

**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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## Content





1. tubes .....	3
2. ceramic guides .....	3
3. rubber packing chuck adapter (without changer) .....	4
4. rubber packing for ER 11 chuck (changer) .....	5
4. rubber packing for ER 11 chuck (changer) .....	6
5. pipe guide T (changer) .....	7
5. pipe guide T (changer) .....	8
5. pipe guide T (changer) .....	9
6. pipe guide D (changer) .....	10
7. chuck ER 11 (changer) .....	11
7. chuck ER 11 (changer) .....	12
8. electrode clamping system .....	13
9. electrode changing holder .....	13
10. high-pressure pump BP2 .....	14
10. high-pressure pump BP2 .....	15
10. high-pressure pump BP2 .....	16
11. tank- and filter unit .....	17
12. wear parts .....	18
12. wear parts .....	19
12. wear parts .....	20
13. spare parts .....	21
14. electric & pneumatic .....	22
15. guide holding plates .....	23
16. clamping devices .....	24
17. drilling additives .....	24
18. quality check of dielectric .....	25
19. further accessories .....	25
20. others .....	26
21. cleaning agents .....	26
21. cleaning agents .....	27

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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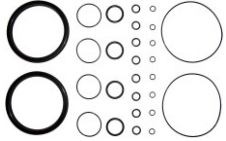






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article no.	article	name	pc. / set
		<b>8. electrode clamping system</b>	<b>unit</b>
102 912 xxx		electrode clamping system ER 11 various diameters available on inquiry	1 pc.
340 800 265		adapter cone for drill chuck	1 pc.
340 800 272		keyless drill 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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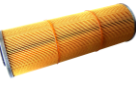





article no.	article	name	pc. / set unit
		<b>10. high-pressure pump BP2</b>	<b>unit</b>
340 900 235		T-fitting for valve screw cap	1 pc.
340 900 275		set brass screw connection/cutting ring (copper pipe T-fitting)	1 pc.
340 900 140		air pressure controller for high-pressure pump BP2	1 pc.
340 900 215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




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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.
190 200 108		Wirasol special cleaner - 5 l can	1 pc.
190 200 500		EDM Clean 2002 - 10 l can	* 1 pc.
190 200 508		EDM Clean 2002 - 5 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 5 l can	* 1 pc.
190 600 100		hand sprayer for 400 ml content	1 pc.
190 430 000		CRC-3-36 spray 250 ml / 300 ml	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)