



BUEHLER Mounting

SimpliMet



 Wilson®



BUEHLER

Solutions for Materials Preparation, Testing and Analysis





Welcome To Buehler

Buehler is a division of Illinois Tool Works (ITW), and is based in Lake Bluff, Illinois. ITW is a global, Fortune 200 company and global industrial manufacturer of value-added consumables and specialty equipment with related service businesses. Buehler is a premier manufacturer of scientific equipment and supplies for use in materials analysis with offices in nine countries, sales distribution in over 100 countries, and over 45 Expert Solutions Centers.

Buehler was founded in 1936 by Swiss immigrant, Adolph I. Buehler, who saw a need for metallographic sample preparation equipment and optical inspection instruments for the steel and automotive industries in the Midwest USA. Eighty years later Buehler is well established as the world's leading supplier of materials preparation and analysis instruments, equipment, consumable supplies and application solutions.

For more than 100 years Reicherter, Wolpert, Rockwell and Wilson have designed and manufactured innovative and unique hardness testers. Today Buehler continues in their path with new designs and technologies to meet growing demands. In 2011, Wilson Hardness was combined with Buehler to provide a more robust product offering.

Buehler employees and operations are committed to delivering quality and environmentally responsible products guided by ISO 9001 Quality Management Principles and ISO 14001 Environmental Managements Systems. Buehler innovates solutions and offers expert service and support throughout the materials preparation and analysis market.



Home of the hardness testing legacy brands:



Wilson Instruments

Visit www.buehler.com for ordering information.



MOUNTING

Mounting your specimens is important for ease of handling and preservation of the sample edge. When deciding on which mounting technique to use, consider the size and geometry of your part, the part's susceptibility to heat and pressure, and the desired throughput.

COMPRESSION MOUNTING

This is the preferred method for optimal edge preservation and highest throughput. Buehler carries compression mounting systems and mounting compounds designed to fit the varying needs of different labs.

- The SimpliMet 4000 is designed for speed with intuitive controls and easy set up.
- The SimpliMet 3000 is fully programmable and the best choice for storing and recalling multiple protocols with various mount sizes.

Comparison Chart



	SimpliMet 4000	SimpliMet 3000
Mold Size	1in, 1.25in, 1.5in, 25mm, 30mm, 40mm, 50mm	1in, 1.25in, 1.5in, 2in, 25mm, 30mm, 40mm, 50mm
Controls	Automatic	Automatic Programmable
Closure Style	Weightless	Bayonet
Cooling	Integrated, Intelligent	Integrated

SimpliMet™ 4000

Keep Up with Expanding Work Loads

Eliminate bottlenecks at the mounting stage, rapidly transforming your cut samples to specimens ready for grinding and polishing. The SimpliMet 4000 has a small footprint, relieving overcrowding on benchtops while producing more mounts. The single handed closure mechanism engages quickly, moving you right into your next task.

Double your Throughput

- Fast duplex mounting-short cycle times
- SmartCool™ - releases specimen as soon as it's safe, optimizing process time and water usage
- Ease of use - intuitive interface sets and store parameters, while closure mechanism engages quickly and easily

Smaller Press, More Mounts

- Footprint - compact unit relieves overcrowding
- Fast mounting - duplex option in seven diameters

Designed for reliability in 24/7 environments

- Endurance tested for use in high volume labs
- Optional Preventive Maintenance contract-secures your productivity



MOUNTING

Part Number		Voltage/Frequency
20-1011-5001	with 1in Mold Assembly	85-264VAC, 50/60Hz
20-1011-5025	with 25mm Mold Assembly	85-264VAC, 50/60Hz
20-1011-5125	with 1.25in Mold Assembly	85-264VAC, 50/60Hz
20-1011-5030	with 30mm Mold Assembly	85-264VAC, 50/60Hz
20-1011-5150	with 1.5in Mold Assembly	85-264VAC, 50/60Hz
20-1011-5040	with 40mm Mold Assembly	85-264VAC, 50/60Hz
20-1011-5050	with 50mm Mold Assembly	85-264VAC, 50/60Hz

Increase your grinding and polishing efficiency with a Chamfer Ram

Chamfer rams eliminate sharp edges by creating a beveled edge around the working face of the sample. This saves time and consumable costs during your grinding step.

