

# Technical Information Guide: Grit Equivalency Guide & Etchants

## Etchants for Iron and Steels

<b>Nital</b> 1-10 ml HNO <sub>3</sub> 90-99 ml Ethanol or Methanol	Most common etchant for Fe, Carbon and Alloy steels, Cast iron. 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. (Revised)
<b>Picral</b> 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% naphthalenetrizole (a commonly used antibacterial agent) improves etch rate and uniformity. Use by immersion for up to 60 seconds or by swabbing. (Revised)
<b>Glyceric acid</b> 3 parts HCl 2 parts Glycolic 1 part HNO <sub>3</sub>	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.
<b>Vital's Reagent</b> 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 <sub>2</sub> O <sub>2</sub> 25 ml Distilled Water (optional) 25-50 ml H <sub>2</sub> O <sub>2</sub> (30%)	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 <sub>3</sub> ) <sub>3</sub> 25 ml HCl 70 ml Distilled Water	Excellent general-purpose etch, reveals grain boundaries well. Immense sample: 10-30 seconds. (Chapman and Probst)

## Etchants for Aluminum and Alloys

0.5-10 ml HF 90-100 ml Distilled Water	General-purpose reagent. Attacks FeAl <sub>3</sub> , other constituents outlined. Grain contrast usually poor. The 0.5% concentration of HF is very popular. Use by swabbing.
<b>Keller's Reagent</b> 2.5 ml HNO <sub>3</sub> 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 HNO <sub>3</sub> . Outlines all common constituents, reveals grain boundaries in certain alloys.

## Etchants for Nickel and Alloys

<b>Kalling's No. 2</b> 2g 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.
<b>Acetic Glyceric acid</b> 15 ml HCl 10 ml Acetic Acid 5 ml HNO <sub>3</sub> 1-2 drops Glycolic (optional)	For superalloys. Use fresh. Discard when turns yellow/orange. Do not store. Swab sample 5-30 seconds.

## Etchants for Titanium and Alloys

<b>Kroll's Reagent</b> 2-5 ml H <sub>2</sub> O <sub>2</sub> 100 ml Distilled Water	Very good etch. Swab 5-10 seconds or immerse sample 10-30 seconds.
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Safety laboratory practices should be followed, consult MSDS of all chemicals used in etch solutions prior to use. Safety is the responsibility of the user. Buehler disclaims all liability with respect to use of these chemicals and etch solutions.



00018

# Technical Information Guide: Premium Polishing Cloths & Pads

## EUROPEAN/US EQUIVALENCY GUIDE

FEPA (Europe)		ANSI/CAMI (US)		Emery Grit
Grit Number	Micron (µm)	Grit Number	Micron (µm)	
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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# Grit Equivalency Guide

**Anthony S. Fauci**



## **Grit Equivalency Guide:**

*Steel Heat Treatment Handbook - 2 Volume Set* George E. Totten, 2006-11-14 This reference presents the classical perspectives that form the basis of heat treatment processes while incorporating descriptions of the latest advances to impact this enduring technology The second edition of the bestselling Steel Heat Treatment Handbook now offers abundantly updated and extended coverage in two self contained volumes     Steel Heat Treatment George E. Totten, 2006-09-28 One of two self contained volumes belonging to the newly revised Steel Heat Treatment Handbook Second Edition this book focuses on process design equipment and testing used in steel heat treatment Steel Heat Treatment Equipment and Process Design presents the classical perspectives that form the basis of heat treatment processes while     The Complete Household Handbook ,2005 The best ways to clean maintain and organize your home Includes laundry and clothes care food and the kitchen storage and home office solutions and safety     **Aviation Unit and Intermediate Maintenance Manual** ,1990

*Manual of Geology* John Phillips, 1885     Analytical Characterization of Aluminum, Steel, and Superalloys D. Scott MacKenzie, George E. Totten, 2005-10-10 Authored by top researchers this book discusses methodologies to quantify the properties and microstructures of aluminum steel and superalloys It is a unique reference to advanced laboratory techniques in the context of characterization and property evaluation methodologies enabling the evolution of stronger and more function specific compositions Topics include metallography an atlas of microstructures thermal analysis x ray diffraction and residual stress measurement transmission electron microscopy electron backscattering diffraction spectroscopy texture measurement electron momentum spectroscopy positron annihilation spectroscopy and atomic probe tomography

**Worldwide Guide to Equivalent Irons and Steels** Fran Cverna, 2006-01-01 More than 30 000 listings are presented in this edition with increased coverage from major steel producing countries such as China India and Japan     **The Complete Wooden Runabout Restoration Guide** Don Danenberg, 2008-08-15 Now MBI Publishing Company's two top selling boating titles written by one of the world's top authorities on the subject of antique wooden boat restoration are available in one volume In this comprehensive restoration guide for owners and enthusiasts of wooden powerboats of all makes and models built from the early 1920s through the 1960s author Don Danenberg covers all major woodworking aspects of restoration surveying disassembly repair reconstruction and varnishing But when it comes to restoring a classic wooden powerboat getting the frame planking and deck right is just one part of the story Danenberg also walks enthusiasts through the topics of hardware running gear electrical wiring plumbing instruments upholstery trailers and maintenance Fully illustrated with step by step color photos and written in an entertaining style in which the author stresses sound reconstruction techniques over preservation of original components this comprehensive volume also includes resource listings glossaries and School of Hard Knocks sidebars     Technical Manual United States. War Department, 1943     PPI PE Civil Study Guide, 17th Edition Michael R. Lindeburg, 2022-09-30 Maximize your efficiency while studying for the PE Civil CBT exam by pairing the PE Civil

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**Food Buying Guide for Child Nutrition Programs** DIANE Publishing Company, 1994-12 Will help ensure that meals served under the National School Lunch Breakfast Programs meet program requirements Will help personnel buy the right amount of food buy it most economically Gives average yield information on over 600 food items

*Manuals Combined - U.S. Army AH-1 Cobra Operator; Aviation Unit/Intermediate, Operator, Organizational, Field and Depot Maintenance; Repair Parts and Special Tool List; Nondestructive Testing; And Maintenance Test Flight Manuals* , Over 8 700 total pages The types of manuals included are 1 Operator 2 Aviation Unit Intermediate Operator Organizational Field and Depot Maintenance body turbine engine electronics radar and related parts

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**A Manual of Geographical Science, Mathematical, Physical, Historical, and Descriptive** Charles Grenfell  
Nicolay,1852      Geologists' Association Guides ,1996      OECD Guidelines for the Testing of Chemicals / OECD Series on  
Testing and Assessment Report of the SETAC/OECD Workshop on Avian Toxicity Testing OECD,2002-05-10 As part of the  
OECD s Pesticide Programme a Workshop on Avian Toxicity Testing was held in Pensacola Florida on 4 7 December 1994 It  
was jointly organised by the Society of Environmental Toxicology and Chemistry SETAC and the OECD      *Fluorinated*  
*Coatings and Finishes Handbook* Laurence W. McKeen,2015-10-11 Fluorinated Coatings and Finishes Handbook The  
Definitive User s Guide Second Edition addresses important frequently posed questions by end user design engineers coaters  
and coatings suppliers on fluorinated coatings and finishes thus enabling them to achieve superior product qualities and  
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