Aluminium oxide stick for truing and opening of MD-Piano 2000 and 4000 diamond fine grinding discs. Dressing stick MD-Piano 2000/4000</p>
40800203	<p><b>Dressing specimen</b> Aluminium oxide specimens for truing and opening of diamond grinding discs 8D27 / 8D36 and for MD-Piano if manual dressing is not possible. To be clamped in specimen holder 05946906 for Hexamatic or 02606920 for other machines. 25 x 50 x 32 mm (1" x 2" x 1.25") 6 pcs.</p>
40800240	<p><b>Diamond dresser</b> Manual diamond dresser for MD-Alto. To retain the removal rate 1 pcs.</p>

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Flapper Wheel



Polishing Cloths



Transcopy kit

## Non-destructive Testing

### Grinding

40800053	<b>Flapper Wheel</b> For coarse grinding with TransPol Grit 80. 40 mm (1½") dia. x 10 mm, shaft 6 mm dia. 5 pcs.
40400049	<b>Silicon Carbide Paper</b> Silicon carbide grinding paper, for grinding on Transpol-2 and Transpol. Self-adhesive Grit 60. 32 mm (1¼") dia. 100 pcs.
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	<b>DP-Dur</b> Cloth for diamond polishing. For use with Transpol. Satin woven silk. Self-adhesive 32 mm (1¼") dia. 25 pcs.
40500041	<b>DP-Mol</b> Cloth for diamond polishing. For use with Transpol. Woven wool. Self-adhesive 32 mm (1¼") dia. 25 pcs.
40500042	<b>DP-Nap</b> Cloth for diamond polishing. For use with Transpol. Short synthetic nap. Self-adhesive 32 mm (1¼") dia. 25 pcs.
40500043	<b>OP-Felt</b> Cloth for oxide polishing. For use with Transpol. Thick felt. Self-adhesive 32 mm (1¼") dia. 25 pcs.
40500145	<b>DP-Dac</b> Cloth for diamond polishing. For Transpol-2 and Transpol. Satin woven acetate. Self-adhesive 32 mm (1¼") dia. 25 pcs.
03926904	<b>Polishing Chamber</b> Flexible type. For MoviPol-3 and -5 50 pcs.



## 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	<b>Standard Slides</b> 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.

## Others

49900044	<b>Adhesive Tape</b> 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
49900027	<b>Cleaner</b> For heavy duty cleaning. Solopol (Krestopol) 4 tubes of 250 ml
49900000	<b>Concentrated Soap Solution</b> To be used in Hexamatic, Prepamatic, TargetMaster, MAPS and for ultrasonic cleaning 1 l
40900043	<b>Engraver Tip</b> Tungsten carbide tipped point for Engraver 1 pc.
40900041	<b>Tape Kit - TenuPol</b> For electrolytic blanking of 3 mm / 2.3 mm specimens to be electrolytically thinned for TenuPol 1 roll of tape and 1 hole punch
49900052	<b>Disposable Bowl Liner</b> For Tegramin-30 and -25 5 pcs.
49900056	For Tegramin-20 5 pcs.
49900041	For TegraPol-11, -15 and LaboPol-1, -2, -4, -5, -6 5 pcs

### Others

49900061	For LaboPol-20 5 pcs.
49900062	For LaboPol-30/-60 5 pcs.
49900067	For AbraPol-30 3 pcs.
49900033	<b>Protection caps</b> Plastic caps for cylindrical specimens or mounts 25 mm dia. 100 pcs.
49900034	30 mm dia. 100 pcs.
49900035	40 mm dia. 100 pcs.
49900036	50 mm dia. 100 pcs.
49900063	1¼" dia. 100 pcs.

### TargetSystem Consumables

05756914	<b>30 mm dia. Sample Chair</b> 30 mm dia. adapter for cross-sectioning on TargetMaster. To be inserted into TargetGrip (05756916). Max. specimen size 23 x 20.5 mm. Disposable 30 mm dia. 50 pcs.
05756908	<b>40 mm dia. Sample Chair</b> 40 mm dia. adapter for cross-sectioning on TargetMaster. To be inserted into TargetGrip (05756901). Max. specimen size 29 x 20.5 mm. Disposable 40 mm dia. 50 pcs.
05756917	<b>40 mm Elevated Sample Chair</b> 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.
05756912	<b>Mould Insert</b> Mould insert for use with 40 mm dia. mount cups. Max specimen size 35 x 20 mm. 40 mm dia. 50 pcs.
05756907	<b>Resin Barrier</b> Metal labels to be used together with Sample chair (05756908 and 05756914). 50 pcs.

