

ADVANCED MOLD/EDM SUPPLIES

PRECISION GRAPHITE MACHINING
ALL EDM SUPPLIES

"Doing The Dirty Work For YOU"

Since 2004

AME 25

GENERAL

Isomolded, very fine grain, high strength, high density, isotropic graphite.
Maximum inert service temperature of 5,000 F (2,760 C).

TYPICAL APPLICATIONS

Formulated for use in most EDM applications requiring medium metal removal rates and good surface finish. Relatively low wear rates in finishing operations. Surface finish 6.3 to 4.5 Ra μm .

PROPERTIES	ENGLISH UNITS	SI UNITS
	TYPICAL VALUES	
BULK DENSITY	112 lbs/ft ³	1.80 gm/cm ³
GRAIN SIZE	.0005 inch	13 μm
SPECIFIC RESISTANCE	.00049 ohm-in	1,240 μ ohm-cm
FLEXURAL STRENGTH	7,500 psi	52 MP _a
TENSILE STRENGTH	4,500 psi	31 MPa
COMPRESSIVE STRENGTH	15,000 psi	103 MP _A
HARDNESS-SHORE	65	65
HARDNESS-ROCKWELL H	70	70
COEFFICIENT OF THERMAL EXPANSION (400 TO 500C)	2.8 X 10E-6/ ^o F	5.0 X 10E - 6/ ^o C
POROSITY	10%	10%
THERMAL CONDUCTIVITY	60 BTU - Ft/Ft ² Hr ^o F	104 W/m ^o C
ASH	500 ppm	500 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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