	1in	25mm	1.25in	30mm	1.5in	40mm	50mm
Chamfer Ram	20-10120	20-10121	20-10122	20-10123	20-10124	20-10125	20-10127

Save Time

Fast Setup Short Cycle

Save Money

Doubles throughput with one machine Reliable 24/7 usage

Save Space

Small footprint
Fewer machines

Part Number	Additional Molds
20-5001	1in Mold Assembly
20-5025	25mm Mold Assembly
20-5125	1.25in Mold Assembly
20-5030	30mm Mold Assembly
20-5150	1.5in Mold Assembly
20-5040	40mm Mold Assembly
20-5050	50mm Mold Assembly

Did You Know?

Chamfer Lower Rams prepare mounted specimens with a beveled edge around the working face of the sample, thereby, eliminating any sharp edges that could adversely affect the grinding or polishing surface.





COMPRESSION MOUNTING

SimpliMet™ 3000

- Program and recall up to 25 mounting methods
- Ideal for labs with multiple protocols and different mount sizes

Features

- Automatic electro-hydraulic compression mounting system
- Integrated Cooling System
- User can define and store pressure, temperature, heating time and cool time
- Duplex capable molds

Part Number	Voltage/Frequency
20-1435	85-264VAC, 50/60Hz



Required Accessories

Molds are ordered separately, available in a variety of sizes and interchanged easily.

	1in	25mm	1.25in	30mm	1.5in	40mm	2in	50mm
Duplex Mold Assembly	20-2401	20-2405	20-2402	20-2406	20-2403	20-2407	20-2404	20-2408

Compression Mounting Consumables

20-8185-002 [†]	Release Agent, 2oz [6mℓ]	20-3048	Powdered Mold Release, 1.6oz [45g]
20-8185-008 [†]	Release Agent, 8oz [237mℓ]	20-4000-100	SamplKlip™ (qty 100)
20-8185-016 [†]	Release Agent, 16oz [470mℓ]	113043	UniClip™ (qty 100)
20-8185-032 [†]	Release Agent, 32oz [950mℓ]		

[†] Restricted article, requires special packaging

COMPRESSION MOUNTING COMPOUNDS – GENERAL PURPOSE

Material	Recommended Use	Color	Hardness (Shore D)	Edge Retention
PhenoCure™	General purpose metallography	Black, Red, Green	~88	Better
Diallyl Phthalate – Mineral Filled	Moderately hard material	Blue	~91	Better
Diallyl Phthalate – Glass Filled	Moderately hard material (<i>etching</i>)	Blue	~91	Better
EpoMet™ G (<i>Granular</i>)	Very hard material	Black	~96	Best

PhenoCure™

A wood-flour phenolic thermoset resin that provides good edge retention and moderate shrinkage. Available in either powder or premolds with a choice of three colors.



Color	Part Number	Format	Size
Black	20-3100-080	Powder	5 lbs [2.3kg]
	20-3100-400	Powder	25 lbs [11.3kg]
	20-3100-500	Powder	40lbs [18.1kg]
Red	20-3200-080	Powder	5 lbs [2.3kg]
	20-3200-400	Powder	25 lbs [11.3kg]
	20-3200-500	Powder	40lbs [18.1kg]
Green	20-3300-080	Powder	5 lbs [2.3kg]
	20-3300-400	Powder	25 lbs [11.3kg]
	20-3300-500	Powder	40lbs [18.1kg]

Premolds reduce mess and save time. Simply place the premold over the specimen in the mold cylinder. Premolds are sold 500/pack.

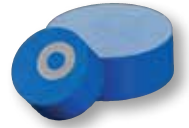
Color	Part Number	Format	Size
Black	20-3111-501	Premold	1in [25mm]
	20-3112-501	Premold	1.25in [32mm]
	20-3113-501	Premold	1.5in [38mm]
	20-10090	Premold	1.75in [45mm]
Red	20-3212-501	Premold	1.25in [32mm]
	20-3213-501	Premold	1.5in [38mm]
Green	20-3312-501	Premold	1.25in [32mm]
	20-3313-501	Premold	1.5in [38mm]




COMPRESSION MOUNTING COMPOUNDS

Diallyl Phthalate

A filled thermoset resin recommended for mounting moderately hard materials. Choose glass filled for etching or mineral filled for better abrasion resistance.