### ViaKit/-Basic Consumables

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

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# POLISHING

## Struers Polishing Consumables

What preparation requirements do you have for your analysis? Do you have a high throughput or just the occasional specimens? Do you work with one kind of material or many? Our complete range of polishing consumables covers every need - for any material, any preparation goal, and any lab setup – to ensure accurate and reliable results, while improving your process speed, efficiency, and safety.

That's because each machine and consumable are designed to work together to control all of the parameters of the polishing process – helping you to 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 especially developed for extra-high performance and efficiency - reducing preparation times by 30% on average. Each DiaPro suspension has been developed and optimized 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
<b>MD-Plan</b>	Coated, woven polyester	Fine grinding of soft metals Pre-polishing of hard materials	15 - 3 $\mu\text{m}$	Very low	Hard
<b>MD-Pan</b>	Impregnated, non-woven technical textile	Fine grinding of soft metals Pre-polishing of hard and brittle materials	15 - 1 $\mu\text{m}$	Very low	Hard
<b>MD-Sat</b>	Woven acetate	Fine grinding and polishing of ferrous metals, non-ferrous metals, coatings and plastics	9 - 1 $\mu\text{m}$	Medium	Hard
<b>MD-Dur</b>	Satin woven natural silk	Fine grinding and polishing of ferrous metals, non-ferrous metals, coatings and plastics	9 - 1 $\mu\text{m}$	Medium	Hard
<b>MD-Dac</b>	Satin woven acetate	Polishing of all materials	9 - 3 $\mu\text{m}$	Medium	Hard
<b>MD-Mol</b> <b>MD-Mol APS</b>	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
<b>MD-Plus</b>	Synthetic nap	One step polishing for sintered carbides and steels	$\leq 3 \mu\text{m}$	High	Soft
<b>MD-Floc</b>	Synthetic nap	Polishing of all materials	$\leq 3 \mu\text{m}$	Very high	Very soft
<b>MD-Nap</b>	Synthetic short nap	Final polishing of all materials	$\leq 1 \mu\text{m}$	Very high	Very soft
<b>MD-Chem / MD-Chem NonStick</b>	Porous neoprene	Final polishing of all materials		High	Soft

## Metalogram Instructions

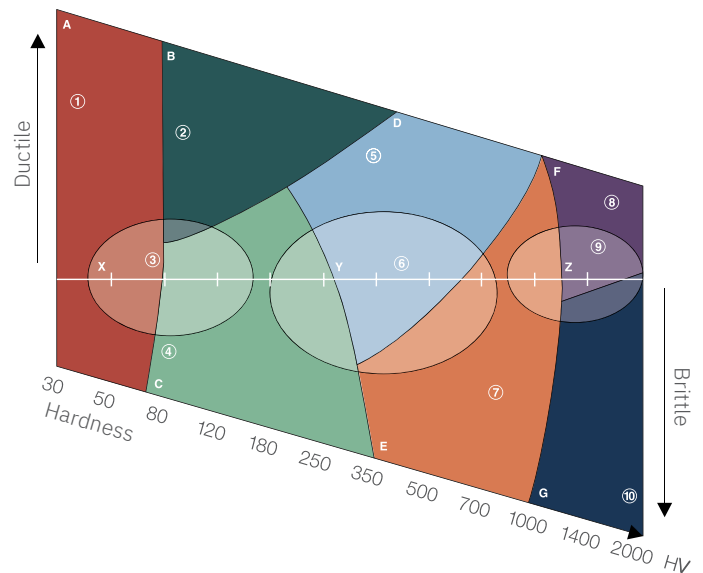
The Metalogram is our way of creating generic methods based on the two parameters, ductility and hardness.

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 0.25 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 0.25 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 0.25 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 0.25 µm
Method G Ex. Al <sub>2</sub> O <sub>3</sub>			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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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-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-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-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-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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**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-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.

*DP/OP-Polishing Cloths**OP-Nat**MD-Rondo***Diamond and Oxide 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-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.
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**DP-Dur**

40500209	250 mm (10") dia. 5 pcs.
40500210	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-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-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.

**DP-Dac**

40500212	Polishing cloth for polishing of all materials. Is used for diamond with particle size 9 - 3 $\mu\text{m}$ . 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.

**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-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.

### 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  $\mu\text{m}$ . 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-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.

### 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.

### 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.

# ALUMINUM

Avoid deformation when preparing aluminum and aluminum alloys  
Get recommendations for replacing coarse grits and learn how silicon dioxide suspension can ensure a thorough final polishing.

