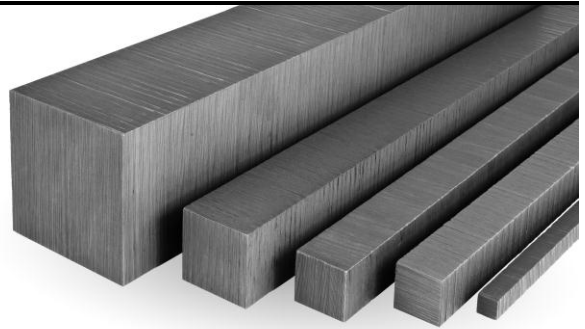


## **EDM graphite**

For electrical discharge machining



DIN	
Europe/EN	

### **Production**

EDM graphites are formed only on isostatic presses. This pressing process leads to homogeneous, isotropic graphite bodies in large formats. For that reason it makes no difference whether the material is taken of the core or the edge region of the graphite block. Rectangular blocks and cylinders are being produced and cut according to customer's request.

### **Quality**

The quality assurance is given top priority in all production stages. Strict entrance tests of all raw materials and continuous monitoring of process parameters are integrated components of the production process. Each incoming semi-finished product is tested destructively. Identification numbers allow tracing back to the raw materials.

### **Machining**

Compared to metals, alternative cutting geometries and speeds are recommended for the machining of graphite, since it cannot be cut, just "shattered".



**Order your demand in our webshop.**  
Semi-finished round bars, square bars, electrode blanks.

## ***EDM graphite***

For electrical discharge machining

EDM graphite available at shot notice:

### **CARBO-N7**

Performance grade

Application: Ideal for general mould tool applications where low wear and speed is required.

Surface Finish: 2.2µmRa, 88µinchRa, 27VDI

Specific Gravity	<i>g/cm<sup>3</sup></i>	1.83
Specific Resistance	<i>µΩm</i>	12.5
Flexural Strength	<i>N/mm<sup>2</sup></i>	54
Hardness	<i>Shore</i>	62
Average Grain Size	<i>µm</i>	7

<b>Dimension</b>	<b>Item-No.</b>	<b>Available</b>
Ø 5 x 300	E8401.5.300	o
Ø 6 x 300	E8401.6.300	o
Ø 8 x 300	E8401.8.300	o
Ø 10 x 300	E8401.10.300	o
Ø 15 x 300	E8401.15.300	o
Ø 20 x 300	E8401.20.300	o
Ø 25 x 300	E8401.25.300	o
Ø 50 x 300	E8401.50.300	o
Ø 75 x 300	E8401.75.300	o
Ø 100 x 300	E8401.100.300	o
10 x 10 x 300	E8441.10.10.300	o
15 x 15 x 300	E8441.15.15.300	o
20 x 20 x 300	E8441.20.20.300	o
25 x 25 x 300	E8441.25.25.300	o
50 x 50 x 300	E8441.50.50.300	o

## Elektroden- Graphit

### CARBO-N2

Precision grade

Application: Superior grade of graphite for ultra-high definition, excellent edge wear resistance and machining properties.

Surface Finish: 0.63µmRa, 25.2µinchRa, 16VDI

Specific Gravity	<i>g/cm<sup>3</sup></i>	1.84
Specific Resistance	<i>µΩm</i>	15.5
Flexural Strength	<i>N/mm<sup>2</sup></i>	88
Hardness	<i>Shore</i>	78
Average Grain Size	<i>µm</i>	2

Dimension	Item-No.	Available
Ø 5 x 300	E8402.5.300	o
Ø 6 x 300	E8402.6.300	o
Ø 8 x 300	E8402.8.300	o
Ø 10 x 300	E8402.10.300	o
Ø 15 x 300	E8402.15.300	o
Ø 20 x 300	E8402.20.300	o
Ø 25 x 300	E8402.25.300	o
Ø 50 x 300	E8402.50.300	o
Ø 75 x 300	E8402.75.300	o
Ø 100 x 300	E8402.100.300	o
10 x 10 x 300	E8441.10.10.300	o
15 x 15 x 300	E8441.15.15.300	o
20 x 20 x 300	E8441.20.20.300	o
25 x 25 x 300	E8441.25.25.300	o
50 x 50 x 300	E8441.50.50.300	o

### Graphite in the process of electrical discharge machining:

When using graphite in the EDM process it must be decided whether to erode with a high abrasion or low wear. Especially in the stages of finishing, working with low wear parameters is recommended.

For the desired surfaces apply the relevant pulse parameters. The performance of a graphite grade can not only be determined on the basis of certain physical and mechanical properties.

A general rule is:

With decreasing grain size electrode wear and achievable surface quality can be improved, the removal rate is reduced.

Other grades of graphite are available. Please also ask for custom made sizes.