

**Your EDM partner**  
Heun Funkenerosion GmbH



## Spare & wear parts catalogue MD-series

Accessories, wear- and spare parts **directly from machine manufacturer**

Your advantage:

Technology advice for special requirements

Permanent quality control by eroding tests

**Not only dealer but also machine manufacturer with own wage labour!**

Special sizes  $\varnothing$  0.08 – 6.0mm available ex stock





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article no.	article	name	pc. / set
		<b>1. tubes</b>	<b>unit</b>
xxx xxx xxx		brass and copper electrodes single 300/400 mm length Ø 0.3 - 3.0 mm	20 pcs.
xxx xxx xxx		brass and copper electrodes coreless 300/400 mm length Ø 0.5 - 3.0 mm	20 pcs.

article no.	article	name	pc. / set
		<b>2. ceramic guides</b>	<b>unit</b>
100 4xx xxx		Ø 0.1 – 3.0 mm Swiss precision guide	1 pc.
110 30x xxx		guide extension, diff. length, special length on inquiry	1 pc.







Special sizes are produced according to your requirements.

\* These articles are essential to be kept on stock.

article no.	article	name	pc. / set
		<b>3. rubber packing chuck adapter (without changer)</b>	<b>unit</b>
100 800 500		rubber packing chuck adapter type A up to 0.5 mm	4 pcs. / set
100 801 300		rubber packing chuck adapter type B up to 1.3 mm	4 pcs. / set
100 802 300		rubber packing chuck adapter type C up to 2.3 mm	4 pcs. / set
100 803 200		rubber packing chuck adapter type D up to 3.2 mm	4 pcs. / set





Other dimensions on inquiry!

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article no.	article	name	pc. / set
		<b>4. rubber packing for ER 11 chuck (changer)</b>	<b>unit</b>
340 812 100		pipe seal Ø 1.0 mm for electrode diameter 0.3 – 0.8 mm	1 pc.
340 812 130		pipe seal Ø 1.4 mm for electrode diameter 0.9 – 1.0 mm	1 pc.
340 812 150		pipe seal Ø 1.6 mm for electrode diameter 1.1 – 1.2 mm	1 pc.
340 812 180		pipe seal Ø 1.8 mm for electrode diameter 1.3 – 1.4 mm	1 pc.
340 812 200		pipe seal Ø 2.0 mm for electrode diameter 1.5 – 1.8 mm	1 pc.
340 812 230		pipe seal Ø 2.2 mm for electrode diameter 1.9 – 2.1 mm	1 pc.

Other dimensions on inquiry!








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article no.	article	name	pc. / set
		<b>4. rubber packing for ER 11 chuck (changer)</b>	<b>unit</b>
340 812 250		pipe seal Ø 2.6 mm for electrode diameter 2.2 – 2.3 mm	1 pc.
340 812 280		pipe seal Ø 2.8 mm for electrode diameter 2.4 mm	1 pc.
340 812 300		pipe seal Ø 3.0 mm for electrode diameter 2.5 – 2.8 mm	1 pc.
340 812 320		pipe seal Ø 3.2 mm for electrode diameter 2.9 – 3.0 mm	1 pc.

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article no.	article	name	pc. / set
		<b>5. pipe guide T (changer)</b>	<b>unit</b>
340 811 057		pipe guide T for electrode diameter 0.2 mm + 0.3 mm, length: 7.4 mm	1 pc.
340 811 067		pipe guide T for electrode diameter 0.4 mm, length: 7.4 mm	1 pc.
340 811 087		pipe guide T for electrode diameter 0.5 mm + 0.6 mm, length: 7.4 mm	1 pc.
340 811 107		pipe guide T for electrode diameter 0.7 mm + 0.8 mm + 0.9 mm, length: 7.4 mm	1 pc.
340 811 138		pipe guide T for electrode diameter 1.0 mm + 1.1 mm, length: 8.4 mm	1 pc.
340 811 156		pipe guide T for electrode diameter 1.2 mm, length: 6.6 mm	1 pc.
340 811 157		pipe guide T for electrode diameter 1.3 mm, length: 7.4 mm	1 pc.