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Diamond products



DiaPro

## Diamond Products

### DiaPro

40600375	<p><b>DiaPro Pan 15 <math>\mu</math>m</b></p> <p>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</p> <p>500 ml</p>
40600376	5 l
40600369	<p><b>DiaPro Allegro/Largo 9 <math>\mu</math>m</b></p> <p>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</p> <p>500 ml</p>
40600370	5 l
40600385	<p><b>DiaPro Plan 9 <math>\mu</math>m</b></p> <p>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><b>DiaPro Sat 6 <math>\mu</math>m</b></p> <p>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><b>DiaPro Largo 3 <math>\mu</math>m</b></p> <p>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

**DiaPro**

40600379	<b>DiaPro Mol B 3 µm</b> 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 500 ml
40600380	5 l
40600393	<b>DiaPro Mol R 3 µm</b> 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 500 ml
40600394	5 l
40600395	<b>DiaPro Dur 3 µm</b> 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 500 ml
40600396	5 l
40600371	<b>DiaPro Dac 3 µm</b> 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 500 ml
40600372	5 l
40600387	<b>DiaPro Plus 3 µm</b> 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 500 ml
40600388	5 l
40600389	<b>DiaPro Floc 3 µm</b> 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 500 ml
40600390	5 l
40600381	<b>DiaPro Dur 1 µm</b> 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 500 ml
40600382	5 l

## DiaPro

40600373	<b>DiaPro Nap B 1 µm</b> 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 500 ml
40600374	5 l
40600397	<b>DiaPro Nap R 1 µm</b> 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 500 ml
40600398	5 l
40600383	<b>DiaPro Nap ¼ µm</b> 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 500 ml
40600384	5 l



DiaDuo



DP-Spray, M and P



DP-Stick P



DP-Paste P

## DiaDuo

40600036	<b>DiaDuo-2</b> All-purpose diamond suspension for materialographic 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-Suspension P



DP-Suspension M



DP-Suspension A

### DP-Suspension P

40600229 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

1  $\mu\text{m}$ . 125 ml

40600228 3  $\mu\text{m}$ . 125 ml

40600227 6  $\mu\text{m}$ . 125 ml

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

0.1  $\mu\text{m}$ . 500 ml

40600363  $\frac{1}{4}$   $\mu\text{m}$ . 500 ml

40600297  $\frac{1}{4}$   $\mu\text{m}$ . 2.5 l

40600362 1  $\mu\text{m}$ . 500 ml

40600251 1  $\mu\text{m}$ . 2.5 l

40600342 1  $\mu\text{m}$ . 5 l

40600361 3  $\mu\text{m}$ . 500 ml

40600250 3  $\mu\text{m}$ . 2.5 l

40600341 3  $\mu\text{m}$ . 5 l

40600360 6  $\mu\text{m}$ . 500 ml

40600249 6  $\mu\text{m}$ . 2.5 l

40600340 6  $\mu\text{m}$ . 5 l

40600359 9  $\mu\text{m}$ . 500 ml

40600248 9  $\mu\text{m}$ . 2.5 l

40600339 9  $\mu\text{m}$ . 5 l

40600358 15  $\mu\text{m}$ . 500 ml

40600247 15  $\mu\text{m}$ . 2.5 l

### DP-Suspension M

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

1  $\mu\text{m}$ . 500 ml

40600256 1  $\mu\text{m}$ . 2.5 l

40600346 1  $\mu\text{m}$ . 5 l

40600356 3  $\mu\text{m}$ . 500 ml

40600255 3  $\mu\text{m}$ . 2.5 l

40600345 3  $\mu\text{m}$ . 5 l

40600355 6  $\mu\text{m}$ . 500 ml

40600254 6  $\mu\text{m}$ . 2.5 l



\*\*\* Hazardous goods fee per shipment

Find Safety Data Sheets (SDS) on [struers.com](https://www.struers.com)**DP-Suspension M**

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
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

**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	<b>DP-Lubricant Green</b> Cooling and lubricating agent for fine grinding and diamond polishing of most materials. Water based 1 l
40700024	5 l
40700055	10 l

\*\*\* Hazardous goods fee per shipment

Find Safety Data Sheets (SDS) on [struers.com](https://www.struers.com)**DP-Lubricant**

40700005***	<b>DP-Lubricant Blue</b> 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
40700059	<b>DP-Lubricant Purple</b> 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	<b>DP-Lubricant Red</b> Lubricating agent for fine grinding and diamond polishing of softer materials. Oil in water emulsion 1 l
40700071	5 l
40700072	10 l
40700028***	<b>DP-Lubricant Brown</b> Cooling and lubricating agent for fine grinding and diamond polishing of water sensitive materials. Alcohol-based with polyethylene glycol 1 l
40700069***	<b>DP-Lubricant Yellow</b> Lubricating agent for fine grinding and diamond polishing of softer water sensitive materials. Alcohol-based 1 l

**Others**

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

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OP-S NonDry



OP-S



AP-A Powder

## Oxide Polishing

### OP-S NonDry

40700064 Non-drying fumed silica suspension for final polishing. Suitable for mixing with chemical additives for polishing of resistant materials. Ready to use. For preparing on pure non-ferrous metals the regular OP-S is recommended.