Color	Part Number	Format	Size
	20-3330-080	Mineral Filled Powder	5 lbs [2.3kg]
Blue	20-3340-080	Glass Filled Powder	5 lbs [2.3kg]

EpoMet™ G (Granular)

A mineral filled epoxy thermoset with excellent edge retention for mounting very hard materials.



Color	Part Number	Format	Size
	20-3380-064	Powder	4 lbs [1.8kg]
	20-3380-160	Powder	10 lbs [4.5kg]
	20-3380-400	Powder	25 lbs [11.3kg]
Black	20-3380-500	Powder	40 lbs [18.1kg]

Tips, Tricks & Techniques:

To permanently label specimens when using opaque mounting compound:

- Place specimen in mold
- Fill most of the mold cylinder with mounting compound
- Add a thin layer of TransOptic™ Powder
- Place a typed label over the TransOptic Powder
- Cover the label with a second layer of TransOptic Powder
- Run the mounting cycle as usual




COMPRESSION MOUNTING COMPOUNDS – SPECIALTY

Material	Recommended Use	Color	Hardness (Shore D)	Edge Retention
TransOptic™	When transparency of the mount is useful and/or when you wish to extract specimens from the mount	Clear	~80	Good
KonductoMet™	SEM analysis when carbon is not the object of analysis	Black	~88	Better
ProbeMet™	SEM analysis when copper is not of interest	Copper	~94	Best
EpoMet™ F (Fine)	Mounting very hard material for specimens with complex geometries	Black	~96	Best

TransOptic

A transparent thermoplastic acrylic that allows the user to easily extract the specimen from the mount with reheating. Requires a special cooling cycle available on the SimpliMet™ 3000 or SimpliMet 4000.




Color	Part Number	Format	Size
 Clear	20-3400-080	Powder	5 lbs [2.3kg]

KonductoMet

A graphite and mineral filled phenolic thermoset recommended for SEM analysis of specimens when carbon is not the object of analysis.




Color	Part Number	Format	Size
 Black	20-3375-016	Powder	1 lb [0.45kg]
	20-3375-400	Powder	25 lbs [11.3kg]

ProbeMet

A copper and mineral filled phenolic thermoset recommended for SEM analysis of specimens when copper is not the object of analysis. Note: Can cause a Cu-Al galvanic couple on Aluminum specimen.




Color	Part Number	Format	Size
 Copper	20-3385-064	Powder	4 lbs [1.8kg]

EpoMet F (Fine)

A mineral filled epoxy thermoset with excellent edge retention for mounting very hard materials.



Color	Part Number	Format	Size
 Black	20-3381-070	Powder	4 lbs [1.8kg]
	20-3381-160	Powder	10 lbs [4.5kg]
	20-3381-400	Powder	25 lbs [11.3kg]

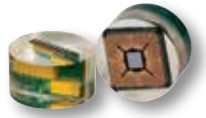


CASTABLE MOUNTING

Castable mounting systems require neither pressure nor external heat and are recommended for mounting specimens that are sensitive to heat and/or pressure. Buehler carries a complete line of castable mounting acrylics and epoxies as well as accessories and equipment to optimize your processing. Epoxy mounting systems provide good physical adherence, low shrinkage and excellent infiltration into pores and cracks when used with our vacuum system. Acrylic mounting systems are typically selected for their short cure times.

Epoxy Systems

EpoxiCure™ 2



Transparent, general purpose epoxy system

EpoHeat™ CLR



Transparent colorless epoxy. Fast heat curing, low viscosity, long pot life

EpoThin™ 2



Transparent, very low viscosity epoxy for filling pores

EpoKwick™



Clear, fast curing epoxy system

EpoColor™



Red epoxy system to highlight pores and cracks

Cure Time	6hrs @ room temperature	60 minutes @ 149°F (65°F)	9hrs @ room temperature	90min @ room temperature	90min @ room temperature
Peak Exotherm	<104°F [40°C]	<324°F [162°C]	<86°F [30°C]	<313°F [156°C]	<340°F [171°C]
Shrinkage	Small	Small	Small	Small	Small
Viscosity	Low	Low	Very Low	Low	Very Low
Pot Life	30min	270min	60min	10min	30min
Shore D Hardness	~80	~82	~78	~80	~83
Recommended Accessories	Cast N' Vac, Disposable Mounting Cups	Cast N' Vac, Disposable Mounting Cups	Cast N' Vac, Disposable Mounting Cups	Cast N' Vac, Disposable Mounting Cups	Cast N' Vac, EPDM Cups and Molds