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article no.	article	name	pc. / set
		<b>5. pipe guide T (changer)</b>	<b>unit</b>
340 811 187		pipe guide T for electrode diameter 1.4 mm, length: 7.4 mm	1 pc.
340 811 188		pipe guide T for electrode diameter 1.5 mm + 1.6 mm, length: 8.4 mm	1 pc.
340 811 207		pipe guide T for electrode diameter 1.7 mm + 1.8 mm, length: 7.4 mm	1 pc.
340 811 237		pipe guide T for electrode diameter 1.9 mm, length: 7.4 mm	1 pc.
340 811 238		pipe guide T for electrode diameter 2.0 mm + 2.1 mm, length: 8.4 mm	1 pc.
340 811 256		pipe guide T for electrode diameter 2.2 mm, length: 6.6 mm	1 pc.
340 811 257		pipe guide T for electrode diameter 2.3 mm, length: 7.4 mm	1 pc.

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article no.	article	name	pc. / set
		<b>5. pipe guide T (changer)</b>	<b>unit</b>
340 811 287		pipe guide T for electrode diameter 2.4 mm + 2.5 mm, length: 7.4 mm	1 pc.
340 811 288		pipe guide T for electrode diameter 2.6 mm, length: 8.4 mm	1 pc.
340 811 306		pipe guide T for electrode diameter 2.7 mm, length: 6.6 mm	1 pc.
340 811 307		pipe guide T for electrode diameter 2.8 mm, length: 7.4 mm	1 pc.
340 811 327		pipe guide T for electrode diameter 2.9 mm, length: 7.4 mm	1 pc.
340 811 328		pipe guide T for electrode diameter 3.0 mm, length: 8.4 mm	1 pc.








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article no.	article	name	pc. / set unit
		<b>6. pipe guide D (changer)</b>	
340 810 110		pipe guide D Ø 1.1 mm for electrode diameter 0.5 – 0.9 mm	1 pc.
340 810 160		pipe guide D Ø 1.6 mm for electrode diameter 1.0 – 1.4 mm	1 pc.
340 810 210		pipe guide D Ø 2.1 mm for electrode diameter 1.5 – 1.9 mm	1 pc.
340 810 260		pipe guide D Ø 2.6 mm for electrode diameter 2.0 – 2.4 mm	1 pc.
340 810 310		pipe guide D Ø 3.1 mm for electrode diameter 2.5 – 3.0 mm	1 pc.

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article no.	article	name	pc. / set
		<b>7. chuck ER 11 (changer)</b>	<b>unit</b>
340 800 003		MD – special chuck ER11 Ø 0.3 mm	1 pc.
340 800 004		MD – special chuck ER11 Ø 0.4 mm	1 pc.
340 800 005		MD – special chuck ER11 Ø 0.5 mm	1 pc.
340 800 006		MD – special chuck ER11 Ø 0.6 mm	1 pc.
102 900 100		miniature chuck ER 11 Ø 0.5 – 1.0 mm	1 pc.
340 800 012		chuck ER11 Ø 1.2 mm	1 pc.
102 900 200		miniature chuck ER 11 Ø 1.0 – 1.5 mm	1 pc.

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article no.	article	name	pc. / set
		<b>7. chuck ER 11 (changer)</b>	<b>unit</b>
340 800 017		chuck ER11 Ø 1.7 mm	1 pc.
102 900 300		miniature chuck ER 11 Ø 1.5 – 2.0 mm	1 pc.
340 800 022		chuck ER11 Ø 2.2 mm	1 pc.
102 900 400		miniature chuck ER 11 Ø 2.0 – 2.5 mm	1 pc.
340 800 027		chuck ER11 Ø 2.7 mm	1 pc.
102 900 500		miniature chuck ER 11 Ø 2.5 – 3.0 mm	1 pc.
340 800 032		chuck ER11 Ø 3.2 mm	1 pc.