0.25  $\mu\text{m}$ . 1 l

40700065 0.25  $\mu\text{m}$ . 5 l

### OP-S

40700000 Standard fumed silica suspension for final polishing. Suitable for mixing with chemical additives for polishing of resistant materials. Ready to use.

0.25  $\mu\text{m}$ . 1 l

40700001 0.25  $\mu\text{m}$ . 5 l

### OP-U NonDry

40700066 Non-drying colloidal silica suspension for final polishing of all materials. Ready to use

0.04  $\mu\text{m}$ . 1 l

40700067 0.04  $\mu\text{m}$ . 5 l

### OP-U

40700002 Standard colloidal silica suspension for final polishing of all materials. Ready to use.

0.04  $\mu\text{m}$ . 1 l

40700003 0.04  $\mu\text{m}$ . 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  $\mu\text{m}$ . 500 ml

### AP-Products

40700049 **AP-A Powder**  
Agglomerated alpha alumina powder for polishing. To be mixed with demineralized water before use

0.3  $\mu\text{m}$ . 1 kg

40700048 1  $\mu\text{m}$ . 1 kg

40700047 5  $\mu\text{m}$ . 1 kg

\*\*\* Hazardous goods fee per shipment

Find Safety Data Sheets (SDS) on [struers.com](https://www.struers.com)

## AP-Products

40700041	<b>AP-D Powder</b> 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

## Electrolytical Preparation

### Electrolytes

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

# COPPER

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.

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## Replication

### 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
- 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

## RepliSet 50 ml Cartridges

40900078	<p><b>RepliSet-GF1</b> 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</p> <p>1 cartridge of 50 ml</p>
40900076	5 cartridges of 50 ml
40900079	<p><b>RepliSet-GT1</b> 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</p> <p>1 cartridge of 50 ml</p>
40900077	5 cartridges of 50 ml

## RepliSet 265 ml Cartridges

40900050	<p><b>RepliSet-F5</b> 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</p> <p>2 cartridges of 265 ml</p>
40900051	<p><b>RepliSet-F1</b> 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</p> <p>2 cartridges of 265 ml</p>
40900052	<p><b>RepliSet-T3</b> 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</p> <p>2 cartridges of 265 ml</p>
40900053	<p><b>RepliSet-T1</b> 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</p> <p>2 cartridges of 265 ml</p>

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## 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.
- 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.

## 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





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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	



# VERIFICATION

## **Struers Verification Consumables**

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

## **Calibration Results**

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



# BRINELL TEST BLOCKS (WITH OR WITHOUT CERTIFICATE)

The Brinell hardness test is used for larger specimens in materials with a coarse or inhomogeneous grain structure. Before performing the Brinell hardness test, the surface of the specimen 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		Hardness						
Test method	Load Factor	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	056483106
HBW 2.5/62.5		056482500	056482501	056482502	056482503	056482504	056482505	056482506
HBW 5/250			056481601	056481602	056481603	056481604	056481605	056481606
HBW 10/1000			056481201	056481202	056481203	056481204	056481205	056481206
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  $\pm 15$  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  $\pm 15$  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
6	056483007	056483008	056483009	056483010	056483011	056483012	056483013	056483014
6	056482407	056482408	056482409	056482410	056482411	056482412	056482413	056482414
6	056481507	056481508	056481509	056481510	056481511	056481512	056481513	056481514
6	056481007	056481008	056481009	056481010	056481011	056481012	056481013	056481014

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

### Vickers, Micro

All blocks will be supplied within  $\pm 25$  HV of the nominal value.

Block size: 30 mm diameter x 10 mm thickness.

### Vickers, Macro

All blocks will be supplied within  $\pm 25$  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	

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## 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 specimen material should be highly polished or electropolished before testing is performed.

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

### *Knoop*

*All blocks will be supplied within  $\pm 25$  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

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# ROCKWELL TEST BLOCKS (WITH OR WITHOUT CERTIFICATE)

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

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

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

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

- CUTTING
- MOUNTING
- GRINDING
- POLISHING
- VERIFICATION
- ACCESSORIES



# ACCESSORIES

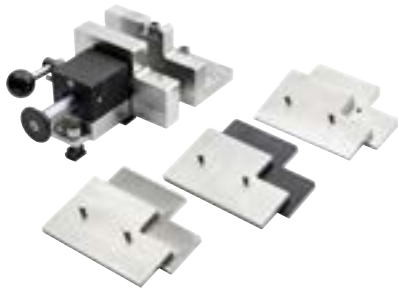
Struers offers a wide variety of tools and accessories, all developed with one principal purpose: to provide easier handling and more accurate specimen preparation.