Material	Small Resin & Hardener		Large Resin & Hardener	
	Resin	Hardener†	Resin	Hardener†
EpoxiCure™ 2 <i>mix ratio</i> 4:1 by volume	20-3430-064 64oz [1.9ℓ]	20-3432-016 16oz [0.48ℓ]	20-3430-128 128oz [3.8ℓ]	20-3432-032 32oz [0.95ℓ]
EpoHeat™ CLR <i>mix ratio</i> 4:1 by volume	20-3423-064 Resin 64oz [1.9ℓ]	20-3424-016 16oz [0.48ℓ]		
EpoThin™ 2 <i>mix ratio</i> 2:1 by volume	20-3440-032 32oz [0.95ℓ]	20-3432-016 16oz [0.48ℓ]	20-3440-128 128oz [3.8ℓ]	20-3442-064 64oz [1.9ℓ]
EpoKwick™ <i>mix ratio</i> 5:1 by weight			20-8136-128 128oz [3.8ℓ]	20-8138-032 32oz [0.95ℓ]
EpoKwick Kit	20-8128 Resin 32oz [0.95ℓ]	Hardener 8oz [0.24ℓ]	20-8129 Resin 128oz [3.8ℓ]	Hardener 32oz [0.95ℓ]
EpoColor™ <i>mix ratio</i> 5.1 by weight	20-8143-032 32oz [0.95ℓ]	20-8144-008 8oz [0.24ℓ]		

† Restricted article, requires special packaging

VACUUM SYSTEMS FOR EPOXY

Buehler® vacuum systems offer excellent pore impregnation in a compact format. Without the presence of air, the mounting compound fills the specimen pores and eliminates gaps between the specimen and the compound. As a result, edge retention is enhanced and friable samples are supported during grinding and polishing.

Cast N' Vac 1000 Vacuum System

- Designed to process multiple samples simply and efficiently
- Large Chamber accommodates large samples

Features

- Large vacuum chamber with space for 11, 1.5in molds
- Built in rotating turn table with unique dispensing mechanism
- The rugged vacuum pump supplies ample vacuum pull down to quickly evacuate trapped air from any porous specimen.
- Patented, high strength plastic chamber maintains vacuum throughout the impregnation period by means of a simple O-ring seal.

(Includes 100 graduated paper cups, 12 SamplKups™, 100 vacuum table liners, Drierite dehydrating agent and vacuum gauge)

Part Number	Voltage/Frequency
20-1382-160	115VAC, 60Hz
20-1382-250	220VAC, 50Hz
20-1382-250E*	220VAC, 50Hz

*Available only in Europe and Asia

Accessories

- 20-2835 Drierite Dehydrating Agent
- 20-2845 Vacuum Table Liners (qty 100)





CASTABLE MOUNTING

Acrylic Systems

SamplKwick™



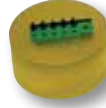
Translucent, general purpose acrylic system

VariKleer™



Clear, general purpose acrylic system

VariDur™ 10



Semi transparent, low odor system

VariDur 200



Blue, mineral filled acrylic for good edge retention

VariDur 3003



Very low shrinkage acrylic

Cure Time	5-8min @ room temperature	5-15min @ room temperature	8min @ room temperature	5-8min @ room temperature	15-30min @ room temperature
Peak Exotherm	~179°F [79°C]	~212°F [100°C]	~212°F [100°C]	~212°F [100°C]	~252°F [122°C]
Shrinkage	Medium	Medium	Medium	Small	Very Small
Viscosity	Medium/High	Medium	Medium/High	Medium/High	Medium
Pot Life	<5min	<5min	<5min	<5min	<5min
Shore D Hardness	~85	~84	~80	~85	~90
Recommended Accessories	Mounting Cups	Mounting Cups, Pressure Pot required for best clarity	Mounting Cups	Mounting Cups	Mounting Cups

