



It's Time to Make the Switch to Top Performing DS4 Ultra-Fine EDM Graphite

"Our detailed engraving of molds and stamping dies demands an EDM electrode that provides excellent durability and delivers sharp corners and fine quality. We switched from the leading ultra-fine EDM graphite to Mersen's DS4 and it really performs... and saved us money."

*– Bob Held
Wisconsin Engraving*



**Industry's Most Complete Line of EDM Graphite
from Roughing to High-End Finishing**

| Graphite Grade | Density | | Hardness Rockwell "H" | Hardness Shore | Flexural Strength | | Electrical Resistivity $\mu \Omega$ cm | Average Grain Size | |
|--|------------------|------|-----------------------------|-------------------|----------------------|-----|--|-----------------------|---------|
| | lbs/ cubic ft | g/cc | | | psi | MPa | | inch | μ m |
| ELLOR® DS4 <small>Featuring DARKSTAR</small> Ultra fine grain graphite Ultimate precision & EDM performance | 117 | 1.88 | 95 | 72 | 13,500 | 93 | 1,320 | <0.0002 | <5 |
| ELLOR® DS4C <small>Featuring DARKSTAR</small> Ultra fine grain copper impregnated graphite Exceptional EDM performance & precision | 178 | 2.85 | 110 | 75 | 19,000 | 131 | 381 | <0.0002 | 4 |
| ELLOR® +50 High density ultra fine grain graphite Lowest electrode wear | 116 | 1.86 | 95 | 78 | 11,000 | 76 | 1,370 | 0.0002 | 5 |
| ELLOR® +40 Ultra fine grain graphite Lowest electrode wear, fine detail | 111 | 1.78 | 75 | 60 | 8,700 | 60 | 1,270 | 0.0003 | 7 |
| ELLOR® +25 High quality universal graphite Good surface finish | 114 | 1.83 | 80 | 65 | 8,000 | 55 | 1,220 | 0.0004 | 9 |
| ELLOR® +20 Universal graphite Excellent quality & performance ratio | 112 | 1.81 | 70 | 65 | 7,500 | 52 | 1,240 | 0.0005 | 11 |
| ELLOR® +18 Roughing graphite Ideal for high metal removal rate | 111 | 1.78 | 98 | 62 | 6,500 | 45 | 1,370 | 0.0005 | 12 |

Distributors

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