In this section you will find accessories for:

- Cutting
- Mounting
- Grinding and polishing
- Automatic cleaning
- Non-destructive testing
- Hardness testing

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





Quick clamping tool



Bolt clamping tool

## 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

05876902

Customizable crown. Used with Support block (05876901 or 05876924), the crown offers a height adjustment range of 60-80 mm.

60-80 mm

05046905

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

For 12 mm T-slots

05116911

#### Swivel Shoes

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

05876903

Customizable crown. Used with Support block (05876901 or 05876924), the crown offers a height adjustment range of 80-100 mm.

80-100 mm

05046906

#### Arm Extension

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

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

05876904

Customizable crown. Used with Support block (05876901 or 05876924), the crown offers a height adjustment range of 100-120 mm.

100-120 mm

## Clamping Tools

- 05876916 **Jaws for quick clamping tools**  
Set of 2 jaw blocks for optimum clamping of e.g. thin-walled tubes. For use with Quick clamping device for 12 mm T-slots, left (06316914) and right (06316916).  
Rubber-coated. For 12 mm T-slots
- 05876914 Set of 2 jaw blocks for optimum clamping of round and oval workpieces. For use with Quick clamping tool for 12 mm T-slots, left (05876911) and right (05876912).  
Prism-shaped. For 12 mm T-slots. Set of 2
- 06316928 **Extended jaws for base plate clamping tools**  
Set of 2 jaw blocks for optimum clamping of small, regular specimens. For use with Base Plate clamping tools for 10 mm and 12 mm T-slots, left and right  
Extended width. For 10-12 mm T-slots
- 05876918 **Jaws for quick clamping tools**  
Set of 2 jaw blocks for optimum clamping of regular workpieces. For use with Quick clamping tool for 12 mm T-slots, left (06316914) and right (06316916).  
Grooved. For 12 mm T-slots. Set of 2
- 05876913 **Jaws for quick clamping tools**  
Set of 2 jaw blocks for optimum clamping of round and oval workpieces. For use with Quick clamping tool for 10 mm T-slots, left (06316912) and right (06316915).  
Prism-shaped. For 10 mm T-slots. Set of 2
- 06316923 **High Vertical Quick Clamping Tool**  
For securing the workpiece on the left side of the cut-off wheel. Suitable for Labotom-15/-20 and Discotom-10/-100. Workpiece height: 85 - 35 mm  
For 10 mm T-Slots
- 05876915 **Jaws for quick clamping tools**  
Set of 2 jaw blocks for optimum clamping of sensitive specimens e.g. thin-walled tubes. For use with Quick clamping tool for 10 mm T-slots, left (06316912) and right (06316915).  
Rubber-coated. For 10 mm T-slots
- 05876917 **Jaws for quick clamping tools**  
Set of 2 jaw blocks for optimum clamping of regular workpieces. For use with Quick clamping tool for 10 mm T-slots, left (06316912) and right (06316915).  
Grooved. For 10 mm T-slots. Set of 2
- 05876905 **Turntable clamping tool**  
0-90 degree turntable for angular cutting. For use with various 10 mm T-slot clamping tools. Table height 42 mm. Table size 185 x 140 mm  
For 10 mm T-slots
- 06316915 **Quick Clamping Tool**  
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: 50 mm. Jaw height: 58 mm  
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
- 05876926 **Single Prism for Vertical Quick Clamping Tool**  
Jaw block for optimum clamping of round and oval workpieces. For use with Vertical quick clamping tool for 10 mm T-slots, (06316922, 06316923).  
1 pc.

## Clamping Tools

- 05136903 **Spring Clamp**  
For retaining the workpiece on the right side of the cut-off wheel. Suitable for Labotom-5, Labotom-15/-20, Discotom-10 and Discotom-100. Complete with backstop and spanner.  
Right. For 10 mm T-slots
- 06316902 **Adjustable stop for serial cutting**  
Precise setting for repetitive cutting. Easy to adjust. Delivered with ruler for precise adjustment  
For 10-12 mm T-slots
- 05876927 **Fixed Stand**  
Stand for specimen holders with dovetail clamp. Manual positioning. Suitable for all machines with 10 mm T-slots.
- 05996916 **Spring Clamp**  
For retaining the workpiece on the left side of the cut-off wheel. For Secotom-15/-50/-20/-60. Complete with backstop and spanner.  
Left For 8 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
- 06316920 **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
- 06316901 **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
- 05876928 **XL Quick Clamping Tool**  
For securing regular workpieces on left side of cut-off wheel. Suitable for Magnutom-400/-500. Complete with backstop and spanner. Jaw movement: 60 mm. Jaw height: 116 mm.
- 06316918 **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
- 06316917 Left. For 10 mm T-slots
- 06316921 **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
- 06316922 **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



