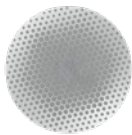


		Application area	Hardness range	MD surface	Finish comparable to SiC Paper or Foil # size (FEPA P)	Abrasive and bond
Plane grinding		Ferrous metals & hard materials	150-2000 HV	MD-Piano (3 grits)	80, 120, 220	Embedded resin bonded diamonds
		Non-ferrous metals and soft materials	40-250 HV	MD-Primo (2 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
		Ceramics, sintered carbides and very hard, ferrous metals	>600 HV	MD-Diamond Pad	120	Metal bonded diamonds

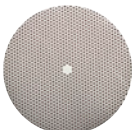


TECHNICAL DATA

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	None	>100	200 mm / 8" 250 mm / 10" 300 mm / 12"

* MD-Primo 120

		Application area	Hardness range	MD surface	Finish comparable to SiC Paper or Foil # size (FEPA P)	Abrasive and bond
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
		Minerals, ceramics, sintered carbides and very hard ferrous metals	>600 HV	MD-Diamond Pad (2 grits)	400, 800	Metal bonded diamonds

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 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

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”
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”
Water	None	None	>100	200 mm / 8” 250 mm / 10” 300 mm / 12”

* MD-Primo 120

Producers of Abrasives. ANSI is the American National Standards Institute. Struers grinding paper / foil follows the FEPA P

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