











	Application area	Hardness range	Grinding stone or disc	Grit size (FEPA F)	Abrasive and bond	Cooling media	Run-in time - pre-dressing needed	Maintenance of the surface	Stone/Disc diameter sizes / Equipment	
High removal plane grinding		Non-ferrous metals	40-250 HV	2S27	# 150	Resin bonded silicon carbide	Water	None	Dressing with diamond dresser (on the equipment)	270 mm / Hexamatic
		Non-ferrous metals	40-250 HV	2S36	# 150	Resin bonded silicon carbide	Water	None	Dressing with diamond dresser (on the equipment)	356 mm / AbraPlan
		Stainless steel and nickel-based alloys	150-500 HV	3A27	# 150	Resin bonded aluminum oxide	Water	None	Dressing with diamond dresser (on the equipment)	270 mm / Hexamatic
		Stainless steel and nickel-based alloys	150-500 HV	3A36	# 150	Resin bonded aluminum oxide	Water	None	Dressing with diamond dresser (on the equipment)	356 mm / AbraPlan
		Medium hard ferrous metals	250-700 HV	4A27	# 150	Resin bonded aluminum oxide	Water	None	Dressing with diamond dresser (on the equipment)	270 mm / Hexamatic
		Medium hard ferrous metals	250-700 HV	4A36	# 150	Resin bonded aluminum oxide	Water	None	Dressing with diamond dresser (on the equipment)	356 mm / AbraPlan
		Hard steels or steels containing many carbides	500-800 HV	6A27	# 150	Resin bonded aluminum oxide	Water	None	Dressing with diamond dresser (on the equipment)	270 mm / Hexamatic
		Hard steels or steels containing many carbides	500-800 HV	6A36	# 150	Resin bonded aluminum oxide	Water	None	Dressing with diamond dresser (on the equipment)	356 mm / AbraPlan



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	Ceramics and sintered carbides	>800 HV	8D27	# 120	Resin bonded diamonds	Water	None	Dressing with aluminium oxide specimens (to be clamped into a specimen holder)	270 mm / Hexamatic
	Ceramics and sintered carbides	>800 HV	8D36	# 120	Resin bonded diamonds	Water	None	Dressing with aluminium oxide specimens (to be clamped into a specimen holder)	356 mm / AbraPlan
	Metal and general applications	250-700 HV	PAMST	# 150	Resin bonded aluminum oxide	Water	None	Dressing with diamond dresser (on the equipment)	200 mm / Prepamatic & Prepamatic-2

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	30 µm	22 µm	18 µm	15 µm	7 µm	4 µm
FEPA P (Europe)	P80	P120	P180	P220	P320	P500	P800	P1000	P1200	P2000	P4000
FEPA F (Europe)	F80	F100	F150	F180	F240	F320	F360	F400	F500	F800	F1200
ANSI/UAMA (US)**	#80	#120	#180	#220	#280	#320	#360	#400	#500	#800	#1200

** ANSI standard B74.18