

ADVANCED MOLD/EDM SUPPLIES

PRECISION GRAPHITE MACHINING
ALL EDM SUPPLIES

"Doing The Dirty Work For YOU"

Since 2004

AME 20

GENERAL

Isomolded, very fine grain high strength, high density, isotropic graphite. Maximum inert service temperature 5,000 F (2,760 C). Standard sizes: 308 x 620 x 1,830mm; 308 x 620 x 916mm.

TYPICAL APPLICATIONS

Formulated for EDM applications requiring medium surface finish and high metal removal rates. Surface finish 9 to 18 μm .

PROPERTIES	ENGLISH UNITS	SI UNITS
	TYPICAL VALUES	
BULK DENSITY	111 lib/ft ³	1.78 gm/cm ³
GRAIN SIZE	.0005 inch	13 μm
SPECIFIC RESISTANCE	.00052 ohm-in	1,320 μ ohm-cm
FLEXURAL STRENGTH	6,500 psi	45 MPa
TENSILE STRENGTH	4,200 psi	29 MPa
COMPRESSIVE STRENGTH	14,300 psi	99 MPa
HARDNESS (Rocwell L)	98	98
COEFFICIENT OF THERMAL EXPANSION (400 TO 500C)	2.9 x 10E-6/ ⁰ F	5.2 x 10E-6/ ⁰ C
POROSITY	12%	12%
THERMAL CONDUCTIVITY	55 BTU-Ft/Ft ² Hr ⁰ F	95 W/m ⁰ C
ASH	400 ppm	400 ppm

Due to constant evolution of techniques and norms, the characteristics and specifications contained in this document are subject to change without notice.

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