

ADVANCED MOLD/EDM SUPPLIES

PRECISION GRAPHITE MACHINING
ALL EDM SUPPLIES

"Doing The Dirty Work For YOU"

Since 2004

AME 70

GENERAL

Isomolded, very fine grain, high strength, isotropic graphite. Maximum inert atmosphere service temperature 5,000 F (2,760 C). Standard Size: 12" x 24" x 72" (305mm x 610mm x 1829mm)

TYPICAL APPLICATIONS

A high quality EDM graphite. A good universal EDM material which yields both good metal removal rates and wear characteristics, while producing an excellent surface finish. Surface finish 5.5 to 4.5 Ra μ m.

PROPERTIES	ENGLISH UNITS	SI UNITS
	TYPICAL VALUES	
BULK DENSITY	114 lbs/ft ³	1.82 gm/cm ³
GRAIN SIZE	.0004 inch	10 μ m
SPECIFIC RESISTANCE	.00048 ohm-in	1,220 μ ohm-cm
FLEXURAL STRENGTH	8,000 psi	55 MP _a
TENSILE STRENGTH	5,000 psi	34 MP _a
COMPRESSIVE STRENGTH	17,300 psi	119 MP _a
HARDNESS - Rockwell H	75	75
COEFFICIENT OF THERMAL EXPANSION (400 TO 500 C)	3.1 X 10E-6/ ⁰ F	5.6 X 10E - 6/ ⁰ C
POROSITY	8%	8%
THERMAL CONDUCTIVITY	61 BTU - Ft/Ft ² Hr ⁰ F	106 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.

www.AdvancedMold.biz

(262) 695-9307