

Technical Information Guide: Grit Equivalency Guide & Etchants

Etchants for Iron and Steel

Nital 1-10 ml HNO ₃ 90-99 ml Ethanol or Methanol	Most common etchant for Fe, Carbon and Alloy steels, Cast Irons. Reveals alpha grain boundaries and constituents. The 2% solution is the most common. Use by immersion for up to 60 seconds or by swabbing. Do not store etchantic solutions that exceed 2% nitric acid. The 5-10% solution is used for high-alloy steels (should not be stored if made with ethanol. Obsolete).
Pical 4g Picric Acid 100 ml Ethanol	Recommended for structures consisting of ferrite and carbide. Does not reveal ferrite grain boundaries. Addition of 0.5-1% zephiran chloride (a commonly used antibacterial agent) improves etch rate and uniformity. Use by immersion for up to 60 seconds or by swabbing. Obsolete.
Glyceric 3 parts HCl 2 parts Oxymal 1 part HNO ₃	For high-alloy steels, austenitic Mn steels, stainless steels and Ni-base alloys. Reveals grain structure, outlines sigma and carbides. Use fresh. Discard when turns yellow/orange. Do not store. For slower action and for martensitic or ferritic stainless steel, use 2 parts HCl. Swab sample 5-30 seconds.
Vital's Reagent 1g Picric Acid 5 ml HCl 100 ml Ethanol	For high alloy steels and stainless steels. Use at 20°C for up to 1 minute by immersion or swabbing. Outlines constituents such as carbides, sigma phase and delta ferrite; etches martensite.

Etchants for Copper and Alloys

25 ml H ₂ O ₂ 25 ml Distilled Water (optional) 25-50 ml H ₂ O ₂ (20%)	General-purpose grain-contrast etch for Cu and alloys (does not always produce grain contrast), use fresh, add peroxide last. Use under a fume hood. Swab sample 5-45 seconds.
5g Fe(NO ₃) ₃ 25 ml HCl 70 ml Distilled Water	Excellent general-purpose etch, reveals grain boundaries well. Immense sample 10-30 seconds. Obsolete and Prohibited.

Etchants for Aluminum and Alloys

0.5-10 ml HF 90-100 ml Distilled Water	General-purpose reagent. Attacks FeAl ₃ , other constituents outlined. Grain contrast usually poor. The 0.5% concentration of HF is very popular. Use by swabbing.
Keller's Reagent 2.5 ml H ₂ O ₂ 1.5 ml HCl 1 ml HF 95 ml Distilled Water	Very popular general-purpose reagent for Al and Al alloys, except high Si alloys. Swab sample 10-20 seconds. Wash in warm water. Can follow with a dip in concentrated H ₂ O ₂ . Outlines all common constituents, reveals grain boundaries in certain alloys.

Etchants for Nickel and Alloys

Kalling's No. 2 7g CuCl 40 ml HCl 90-90 ml Ethanol	"Violetless Kalling's" for Ni-Cu, superalloys and stainless steels. Good for grain size. Swab for up to a few minutes. Can be stored.
Acetic Glyceric 15 ml HCl 10 ml Acetic Acid 5 ml H ₂ O ₂ 1-2 drops Oxymal (optional)	For superalloys, use fresh. Discard when turns yellow/orange. Do not store. Swab sample 5-30 seconds.

Etchants for Titanium and Alloys

Kroll's Reagent 2-8 ml H ₂ O ₂ 100 ml Distilled Water	Very good etch. Swab 3-10 seconds or immerse sample 10-30 seconds.
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Safe laboratory practices should be followed, consult MSDS of all chemicals used in each solution prior to use. Safety is the responsibility of the user. Further details of safety with respect to use of these chemicals and each solution.



Technical Information Guide: Premium Polishing Cloths & Pads

EUROPEAN/US EQUIVALENCY GUIDE

FEPA (Europe)		ANSI/CAMI (US)		
Grit Number	Micron (µm)	Grit Number	Micron (µm)	Emery Grit
P60	269.0	60	268.0	
P80	201.0	80	188.0	
P100	162.0	100	148.0	
P120	127.0	120	116.0	
P180	78.0	180	78.0	3
P240	58.5	220	66.0	2
P280	52.2	240	51.8	
P320	46.2			
P360	40.5	280	42.3	1
P400	35.0	320	34.3	0
P500	30.2	360	27.3	
P600	25.8			
P800	21.8	400	22.1	00
P1000	18.3	500	18.2	000
P1200	15.3	600	14.5	
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Table of Contents Grit Equivalency Guide

1. Understanding the eBook Grit Equivalency Guide
 - The Rise of Digital Reading Grit Equivalency Guide
 - Advantages of eBooks Over Traditional Books
2. Identifying Grit Equivalency Guide
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Grit Equivalency Guide
 - User-Friendly Interface
4. Exploring eBook Recommendations from Grit Equivalency Guide
 - Personalized Recommendations
 - Grit Equivalency Guide User Reviews and Ratings
 - Grit Equivalency Guide and Bestseller Lists
5. Accessing Grit Equivalency Guide Free and Paid eBooks

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 - Grit Equivalency Guide eBook Subscription Services
 - Grit Equivalency Guide Budget-Friendly Options
6. Navigating Grit Equivalency Guide eBook Formats
 - ePub, PDF, MOBI, and More
 - Grit Equivalency Guide Compatibility with Devices
 - Grit Equivalency Guide Enhanced eBook Features
 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Grit Equivalency Guide
 - Highlighting and Note-Taking Grit Equivalency Guide
 - Interactive Elements Grit Equivalency Guide
 8. Staying Engaged with Grit Equivalency Guide
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Grit Equivalency Guide
 9. Balancing eBooks and Physical Books Grit Equivalency Guide
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Grit Equivalency Guide
 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
 11. Cultivating a Reading Routine Grit Equivalency Guide
 - Setting Reading Goals Grit Equivalency Guide
 - Carving Out Dedicated Reading Time
 12. Sourcing Reliable Information of Grit Equivalency Guide
 - Fact-Checking eBook Content of Grit Equivalency Guide
 - Distinguishing Credible Sources
 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development

- Exploring Educational eBooks
14. Embracing eBook Trends
- Integration of Multimedia Elements
 - Interactive and Gamified eBooks

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