

## Electrode Specifications

### Brass



Drills the fastest. Best for most materials.

- Tolerances: +0 mm / -0.02 mm  
+0" / -.0008"
- Length: 100 mm / 4" to 700 mm / 28"
- Single Hole/Rod Diameter: 0.1 mm / .004"  
to 6 mm / 0.24"
- Multi-Channel Diameter: 0.4 mm / .016"  
to to 6 mm / .24"
- Brass Composition: 70% Cu, 30% Zn;  
63% Cu, 37% Zn

### Copper



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

- Tolerances:  
0 mm / -0.02 mm  
+0" / -.0008"
- Length: 100 mm / 4" to  
700 mm / 28"
- Single Hole/Rod Dia.: 0.1  
mm / .004" to 6 mm / .24"
- Multi-Channel Dia.: 0.4  
mm / .016" to 6 mm / .24"
- Copper Composition:  
C12200, C110
- Oxygen-free Copper:  
C10200: 99.95% Cu  
C101: 99.99% Cu

### Tungsten Carbide



Drills through the toughest materials with ease, such as nickel and cobalt-based alloys (inconel, kovar, waspaloy) and exotic elements (niobium, tantalum). Available in smallest diameters of all materials. Held to tighter tolerances than brass or copper.

- Tolerances: -0.002 mm /  
-0.008 mm  
-.0003" / -.00008"
- Length: 100 mm / 4" to  
400 mm / 16"
- Single Hole/Rod Dia.: 0.06  
mm / .002" to 3 mm / .12"
- Composition: 94% WC,  
6% Co; 96% WC, 4% Co

### Copper-Tungsten



Combines the characteristics of copper and tungsten carbide electrodes. Drills through materials beyond the capabilities of copper, short of the capabilities of tungsten carbide. Available in sheet form. Ideal for stress testing. Can be precision lapped.

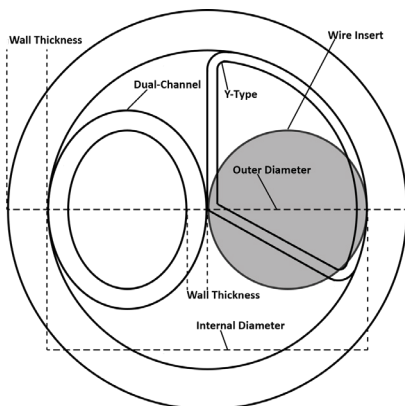
- Tolerances: -0.002 mm / -0.008 mm  
-.0003" / -.00008"
- Length: 100 mm / 4" to 400 mm / 16"
- Composition: 60% W, 40% Cu; 70% W,  
30% Cu; 80% W, 20% Cu

### Silver-Tungsten and Molybdenum



Silver tungsten offers the cleanest surface finish. Ideal for well-defined corners in drilled holes. Molybdenum rods perform similarly to tungsten carbide.

- Tolerances: -0.002 mm / -0.008 mm  
-.0003" / -.00008"
- Length: 100 mm / 4" to 400 mm / 16"



### Electrode Types

**Multi-channel**—Ideal for blind-hole drilling. Leaves no slug.

**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. Cost-effective and fast. Best flushing.

**Rod/Wire**—Used for sinker EDM.

### Custom Options

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