## Clamping Tools

06316907	<p><b>Base plate clamping tool</b> 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 (06316929), Extended (06316927) and Rubber Coated (06316911) jaws available as accessories.</p> <p>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
06316930	<p><b>Jaws for base plate clamping tools 10-12 mm</b> Set of 2 jaw blocks for optimum clamping of round and oval workpieces. For use with Base Plate clamping tools for 10 mm and 12 mm T-slots, left and right. Prism-shaped. For 10-12 mm T-slots</p>
06316926	<p><b>Bolt clamping tool</b> For longitudinal sectioning of bolts and fasteners. With ruler for easy positioning of the workpiece. Suitable for Secotom-15/-50/-20/-60. 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.</p> <p>For 8 mm T-slots</p>
05876929	<p><b>XL Quick Clamping Tool</b> For securing regular workpieces on right side of cut-off wheel. Suitable for Magnutom-400/-500. Complete with backstop and spanner. Jaw movement: 60 mm. Jaw height: 116 mm.</p>
05876930	<p><b>XL Jaws</b> Set of 2 jaw blocks for optimum clamping of round and oval workpieces. For use with XL Quick clamping tool (058769XX).</p>
05876931	<p><b>XL Jaws</b> Set of 2 jaw blocks for optimum clamping of regular workpieces. For use with XL Quick clamping tool (0587692X).</p>
05876936	<p><b>XL Vertical clamping tool, 12 mm T-slots</b> For clamping irregularly shaped workpieces on the cutting table. Suitable for all machines with 12 mm T-slots. Clamping height is adjustable up to 176 mm (with riser block). Complete with operating key and one flat clamping shoe.</p>
05876901	<p><b>Support Block</b> Turnable, horizontally and vertically adjustable support blocks. Height adjustment range: 20 mm. Used with customizable crowns: 60-80 mm (05876902), 80-100 mm (05876903) or 100-120 mm (05876904), which are ordered separately. Extra support blocks (05876923) can be added to the base plate</p> <p>For 12 mm T-slots</p>
05876924	<p><b>Support Block</b> Turnable and vertically adjustable support block with 12 mm T-nut. Height adjustment range: 20 mm. Used with customizable Crowns: 60-80 mm (05876902), 80-100 mm (05876903) or 100-120 mm (05876904), which are ordered separately</p> <p>For 12 mm T-slots</p>

## Clamping Tools

06316904	<b>Pinch-reduction clamping tool</b> 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
06316903	For 12 mm T-slots
05046912	<b>Chain Spanner</b> For clamping irregularly shaped workpieces. Complete with anchor block and operating key For 12 mm T-slots



*EasyDoser*

## Hot Mounting

### Dosing Units for Hot Mounting

05796902	<b>EasyDoser</b> Manual dosing unit for hot mounting presses. For Struers 1 kg hot mounting resins
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*Wupty*

## Cold Mounting

### Cold Mounting Accessories

05696901	<b>Wupty</b> 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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MD-Disc with cone



MD-Disc with driving pins



Wet Grinding Disc with driving pins

CUTTING

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ACCESSORIES

## Grinding and Polishing

### MD-Disc

02426920	<b>MD-Disc with driving pins</b> 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.

### Grinding/polishing Discs

02426935	<b>Wet Grinding Disc with driving pins</b> Aluminium 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	<b>Aluminium Disc with driving Pins</b> For use with adhesive backed consumables. 200 mm (8") dia.
02426907	250 mm (10") dia.
02426906	300 mm (12") dia.
40800113	<b>Magnetic Foil</b> To be attached on standard aluminium 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.

### Acc. for Tegramin

06086401	<b>MD-Disc with cone</b> 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

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

### Acc. For LaboPol-20/-30/-60

- 06206932 **Wet Grinding Disc with cone**  
Aluminium, 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.
- 06206924 **Wet Grinding Disc with cone**  
Aluminium disc with retention ring. For use on LaboPol-20 with plain back silicon carbide paper. With cone for easy replacement  
200 mm (8") dia.
- 06206917 **Cast iron disc for mineralogy, ø300 mm**  
Concentrically grooved, cone-type disc for lapping mineralogical specimens on LaboPol-30/-60 (06336127/06346127). Made of special SiC-resistant cast iron alloy



Case



Dispensing Gun

### TriPod

- 04386921 **Parallel Section Sample Mounts**  
12.5 mm stainless steel sample mount for TriPod Polishing Fixture-P (04386201)  
10 pcs.
- 04386922 12.5 mm aluminium sample mount for TriPod Polishing Fixture-P (04386201)  
10 pcs.

