



# High performance graphites for EDM

Improvement in long-term competitiveness whilst benefiting from the expertise of the world no. 1 in the production of isostatic graphites.

## Which graphite should you choose for your application?

### ■ Solid 3D shapes and gravity cast moulds.

**ISEM-3** : a robust material suitable for roughing operations.  
**ISEM-8** : a multipurpose fine graphite for roughing and finishing ; its excellent machinability enables fine details to be obtained.

### ■ Fine grooves and moulds with fine contours or multi-cavity moulds.

**TTK50** : a new generation graphite : depending on the geometry of the electrode, it saves having to use a finer graphite for finishing.  
**ISO63** : a material which has been successfully used for a long time. It provides excellent surface conditions due to its high density and wear resistance.

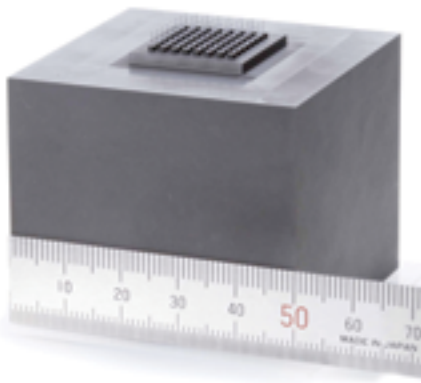
### ■ Complex shapes such as honeycomb and ultra-fine surface conditions or multi-cavity moulds.

**TTK4** : ideal for complex and difficult shapes. The finest structures can be machined. TTK4 is distinguished by its excellent machinability.  
**TTK5** : harder, you will be delighted by the erosion wear resistance of TTK5 and its high flexural strength.

### ■ Super-fine structures, complex shapes, high precision, demanding surface conditions, multi-cavity moulds

**TTK8** : premium quality suitable for the most demanding processes. Their exceptional strength allows the finest machining with the maximum of detail.  
**TTK9** : harder, and with a higher flexural strength, TTK9 is clearly designed to achieve a perfect final result!

## Graphite materials



Materials	Density	Hardness	Electrical resistivity	Flexural strength	Grain size	Standard dimension
	<i>g/cm<sup>3</sup></i>	<i>Shore</i>	<i>μΩm</i>	<i>MPa</i>	<i>μm</i>	<i>mm</i>
ISEM-3	1.85	60	10.0	49	10	1 000 x 620 x 305
ISEM-8	1.78	63	13.4	52	8	1 000 x 620 x 305
TTK-50	1.80	70	13.0	60	6	1 000 x 540 x 230
ISO-63	1.78	76	15.0	65	5	1 000 x 540 x 230
TTK-4	1.78	72	14.0	73	4	950 x 510 x 210
TTK-5	1.78	80	15.5	80	4	950 x 510 x 210
TTK-8	1.77	78	15.0	80	2	700 x 400 x 100
TTK-9	1.77	90	18.0	92	2	700 x 400 x 100

## Achievable surface conditions

VDI normal	38	36	35	34	33	32	31	30	29	28	27	26	25	24	23	22	21	20	19	18	17	16	15	14
<i>Ra μm</i>	8.00			5.00				3.15				2.00				1.25				0,8				0,5
<i>Rmax μm</i>	63-40			40-25				25-16				16-10				10-6.3				6.3-4				4-2.5
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(The above values are typical, non-contractual values based on our experience. They are subject to variation according to the circumstances and production parameters).

- Workshop fully dedicated to Graphite machining
- A wide range of standard electrodes and grades available

■ Log



Dimensions	Packet
10 x 300	5
15 x 300	5
20 x 300	5
30 x 300	3
40 x 300	2
50 x 300	2

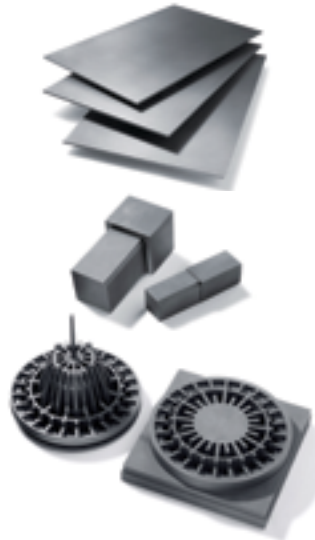
■ Square

*With or without flange*



Dimensions
10 x 10 x 300
15 x 15 x 300
20 x 20 x 300

■ « T » profiles, Plates, elevated squares, other...



■ Cut to size

*According to plan*



*manufacturer traceability*

→ Other dimensions and quantity on demand

## Everything for Electro-Erosion

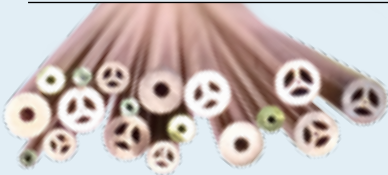
Accessories and Consumables for any electro-erosion machine.

*Agie, Charmilles, Fanuc, Hitachi, Mitsubishi, Sodick, Ona...*

Filters

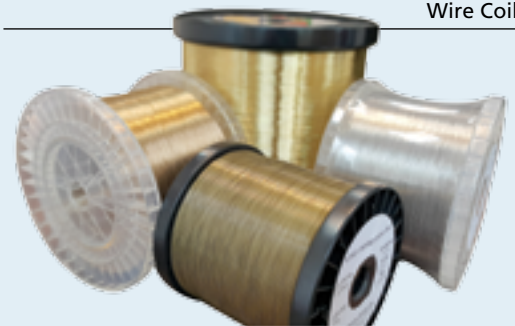


High-speed Brass / Copper Drilling Pipes



Resin (50l) – Spare parts –  
Miscellaneous accessories – Threaded electrodes

Wire Coil



Wire	KG	N
Brass	8KG / 16KG	500N / 900N / 1000N
Zinc-coated brass	16KG	900N

For all information please contact:

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