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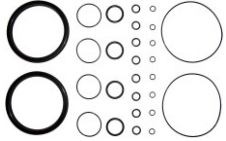






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article no.	article	name	pc. / set
		<b>8. electrode clamping system</b>	<b>unit</b>
102 912 xxx		electrode clamping system ER 11 various diameters available on inquiry	1 pc.
340 800 265		adapter cone for drill chuck	1 pc.
340 800 272		keyless drill chuck (2 pcs./set)	1 pc.
340 800 270		quick drill chuck 0.1 – 1.5 mm	1 pc.
340 800 297		cap nut – lock nut – ER11 #73	1 pc.

article no.	article	Name	pc. / set
		<b>9. electrode changing holder</b>	<b>unit</b>
340 800 5xx		electrode changing holder various diameter available on inquiry	1 pc.
340 800 xxx		electrode changing holder set (incl. 1x rubber packing, pipe guide T, pipe guide D), various diameter available on inquiry	1 set




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article no.	article	name	pc. / set
		<b>10. high-pressure pump BP2</b>	<b>unit</b>
340 900 200		sealing kit for high-pressure pump BP2	1 pc.
340 800 330		high-vacuum silicone lubricant	1 pc.
340 900 205		valve set for high-pressure pump BP2 #28	4 pcs. / set
340 900 250		plastic guide for high-pressure pump BP2	1 pc.
340 900 225		locking ring for piston bearing of high-pressure pump BP2	1 pc.
340 900 220		blocking valve for high-pressure pipe incl. fittings	1 pc.
340 900 230		valve screw cap for high-pressure pump BP2	1 pc.

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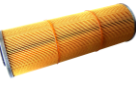





article no.	article	name	pc. / set unit
		<b>10. high-pressure pump BP2</b>	<b>unit</b>
340 900 235		T-fitting for valve screw cap	1 pc.
340 900 275		set brass screw connection/cutting ring (copper pipe T-fitting)	1 pc.
340 900 140		air pressure controller for high-pressure pump BP2	1 pc.
340 900 215		Reed-contact for high-pressure pump BP2	1 pc.
340 900 260		switch valve for high-pressure pump BP2	1 pc.
340 900 160		suction filter for high-pressure pump BP2	1 pc.

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article no.	article	name	pc. / set
		<b>10. high-pressure pump BP2</b>	<b>unit</b>
340 900 170		high-pressure pump BP2	1 pc.
340 800 320		high-pressure adaptor (high-pressure hose – tank- and filter unit)	1 pc.
340 800 325		high-pressure hose, length 4.50 m (motorized Z-axis)	1 pc.
340 800 326		high-pressure hose, length 3.50 m (manually adjustable Z-axis)	1 pc.

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article no.	article	name	pc. / set
		<b>11. tank- and filter unit</b>	<b>unit</b>
240 000 S26		filter cartridge (white)	* 1 pc.
340 800 600		filter for tank- and filter unit (water)	1 pc.
340 900 150		filter for tank- and filter unit (oil version)	1 pc.
631 000 101		key for filter housing	1 pc.
340 810 650		filter housing for water filter	1 pc.
631 000 110		O-ring for filter housing	1 pc.
340 200 150		heat exchanger	1 pc.
250 200 915		cooling unit	1 pc.







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article no.	article	name	pc. / set
		<b>12. wear parts</b>	<b>unit</b>
340 800 250		carbon brush #62	* 1 pc.
340 800 208		backup ring #55 (without changer)	* 3 pcs. / set
340 800 209		O-ring BP6/P6 #56 + #30 (without changer)	* 2 pcs. / set
340 800 205		seal pipe #31 (without changer)	* 1 pc.
340 800 296		backup ring #55 (with changer)	* 3 pcs. / set
340 800 290		O-Ring BP6/P6 #56 + #30 (with changer)	* 2 pcs. / set








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article no.	article	name	pc. / set
		<b>12. wear parts</b>	<b>unit</b>
340 800 295		seal pipe #31 (with changer)	* 1 pc.
340 800 284		copper slip ring #61	1 pc.
340 800 306		ball bearing 35x15x11 #52 (with changer)	2 pcs. / set
340 800 285		O-ring BP6 #17 + #20 (with changer)	1 pc.
340 800 315		lunette sponge set	2 pcs. / set
340 800 204		C-axis spindle incl. copper slip ring (without changer)	1 pc.









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article no.	article	name	pc. / set
		<b>12. wear parts</b>	<b>unit</b>
340 800 204		C-axis spindle incl. copper slip ring (with changer)	1 pc.
340 900 550		door sealing profile for machine with oil basin	1 pc.
340 900 560		door sealing profile for machine with water basin	1 pc.
340 800 650		air filter mat	1 pc.
340 800 300		touch-screen – protective foil 12.1“	1 pc.
340 800 305		touch-screen – protective foil 15“	1 pc.





