



	Application area	Hardness range	MD surface	Finish comparable to SiC Paper or Foil # size (FEPA P)	Abrasive and bond	Cooling media	Run-in time – pre-dressing needed	Maintenance of the surface	Indicative life-time per surface (Number of SiC Papers or Foils)	Surface diameter sizes
Plane grinding	 Ferrous metals & hard materials	150-2000 HV	MD-Piano (3 grits)	80, 120, 220	Embedded resin bonded diamonds	Water	None	Dressing with sintered alumina stick from time to time	100	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"
	 Non-ferrous metals and soft materials	40-250 HV	MD-Primo (2 grits)	120, 220	Embedded resin bonded SiC	Water	None	Dressing with sintered alumina stick from time to time	100	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"*
	 Stainless steel & nickel-based alloys	120-1000 HV	MD-Alto	220	Resin bonded aluminum oxide	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"
	 Titanium alloys and hard materials containing titanium	150-2000 HV	MD-Mezzo	220	Embedded resin bonded diamonds	Water	None	Dressing with sintered alumina stick from time to time	100	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"
	 Aluminum alloys and hard materials containing aluminum	50-2000 HV	MD-Molto	220	Embedded resin bonded diamonds	Water	None	Dressing with sintered alumina stick from time to time	100	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"
Fine grinding	 Ferrous metals & hard materials	150-2000 HV	MD-Piano (2 grits)	500, 1200	Embedded resin bonded diamonds	Water	None	Dressing with sintered alumina stick from time to time	100	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"
	 Materials harder than 150 HV	>150 HV	MD-Allegro	500	Suspension/spray 15-6 µm	Lubricant / suspension / All-in-One	None	None	>100	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"
	 Ferrous metals & hard materials	150-2000 HV	MD-Piano (2 grits)	2000, 4000	Embedded resin bonded diamonds	Water	None	Dedicated sintered alumina stick. Dress from time to time.	300	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"
	 Soft materials & composites with soft matrix	40-1500 HV	MD-Largo	1200	Suspension/spray 9-3 µm	Lubricant / suspension / All-in-One	None	None	>100	200 mm / 8" 250 mm / 10" 300 mm / 12" 350 mm / 14"

* MD-Primo 120



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