

# HOLEPOP

EDM SUPPLIES & ELECTRODES

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## Electrodes

### Materials

**Brass**—Drills the fastest. Best for most materials.

**Copper**—Lower disintegration rate than brass. Drills more efficiently through hard materials.

**Tungsten Carbide**—Drills through the toughest exotic materials such as molybdenum and iniconel with ease. Can be made to smaller diameters than brass or copper with tighter tolerances.

### Electrode Types

**Multi-channel**—Ideal for blind-hole drilling. Leaves no slug. Tungsten carbide has no multi-channel variants.

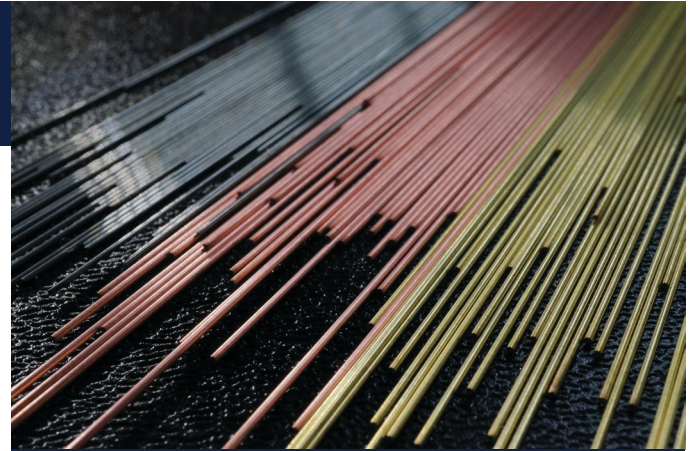
**Web/Y-type**—Two and three channel, respectively. Inner channels are flush against walls.

**Dual/Three Channel**—Tubular inserts retain circular shape.

**Wire Insert**—Rods are inserted instead of tubes.

**Single Hole**—Ideal for through-hole drilling.

**Rod**—Used for sinker EDM exclusively.



## Specifications

### Brass and Copper

Tolerances:  $+0.00$  mm/in to  $-0.02$ mm/.0008in

Length: 100mm/4in to 700mm/28in

Single Hole/Rod Dia.: .1mm/.004in to 6mm/.24in

Multi Dia.: .4mm/.016in to 6mm/.24in

Brass Composition: 70% Cu, 30% Zn

Copper Composition (C12200): 99.9% Cu

Oxygen-free Copper Composition (C10200): 99.95% Cu

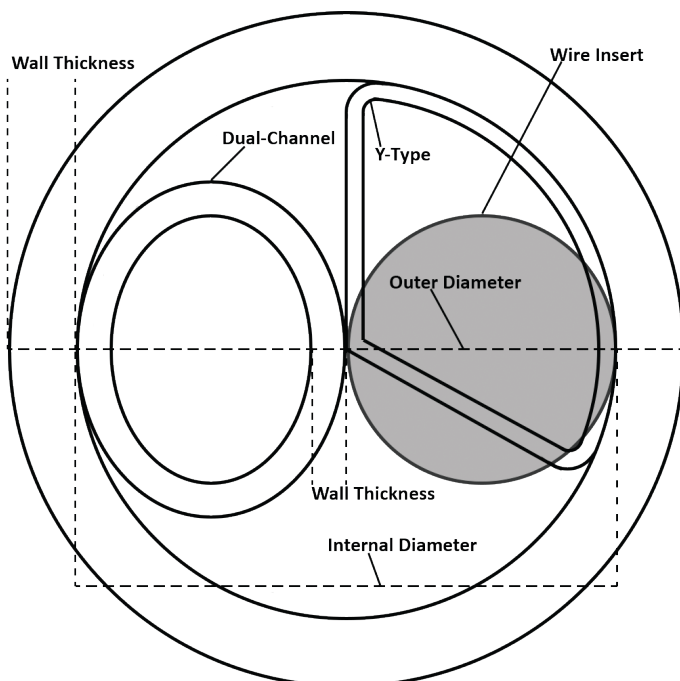
### Tungsten Carbide

Tolerances:  $-0.002$ mm/.00008in to  $-0.008$ mm/.0003in

Length: 100mm/4in to 400mm/16in

Single Hole/Rod Dia.: .06mm/.002in to 3mm/.12in

Composition: 94% WC, 6% Co



## Customization

The following aspects are customizable:

- Inner and outer diameter
- Wall thicknesses (all channels)
- Length
- Eccentricity of inner channels
- Flow rate