Material	Powder		Liquid†		Kit†
	Part Number	Size	Part Number	Size	
SamplKwick™	20-3562	1 lb [0.45kg]	20-3564	12oz [0.36ℓ]	20-3560
	20-3566	5 lbs [2.3kg]	20-3568	64oz [1.9ℓ]	Powder 1 lb [0.45kg]
	20-3562-025	25 lbs [11.3kg]	20-3564-320	2.5gal [9.5ℓ]	Liquid 12oz [0.36ℓ]
	20-3562-100	100 lb [45kg]	20-3564-640	5gal [19ℓ]	
VariKleer™	20-3591	2.2 lbs [1kg]	20-3592	16.9oz [500mℓ]	20-3590
	20-3591-002	4.4 lbs [2kg]	20-3592-001	33.8oz [1ℓ]	Powder 2.2 lbs [1kg]
	20-3591-010	22 lbs [10kg]	20-3592-005	1.3gal [5ℓ]	Liquid 16.9oz [500mℓ]
VariDur 10	11-1027	2.2 lbs [1kg]	11-1029	16.9oz [500mℓ]	11-1037
	11-1031	22 lbs [10kg]	11-1033	1.3gal [5ℓ]	Powder 2.2 lbs [1kg]
VariDur 200	11-1030	2.2 lbs [1kg]	11-1029	16.9oz [500mℓ]	Liquid 500mℓ
	11-1034	22 lbs [10kg]	11-1033	1.3gal [5ℓ]	11-1039
VariDur 3003 3-part system	20-3531	3.3 lbs [1.5kg]	20-3532	16.9oz [500mℓ] Liquid 1	20-3530
	for use with 20-3532			33.8oz [1ℓ] Liquid 2	Powder 1.7 lbs [750g]
	20-3534	16.5 lbs [7.5kg]	20-3535	33.8oz [2.5ℓ] Liquid 1	Liquid 1 8.4oz [250mℓ]
	for use with 20-3535 & 20-3536		20-3536	1.3gal [5ℓ] Liquid 2	Liquid 2 16.9oz [500mℓ]

† Restricted article, requires special packaging

Ring Forms & Castable Molds

Disposable Mounting Cups (qty 50)

- Best when used for mounting low exotherm castable systems like EpoxiCure™ 2 and EpoThin™ 2
- Not for use in ovens
- Can also be used as specimen caps



20-8280 1in
 20-8281 1.25in
 20-8282 1.5in
 20-8283 2in

SamplKup™ (qty 12)

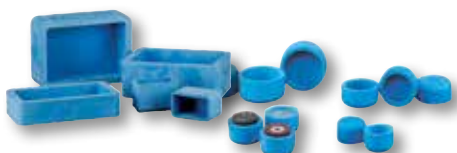
- Best dimensional stability
- Suitable for use with all Buehler castable systems
- Not for use in ovens



20-9178 1in
 20-8180 1.25in
 20-9181 1.5in
 20-9184 2in
 20-9177 25mm
 20-9179 30mm
 20-9182 40mm
 20-9183 50mm

Ethylene propylene diene monomer (EPDM) Cups & Rectangular Molds

- Suitable for use with all Buehler castable systems
- Best choice when curing mounts in ovens
- Best choice for large, rectangular mounts



EPDM Round Molds (qty 5)

20-8181 1in
 20-8182 1.25in
 20-8183 1.5in
 20-8184 2in
 20-7183 40mm
 20-7184 50mm

EPDM Rectangular Molds (qty 1)

20-7185 2.2 x 1.2 x 0.9in
 [55 x 30 x 22mm]
 20-6185 2.5 x 1.4 x 1.8in
 [63 x 25 x 46mm]
 20-7186 2.8 x 1.6 x 0.9in
 [70 x 40 x 22mm]
 20-6186 6 x 4 x 2in
 [150 x 100 x 50mm]
 20-6187 6 x 3 x 1in
 [150 x 76 x 25mm]

Plastic Ring Forms

- For use with epoxy systems



Ring Forms (qty 100)

20-8151-100 1in
 20-8152-100 1.25in
 20-8153-100 1.5in
 20-8154-100 2in



Mounting Consumables & Accessories

Thermoplastic Cement

For adhering samples to glass slides or other specialty holders



40-8100 (qty 12)

Mounting Wax

For adhering samples to glass slides or other specialty holders



40-8150* Crystalbond
7 x 0.875in
[178 x 22mm]
20-8145** Crystalbond LT
7 x 1 x 0.5in
[178 x 25 x 13mm]

Pigments for castable systems

For color coding or creating contrast between the specimen and the mold



20-8501 Blue, 1oz [3mL]
20-8502 Black, 1oz [3mL]
20-8504 Red, 1oz [3mL]

Flat Edge Filler

Enhances edge retention in castable mounting systems.