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article no.	article	name	pc. / set
		<b>13. spare parts</b>	<b>unit</b>
340 800 280		seal stopper + dowel pin #15 + #16	1 pc.
340 800 282		thread cone for electrodes	1 pc.
340 800 286		nut – screw nut – holding plate #83	1 pc.
340 800 820		stop for pivot arm	2 pcs. / set
340 800 920		voltmeter	1 pc.
340 800 940		ampere meter	1 pc.
340 900 300		key switch	1 pc.

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article no.	article	name	pc. / set
		<b>14. electric &amp; pneumatic</b>	<b>unit</b>
340 800 390		pressure reducing valve	1 pc.
340 800 287		lunette actuator #53	1 pc.
340 800 840		actuator for pivot arm, S-lock AF24-16-D034 #79, clamping and electrode fixation for E-fix #53 and E-hold #37 for MD	1 pc.
340 800 850		actuator for pusher AF20A-S10 #8	1 pc.
340 800 640		table- /head cable	per meter
340 900 900		contactor TMC – 22	1 pc.
340 900 950		auxiliary contact for contactor	1 pc.
xxx xxx xxx		fuse set	1 set

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article no.	article	name	pc. / set
		<b>15. guide holding plates</b>	<b>unit</b>
340 800 210		guide holding plate Ø 9.0 mm (MD350 – without changer)	1 pc.
340 800 215		guide holding plate Ø 6.0 mm (MD435 / MD740 – with changer)	1 pc.
340 800 220		guide holding plate Ø 9.0 mm (MD435 / MD740 – with changer)	1 pc.
340 800 314		isolator- and adaptor plate for guide holder incl. levelling ball	1 set




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article no.	article	name	pc. / set
		<b>16. clamping devices</b>	<b>unit</b>
420 300 600		clamping jaws stainless steel	2 pcs. / set
340 800 395		slant sliding block	1 pc.
420 300 700		set of clamping screws stainless steel	8 pcs. / set.
xxx xxx xxx		clamping devices of leading manufacturers 3R / Hirschmann / Erowa	1 pc.

article no.	article	Name	pc. / set
		<b>17. drilling additives</b>	<b>unit</b>
100 701 100		EX-01 drilling solution - 10 l can (steel machining)	1 pc.
100 702 000		GT-01 drilling solution - 10 l can (carbide machining)	1 pc.
410 800 600		Ionoplus for machine with oil basin (carbide machining)	per litre

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article no.	article	name	pc. / set
		<b>18. quality check of dielectric</b>	<b>unit</b>
251 000 100		conductance measuring device	* 1 pc.
251 000 200		refractometer	1 pc.




article no.	article	Name	pc. / set
		<b>19. further accessories</b>	<b>unit</b>
630 200 100		flushing tube with magnet base	1 pc.
630 200 200		flushing tube mounted on drilling head	1 pc.
110 301 752		set of centering tip	1 pc.
101 100 000		rubber slider	1 pc.




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article no.	article	name	pc. / set unit
		<b>20. others</b>	<b>unit</b>
325 000 350		operating instruction CD (digital)	1 pc.
325 000 700		operating instruction (hard copy)	1 pc.
110 200 320		indexer URT 2002 with automatic control system	1 pc.







article no.	article	Name	pc. / set unit
		<b>21. cleaning agents</b>	<b>unit</b>
190 200 100		Wirasol special cleaner - 10 l can	1 pc.
190 200 200		machine cleaning agent - 10 l can	1 pc.
190 200 500		EDM Clean 2002 - 10 l can	* 1 pc.

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article no.	article	name	pc. / set unit
		<b>21. cleaning agents</b>	
190 400 000		CRC-3-36 incl. sprayer - 5 l can	* 1 pc.
190 430 000		CRC-3-36 spray 300 ml	1 pc.
190 450 000		CRC-3-36 spray 500 ml	1 pc.
190 860 000		CRC-3-36 Bräckleen Plus spray 500 ml	1 pc.
191 430 000		CRC SP 400 II spray 300ml	1 pc.
190 600 100		hand sprayer for 400 ml content	1 pc.

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Terms of payment are subject to agreement.

Technical details and prices are subject to change! Pictures and data are non-committal.  
For technical questions please contact us via e-mail hotline [techniker@heun-gmbh.de](mailto:techniker@heun-gmbh.de)