



TOKAI CARBON



● Locations

Schunk-Tokai Cooperation Poland

Tokai Carbon, producer of graphite for EDM electrodes, assures:

- **constant quality of material guaranteed by producer,**
- **short delivery times,**
- **technical support for machining of graphite and EDM settings,**
- **delivery of ready electrodes,**
- **competitive prices,**

Schunk and Tokai are working together on Polish market since 2014. Products offered from both companies are: isostatic graphite for EDM purposes, carbon fibre composites CFC products used in vacuum furnaces, graphite rotors for refining of aluminium and continuous casting dies. As a production companies we can assure savings in production costs through right material choices and competitive prices.

Schunk - Tokai Cooperation Poland

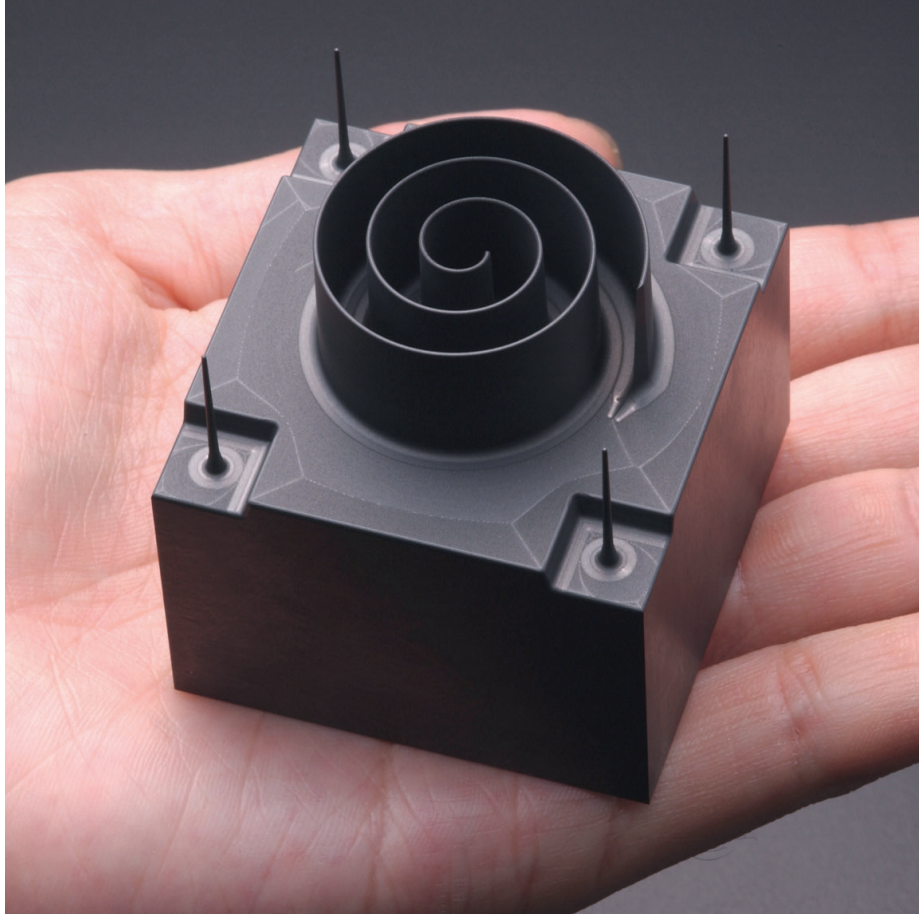
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Tokai Carbon

- Tokai Carbon, producer
of graphite for EDM electrodes

EDM Graphite Technical Data

HK-1: GENERAL GRADE

APPLICATION: Ideal for rough machining of large surface areas, i.e. drop forging dies.
SURFACE FINISH: 3.2 µm Ra, 30VDI

DENSITY (g/cm ³)	SPECIFIC RESISTANCE (µΩm)	FLEXURAL STRENGTH (N/mm ²)	HARDNESS (Shore)	AVE. GRAIN SIZE (µm)
1,85	11	50	58	11

HK-10: PERFORMANCE GRADE

APPLICATION: Ideal for rough machining of large surface areas, i.e. drop forging dies.
SURFACE FINISH: 2.5 µm Ra, 28VDI

DENSITY (g/cm ³)	SPECIFIC RESISTANCE (µΩm)	FLEXURAL STRENGTH (N/mm ²)	HARDNESS (Shore)	AVE. GRAIN SIZE (µm)
1,84	12	52	54	9

HK-15: PERFORMANCE GRADE

APPLICATION: Ideal for general mould tool applications where low wear and speed is needed.
SURFACE FINISH: 2.2 µm Ra, 27VDI

DENSITY (g/cm ³)	SPECIFIC RESISTANCE (µΩm)	FLEXURAL STRENGTH (N/mm ²)	HARDNESS (Shore)	HARDNESS (µm)
1,83	12,5	54	62	7

HK-20: HIGH PERFORMANCE GRADE

APPLICATION: Ideal for general mould tool applications where low wear and high
SURFACE FINISH: 1.6 µm Ra, 24VDI

DENSITY (g/cm ³)	SPECIFIC RESISTANCE (µΩm)	FLEXURAL STRENGTH (N/mm ²)	HARDNESS (Shore)	HARDNESS (µm)
1,86	12	66	60	6

HK-2: PRECISION GRADE

APPLICATION: Ideal for high quality finishing of small to medium die--casting tools,
high definition mould and press tools.
SURFACE FINISH: 1,26 µm Ra, 22VDI

DENSITY (g/cm ³)	SPECIFIC RESISTANCE (µΩm)	FLEXURAL STRENGTH (N/mm ²)	TWARDOŚĆ (Shore)	ŚREDNIA WIELKOŚĆ ZIARNA (µm)
1,82	13,5	64	64	7

HK-75: HIGHPRECISIONGRADE

APPLICATION: Ideal for high quality finishing of small to medium die--casting tools,
high definition mould and press tools.
SURFACE FINISH: 1.0 µm Ra,20VDI

DENSITY (g/cm ³)	SPECIFIC RESISTANCE (µΩm)	FLEXURAL STRENGTH (N/mm ²)	HARDNESS (Shore)	AVE. GRAIN SIZE (µm)
1,82	16,5	66	72	4

HK-3: HIGH PRECISION GRADE

APPLICATION: Superior grade of graphite for ultra-high definition, excellent edge
wear resistance and mechanical properties.
SURFACE FINISH: 0.63 µm Ra, 16VDI

DENSITY (g/cm ³)	SPECIFIC RESISTANCE (µΩm)	FLEXURAL STRENGTH (N/mm ²)	HARDNESS (Shore)	AVE. GRAIN SIZE (µm)
1,84	15,5	88	78	2

HK-6: ULTRA HIGH PRECISION GRADE

APPLICATION: Unique grade of ultra--fine graphite incorporating high strength,
low wear characteristics and excellent properties for high quality surface finishing.
SURFACE FINISH: 0.63 µm Ra, 16VDI

DENSITY (g/cm ³)	SPECIFIC RESISTANCE (µΩm)	FLEXURAL STRENGTH na zginanie (N/mm ²)	HARDNESS (Shore)	AVE. GRAIN SIZE (µm)
1,86	12	85	68	3

NOTE: Copper Impregnated materials HK--2C and HK--3C are also available. All properties are typical values and are not to be used for specification limits. All information was correct at the time of writing.