20-8196 1 lb [0.45kg]

Conductive Filler

Nickel-based filler makes castable mounting systems conductive



20-8500 2 lb [0.9kg]

Mold Release Powder



20-3048 2oz [45g]

Mold Release Spray



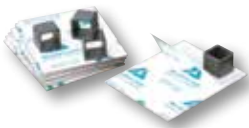
20-3050-008 8oz [0.24L]

Release Agent



20-8185-002[†] 2oz [6mL]
20-8185-008[†] 8oz [237mL]
20-8185-016[†] 16oz [470mL]
20-8185-032[†] 32oz [950mL]

MetKleer™ Adhesive Bases



20-8188 4 x 5in
[102 x 127mm]
(qty 10)

Paper Cups & Stirring Sticks



20-8177-100 Paper Cups, 5oz [148mL] (qty. 100)
20-8175 Stirring Sticks, wooden (qty 1000)

SO - Special Order. Items may have long lead times and minimum orders.
* Flows at 165°F [74°C] ** Flows at 120°F [49°C]
† Restricted article, requires special packaging

Support Clips & Clamps

Support clips are for use in supporting specimens during mounting. The weight and hardness of the clips should be considered when choosing a clip. The stainless steel SamplKlip™ is the heaviest clip, but may be too hard for use when preparing a soft material. The UniClip™ is the next heaviest clip and is softer, making it more compatible with soft materials. For metallic specimens that are to be etched after preparation, one of the polymer clips (SamplKlip I, Specimen Support Clip, or UniClip) is best to prevent interference with etching due to a stainless steel clip in contact with the specimen.

SamplKlip Support Clip – Stainless Steel (qty 100)*

For use with all mounting systems.



20-4000-100
0.25 H x 0.550 W x 0.350in L [6 x 14 x 9mm], 0.575g

SamplKlip I Support Clip – Plastic (qty 100)*

Best when used with castable mounting systems.



20-4100-100
0.25 H x 0.475 W x 0.3in L [~6 x 12 x 8mm], 0.230g

20-4100-100S
0.25 H x 0.425 W x 0.25in L [~6 x 11 x 6mm], 0.230g

Specimen Support Clip – Plastic (qty 1000)†

Best when used with castable mounting systems.



20-4001-000
0.25 H x 0.290 W x 0.375in L [6 x 7 x 9.5mm], 0.145g

UniClip Support Clip – Plastic (qty 100)†

For use with all media. Orient with "legs" upward for compression mounting systems.



113043
0.4 H x 0.360 W x 0.500in L [10 x 9 x 13mm], 0.290g

* Compatible with specimens up to 0.200in [5mm] thick

† Compatible with specimens between 0.0035 – 0.090in [0.9 – 2.3mm]

PetroBond™ Thin Section Bonding Fixture

- For bonding petrographic samples to glass slides
- Controls adhesive thickness by evenly distributing adhesive between specimen and glass slide during curing
- Holds up to 12 glass slides

Part Number

38-1490



Social Responsibility

It is not enough to achieve our mission to be the premier provider of solutions for our market. We feel strongly that part of our responsibility is to our community and global environmental sustainability. It is for this reason that in 2010 we adopted a robust recycling program throughout our operations and front offices. Now in its fifth year, this program prevents nearly 110,000 pounds [50,000 kilograms] of waste from entering landfills annually, in turn conserving other resources such as electricity, oil and water.

Throughout the year, we support numerous other corporate citizenship programs, primarily in education and human welfare. Through presentations, joint activities and fundraisers, we support Junior Achievement and United Way Worldwide. For several years, our worldwide headquarters has participated in the Work Study program at Cristo Rey St. Martin College Prep School; through this program, Buehler is helping students achieve a high school education as well as making them college bound through their work study program.



109,761 pounds
49,787 kilograms
Fiber, Metal and Plastic. On average,
the following resources are saved
annually:



35,331 gallons
133,742 liters
Oil



405 cubic yards
309 cubic meters
Landfill Space



258,038 gallons
976,780 liters
Water



628,325 kW hours
Electricity



627
Mature Trees



BUEHLER

An ITW Company

Buehler Worldwide Locations



Lake Bluff, IL, US
Binghamton, NY, US
Norwood, MA, US
Coventry, UK
Dardilly, FR
Esslingen, DE
Hong Kong, CN
Shanghai, CN
Tokyo, JP



Solutions for Materials Preparation, Testing and Analysis

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