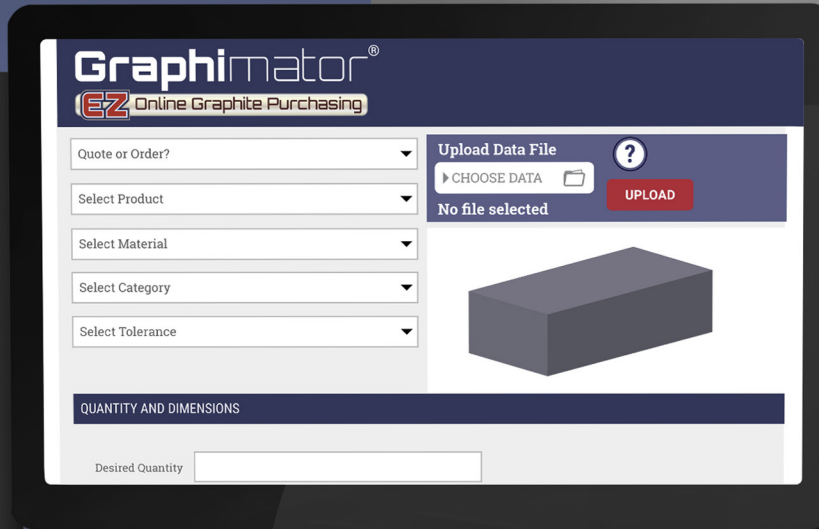


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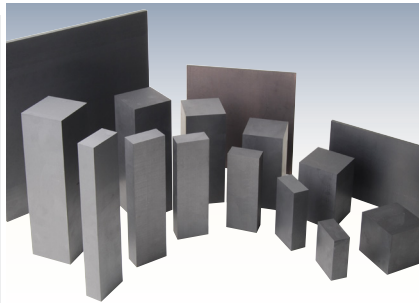
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Electrical Discharge Machining

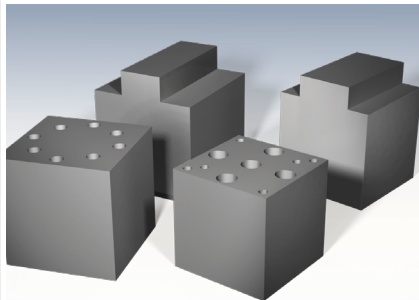
MATERIALS CHART

EDM Grades	Average Particle Size (in.)	Apparent Density g/cm ³	Material Hardness shore	Electrical Resistivity μΩ-in.	Flexural Strength psi	Compressive Strength psi
AR-06	0.00047	1.78	55	539	6,500	14,300
AR-08	0.00047	1.80	65	488	7,500	16,500
AR-12	0.00035	1.82	65	450	8,400	18,420
AR-200	0.00028	1.78	60	500	8,700	17,110
AR-14	0.00019	1.86	80	500	11,020	24,220
TTK-4	0.00016	1.78	72	552	10,600	19,600
DS-4	0.00016	1.88	72	500	13,050	27,250
DS-4C	0.00016	3.00	75	150	19,000	28,000
EDM-1®	0.00019	N/A	69	760	9,715	14,220
EDM-3®	0.00019	N/A	73	615	13,340	18,125
EDM-C3®	0.00019	N/A	66	127	20,300	28,350
EDM-AF5®	0.00004	N/A	83	850	14,500	22,115

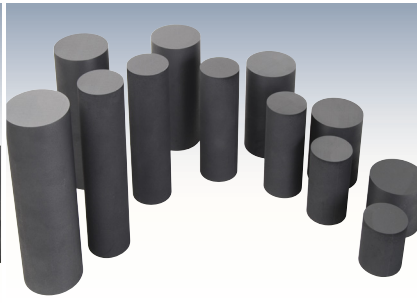
Specifications are typical from manufacturer and subject to minor changes.



Squares



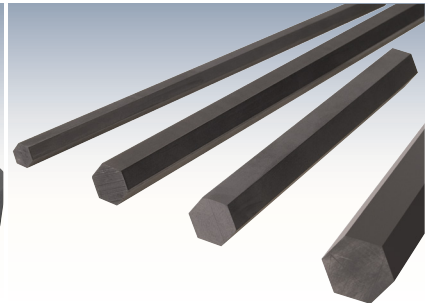
Quick-Change Electrodes



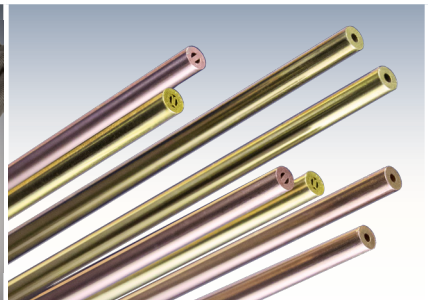
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