



PROPERTIES OF GRAPHITE GRADE ELLOR[®] DS4

GENERAL

Isomolded, very fine micro-grain, high strength, isotropic graphite.

Standard size:
305 x 305 x 102 mm

TYPICAL APPLICATIONS

Micro-grain EDM graphite with exceptional ease of machining and outstanding EDM performance. Provides excellent surface finish and low electrode wear. Best choice for fine detail and intricate EDM electrodes. Surface finish 0.56 to 1.60 Ra μ m.

PROPERTIES

	Typical Values	
	English Units	SI Units
Bulk Density	117 lbs/ft ³	1,88 g/cm ³
Grain Size	< 0.0002 inch	4 μ m
Specific Resistance	0.00050 ohm-in	1270 μ ohm.cm
Flexural Strength	13,000 psi	90 MPa
Tensile Strength	7,800 psi	54 MPa
Compressive Strength	20,000 psi	138 MPa
Hardness Rockwell "H"	95	95
Coefficient of Thermal Expansion (400 to 500°C)	4.2 x 10E-6/°F	7,5 x 10E-6/°C
Ash	400 ppm	400 ppm

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