

Trust DS4 Ultra-fine EDM Graphite for your Toughest Jobs

"The intricate EDM electrodes required to produce our audio speaker grills take 7+ days of machining and 30+ hours of EDM burning. We needed a graphite we can trust to withstand this demanding application. We switched to Mersen's DS4 ultra-fine EDM graphite a few years ago and it's been the best performing graphite we've used. With the DS4 material we have also seen significant savings per electrode."

Eric Jacobsen
Hi-Tech Mold & Engineering



DS4 Delivers:

- Excellent surface finish
- Intricate detail
- Easy to machine
- Exceptionally strong
- Saves significant money

Ask your EDM distributor for DS4!

MERSEN
Shaping the future of EDM

edm.mersen.com



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

Graphite Grade	Density		Hardness Shore	Flexural Strength		Electrical Resistivity		Average Grain Size	
	lbs/ cubic ft	g/cc		psi	MPa	Ω inch	μ Ω cm	inch	μ m
ELLOR® DS4 <small>Featuring DARKSTAR</small> Ultra fine grain graphite Ultimate precision & EDM performance	117	1.88	72	13,500	93	.00050	1,320	<0.0002	4
ELLOR® DS4C <small>Featuring DARKSTAR</small> Ultra fine grain copper impregnated graphite Exceptional EDM performance & precision	187	3.00	75	19,000	131	.00015	381	<0.0002	4
ELLOR® +50 High density ultra fine grain graphite Lowest electrode wear	116	1.86	80	11,000	76	.00054	1,370	0.0002	5
ELLOR® +40 Ultra fine grain graphite Lowest electrode wear, fine detail	111	1.78	60	8,700	60	.00050	1,270	0.0003	7
ELLOR® +25 High quality universal graphite Good surface finish	114	1.83	65	8,000	55	.00048	1,220	0.0004	9
ELLOR® +20 Universal graphite Excellent quality & performance ratio	112	1.81	65	7,500	52	.00049	1,240	0.0005	11
ELLOR® +15 Roughing graphite Ideal for high metal removal rate	111	1.78	62	6,500	45	.00054	1,370	0.0005	12

