



## PROPERTIES OF GRAPHITE GRADE ELLOR<sup>®</sup> DS4C

### GENERAL

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

Standard size:  
305 x 152 x 51 mm  
305 x 203 x 51 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 $\mu$ m.

### PROPERTIES

	Typical Values	
	English Units	SI Units
<b>Bulk Density</b>	178 lbs/ft <sup>3</sup>	2,85 g/cm <sup>3</sup>
<b>Grain Size</b>	< 0.0002 inch	5 $\mu$ m
<b>Specific Resistance</b>	0.00015 ohm-in	381 $\mu$ ohm.cm
<b>Flexural Strength</b>	19,000 psi	131 MPa
<b>Compressive Strength</b>	28,000 psi	159 MPa
<b>Hardness Shore</b>	75	75
<b>Hardness Rockwell "H"</b>	110	110
<b>Coefficient of Thermal Expansion (400 to 500°C)</b>	4.2 x 10E-6/°F	7,5 x 10E-6/°C

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