



## PROPERTIES OF GRAPHITE GRADE 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 Raµm.

### PROPERTIES

	Typical Values	
	English Units	SI Units
<b>Bulk Density</b>	117 lbs/ft <sup>3</sup>	1,88 g/cm <sup>3</sup>
<b>Grain Size</b>	< 0.0002 inch	4 µm
<b>Specific Resistance</b>	0.00050 ohm-in	1270 µohm.cm
<b>Flexural Strength</b>	13,000 psi	90 MPa
<b>Tensile Strength</b>	7,800 psi	54 MPa
<b>Compressive Strength</b>	20,000 psi	138 MPa
<b>Hardness Shore</b>	70	70
<b>Hardness Rockwell "H"</b>	95	95
<b>Coefficient of Thermal Expansion (400 to 500°C)</b>	4.2 x 10E-6/°F	7,5 x 10E-6/°C
<b>Ash</b>	400 ppm	400 ppm

13-May-2010 Rev03

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