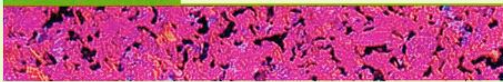


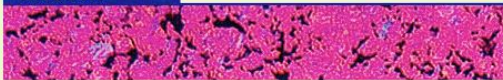
RINGSDORFF® Specialty Graphite Grades for EDM

R 8340



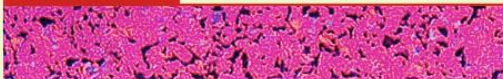
Efficient grade for roughing

R 8500X



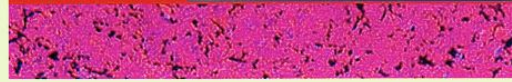
Grade for roughing and prefinishing

R 8500



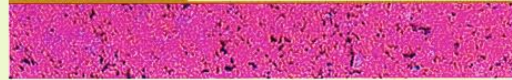
Universal grade for toolmakers

R 8510



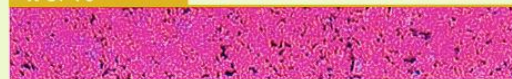
Wear resistant fine grain graphite for demanding applications

R 8650



Finishing grade for highest accuracy

R 8710



Premium finishing grade to perform high quality EDM tasks with high removal rates



Physical Properties

		R 8340	R 8500X	R 8500	R 8510	R8650	R 8710
Density	g/cm ³	1.72	1.75	1.77	1.83	1.84	1.88
Open Porosity	Vol.-%	15	14	13	10	10	10
Average Grain Size	μm	15	12	10	10	7	3
Average Pore Size	μm	2.0	2.0	1.5	1.5	0.8	0.6
Permeability	x 10 ⁻² cm ² /sec	15	15	10	4	3	1
Rockwell Hardness		80	80	70	95	95	110
		HR 10/100	HR 5/100	HR 5/100	HR 5/100	HR 5/100	HR 5/100
Flexural Strength	MPa	45	43	50	60	65	85
Young's Modulus	GPa	10.5	10	10.5	11.5	12.5	13.5
Electrical resistivity	μΩm	12	15	14	13	14	13
Thermal Conductivity	W m ⁻¹ K ⁻¹	90	80	80	100	90	100
Thermal Exp. (293.15 - 473.15 K)	x 10 ⁻⁶ K ⁻¹	2.9	3.8	3.9	4.0	3.9	4.7
Ash Value	max. %	0.02	0.02	0.02	0.02	0.02	0.02

Average values.

Broad Base. Best Solutions.



Nota: i valori sono puramente indicativi, in quanto la rugosità può variare in base alle dimensioni del pezzo

Ra max (μm)	0.4	0.56	0.80	1.12	1.6	2.24	3.15	4.5	6.30	9.00	12.5	18.0
VDI	12	15	18	21	24	27	30	33	36	39	42	45