## TriPod

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

## Automatic Cleaning

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

## Others NDT

40900065	<b>Dispensing Gun</b> Hand-operated dispensing gun for RepliSet For 265 ml cartridges
40900066	For 50 ml cartridges
40900067	<b>Case</b> Aluminium 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

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Indenters

## Hardness Testing

Indenters	
06709101	<p><b>Rockwell C diamond indenter</b> With accredited certificate acc. to ASTM &amp; ISO. For Duramin-100/-150/-160/-170/ -600/-650. Ø6.35 mm shaft</p>
06709102	<p><b>Rockwell ball indenter, 1/16"</b> With accredited certificate acc. to ASTM &amp; ISO. For Duramin-100/-150/-160/-170/ -600/-650. Ø6.35 mm shaft</p>
06709103	<p><b>Rockwell ball indenter, 1/8"</b> With accredited certificate acc. to ASTM &amp; ISO. For Duramin-100/-150/-160/-170/ -600/-650. Ø6.35 mm shaft</p>
06709104	<p><b>Rockwell ball indenter, 1/4"</b> With accredited certificate acc. to ASTM &amp; ISO. For Duramin-100/-150/-160/-170/ -600/-650. Ø6.35 mm shaft</p>
06709105	<p><b>Rockwell ball indenter, 1/2"</b> With accredited certificate acc. to ASTM &amp; ISO. For Duramin-100/-150/-160/-170/ -600/-650. Ø6.35 mm shaft</p>
06709110	<p><b>Brinell indenter, 1 mm</b> With accredited certificate acc. to ASTM &amp; ISO. For Duramin-100/-160/-170/-600/-650/-3000. Ø6.35 mm shaft</p>
06709111	<p><b>Brinell indenter, 2.5 mm</b> With accredited certificate acc. to ASTM &amp; ISO. For Duramin-100/-160/-170/-600/-650/-3000. Ø6.35 mm shaft</p>
06709112	<p><b>Brinell indenter, 5 mm</b> With accredited certificate acc. to ASTM &amp; ISO. For Duramin-100/-160/-170/-600/-650/-3000. Ø6.35 mm shaft</p>
06709113	<p><b>Brinell exchangeable indenter, 10 mm</b> With accredited certificate acc. to ASTM &amp; ISO. For Duramin-100/-160/-170/-600/-650/-3000. Ø6.35 mm shaft</p>
06709114	<p><b>Brinell indenter, 1 mm</b> With accredited certificate acc. to ASTM &amp; ISO. For Duramin-4/-40/-100. Ø3 mm shaft</p>



Indenters

Indenters	
06709115	<p><b>Brinell indenter, 2.5 mm</b>            With accredited certificate acc. to ASTM &amp; ISO. For Duramin-4/-40/-100.            Ø3 mm shaft</p>
06709121	<p><b>Vickers indenter</b>            With accredited certificate acc. to ASTM &amp; ISO. For Duramin-4/-40/-100.            Ø3 mm shaft</p>
06709120	<p><b>Vickers indenter, ≥HV1</b>            With accredited certificate acc. to ASTM &amp; ISO. For Duramin-100/-600/-650.            Ø6.35 mm shaft</p>
06709130	<p><b>Knoop indenter</b>            With accredited certificate acc. to ASTM &amp; ISO. For Duramin-4/-40/-100.            Ø3 mm shaft</p>
06709131	<p><b>Knoop Indenter ø6,35mm</b>            With accredited certificate acc. to ASTM &amp; ISO. For Duramin-100/-600/-650.            Shaft size Ø6,35mm</p>
06709132	<p><b>Adapter for second indenter, Duramin-4/-40</b>            Required if two indenters are to be installed in turret. For Duramin-4/-40.</p>



MD-Concert Concertino



MD-Storage Cabinet



Table unit

## Lab Furniture

### Laboratory Furniture

05306101	<b>MD-Concert</b> Storage cabinet for 9 MD preparation surfaces in 300 mm (12"), 250 mm (10") or 200 mm (8") dia.
05306102	<b>MD-Concertino</b> Storage cabinet for 7 MD preparation surfaces in 200 mm (8") dia.
05666001	<b>Storage Cabinet MEDCU</b> For 10 MD preparation surfaces in 350 mm (14") dia. 235 x 380 x 395 mm (h x w x d)
06266901	<b>Extension for table unit</b> Can be mounted on both right and left hand side Width: 400 mm, depth 950 mm

## Cooling Systems

### Advanced Cooling System

05766933	<b>XL Filter bag</b> Replacement filter bag for repeated use with the filter tray. Replacement filter bag
05766928	<b>Filter bag</b> 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







# MATERIALOGRAPHIC TRAINING COURSES

In our materialographic training courses, we combine theoretical understanding of the materialographic process with a practical approach, focusing on choosing and using suitable solutions and techniques.

To support the requirements of specimen preparation and examination, we also offer specific courses on hardness testing and microscopy.

