

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 (avoid). |
| 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. |
| Vollmer'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. |
|--|--|

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 | |
| | | | | |

Grit Equivalency Guide

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Grit Equivalency Guide:

The Top Books of the Year Grit Equivalency Guide The year 2023 has witnessed a noteworthy surge in literary brilliance, with numerous engrossing novels captivating the hearts of readers worldwide. Lets delve into the realm of popular books, exploring the captivating narratives that have enthralled audiences this year. The Must-Read : Colleen Hoovers "It Ends with Us" This heartfelt tale of love, loss, and resilience has gripped readers with its raw and emotional exploration of domestic abuse. Hoover skillfully weaves a story of hope and healing, reminding us that even in the darkest of times, the human spirit can triumph. Grit Equivalency Guide : Taylor Jenkins Reids "The Seven Husbands of Evelyn Hugo" This spellbinding historical fiction novel unravels the life of Evelyn Hugo, a Hollywood icon who defies expectations and societal norms to pursue her dreams. Reids captivating storytelling and compelling characters transport readers to a bygone era, immersing them in a world of glamour, ambition, and self-discovery. Discover the Magic : Delia Owens "Where the Crawdads Sing" This evocative coming-of-age story follows Kya Clark, a young woman who grows up alone in the marshes of North Carolina. Owens weaves a tale of resilience, survival, and the transformative power of nature, captivating readers with its evocative prose and mesmerizing setting. These popular novels represent just a fraction of the literary treasures that have emerged in 2023. Whether you seek tales of romance, adventure, or personal growth, the world of literature offers an abundance of engaging stories waiting to be discovered. The novel begins with Richard Papen, a bright but troubled young man, arriving at Hampden College. Richard is immediately drawn to the group of students who call themselves the Classics Club. The club is led by Henry Winter, a brilliant and charismatic young man. Henry is obsessed with Greek mythology and philosophy, and he quickly draws Richard into his world. The other members of the Classics Club are equally as fascinating. Bunny Corcoran is a wealthy and spoiled young man who is always looking for a good time. Charles Tavis is a quiet and reserved young man who is deeply in love with Henry. Camilla Macaulay is a beautiful and intelligent young woman who is drawn to the power and danger of the Classics Club. The students are all deeply in love with Morrow, and they are willing to do anything to please him. Morrow is a complex and mysterious figure, and he seems to be manipulating the students for his own purposes. As the students become more involved with Morrow, they begin to commit increasingly dangerous acts. The Secret History is a masterful and thrilling novel that will keep you guessing until the very end. The novel is a cautionary tale about the dangers of obsession and the power of evil.

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