Our TPM (The Professional Materialographer) training courses cover the entire materialographic process, from cutting to specimen analysis and verification.

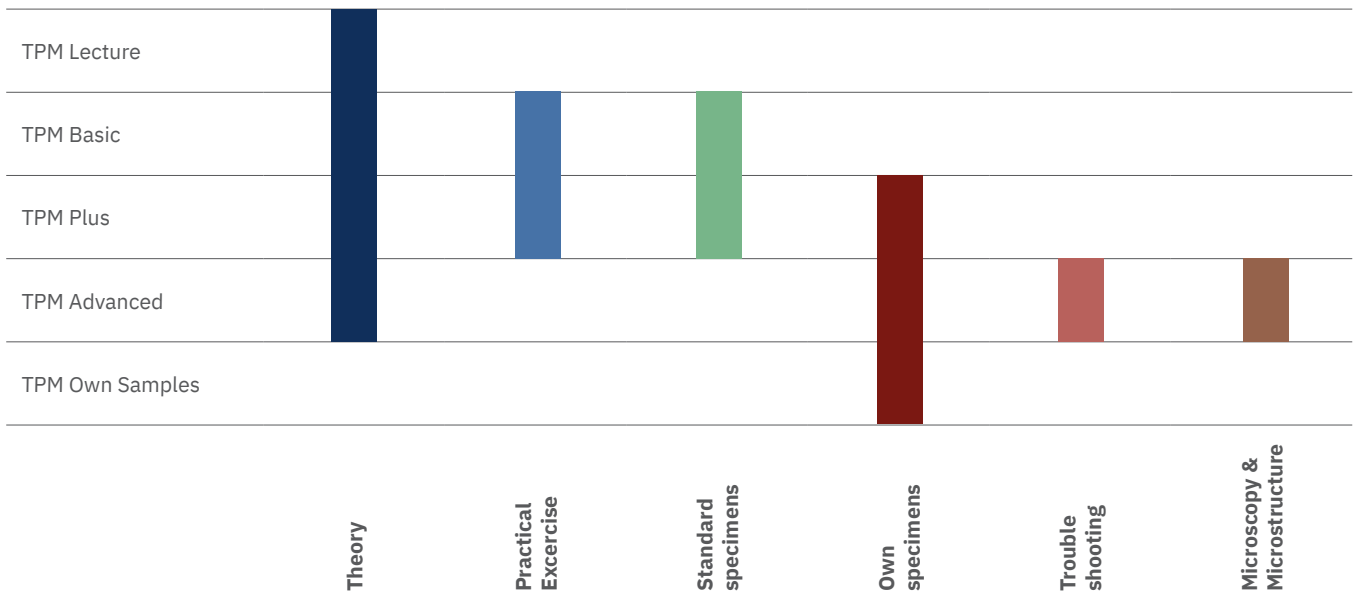
Customized training, including specific processes or materials, can be arranged. Also training of lab teams in their own facilities is offered.



**“I really appreciate the high mentor to studio ratio in the lab work. It meant there was no wasted time. Overall, the experience was terrific.”**

Course participant, TPM Plus





- **Theory**
  - Increased theoretical knowledge base
  - Input to optimize materialographic process
  - Tools to select consumables
- **Practical Exercise**
  - See your own tasks in a new perspective
  - Application of the latest theories in a practical context
  - Introduction to how to save time and increase safety with the latest techniques
- **Standard Specimens**
  - Experience with hands-on preparation
  - Application of selection guides for method selection
  - Introduction to changes for method optimization
- **Own specimens**
  - New timesaving and quality improving method to implement in your own lab
  - Solve relevant problems appearing in your own lab
  - Start using new unrevealed features on your own equipment that will assist preparation
- **Trouble-shooting**
  - Prepared to address future problems
  - Independent and fast problem solving on your own
  - Less trial and error, more systematic and straight to the point in problem solving
- **Microscopy & Microstructure**
  - Identify preparation artefacts quickly and resolve them
  - Use your own microscope better
  - Integrate microscopy as an active part of preparation to get efficient preparation



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## Ensuring certainty

Materialographic preparation and testing demands consistent, reproducible results. These come not only from your laboratory process, operators and equipment, but from your supply chain and your partner. As a Struers customer you benefit from high quality design and engineering of equipment and consumables, but just as much from our unique knowledge base, robust global supply chain, and expert service and applications support – where and when you need it. We call all this ensuring certainty

Struers remains dedicated to making the world a better place through the pursuit of deep scientific insights and ground-breaking technology. Today, we're your trusted partner in a fast-changing world, sharing our expertise and practical experience on a global scale. This gives you innovative solutions that help you face the future with confidence. We continue to lead the way in materialographic products and services, and to shape future developments towards a better society.

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