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How to Place an Order for Metallic & Special Purpose Electrodes

Simply call our 800 number, Fax your order to 1-800-325-7584, or visit our Web Site at www.intech-edm.com to order on-line. Please provide:

- Your company name and customer account number, if available.
- Name of person placing order, and telephone number.
- Catalog number, size, quantity and description of product.

- Shipping method and any special instructions.
- Purchase order number.

Please note that we accept American Express, Discover, MasterCard and Visa as payment for purchases.

Then enjoy Intech's **60 Day Return Policy*** and **95% Same-day Service Level***.

* See Ordering Information, page 1.3, for details.

Customer Service



Since our Customer Service Representatives interact with so many customers, having many different models of EDM machines, they've had to become the most knowledgeable in the business. The variety and complexity of machines our customers use present two challenges to us.

First, because the parts often look very much alike, it can be confusing as to which part is for which machine model. Second, since each machine model has different characteristics, it's important for us to be familiar with that machine so we can recommend the correct accessory, wire or other product.

To answer these challenges, Intech EDM has developed the most comprehensive on-line computer database in the EDM industry. It identifies all known machine models, and the exact replacement parts, wire and other products each requires.

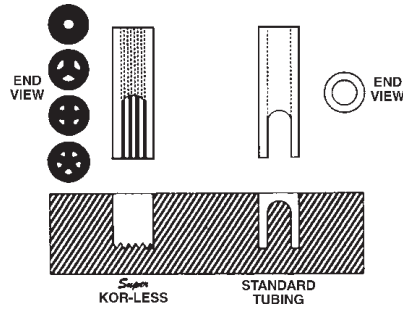
We continue to refine this system, and are constantly updating it with new information as it becomes available. It's now so smart, we call it **Intech Knows**.

Talk to any of our Customer Service Representatives and tell them about your machine – the brand, complete model number, serial number, and date manufactured (if you know it) – and **Intech Knows** will help us make sure that we ship you the correct product for your specific machine.

Super Kor-less®

Copper Small-hole Drills

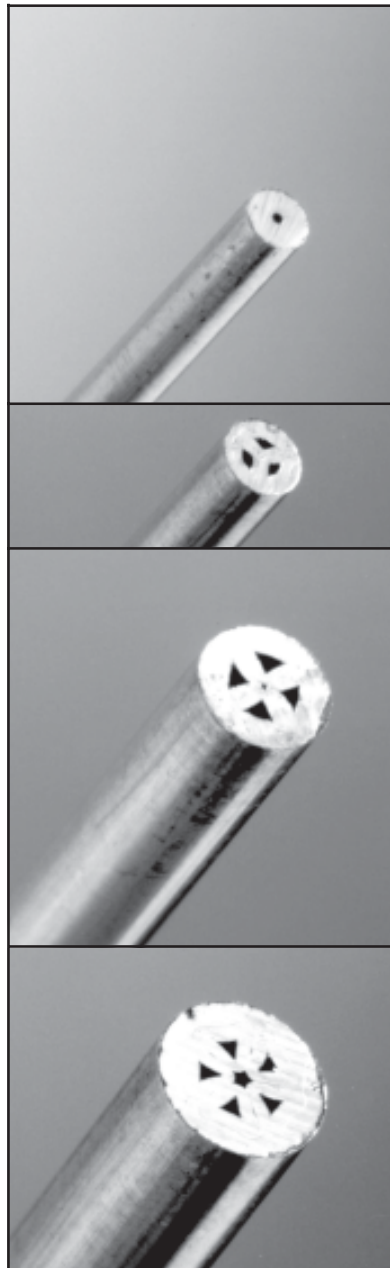
Super Kor-less® Electrodes have a unique design which eliminates the standing spike normally experienced with tubular electrodes. Super Kor-less® Electrodes are equally useful in "blind" bottom or "through hole" applications; and because no moving "spike" is present, EDMing is faster and more efficient. All Super Kor-less® Electrodes are made in the U.S.A.



Dia. Tolerance: $+0/-0.0005"$ ($+0/-0.013\text{mm}$).
Length: 12" (304.88mm). **1 Pack = 10 Pieces**

Upon request, sizes up to 0.25" are available, and any intermediate diameter can be centerless ground.

Superset: contains 100 Super Kor-less electrodes; 5 pieces each of 20 different diameters as indicated by Y in table to right.
Catalog No. – TS3010



Catalog No.	Diameter		In Set
	Inch	mm	
TC0050	.020	0.508	Y
TC0060	.024	0.610	
TC0070	.028	0.711	
TC0080	.031	0.787	Y
TC0090	.035	0.889	Y
TC0100	.039	0.991	
TC0110	.043	1.092	Y
TC0120	.047	1.194	
TC0130	.051	1.295	Y
TC0140	.055	1.397	Y
TC0150	.059	1.499	Y
TC0170	.067	1.702	Y
TC0180	.071	1.803	
TC0190	.075	1.905	Y
TC0200	.079	2.007	Y
TC0210	.083	2.108	
TC0220	.087	2.210	Y
TC0230	.091	2.311	
TC0240	.094	2.388	Y
TC0250	.098	2.489	Y
TC0260	.102	2.591	
TC0270	.106	2.692	
TC0280	.110	2.794	Y
TC0290	.114	2.896	
TC0300	.118	2.997	Y
TC0310	.122	3.099	
TC0320	.126	3.200	Y
TC0330	.130	3.302	Y
TC0340	.134	3.404	
TC0350	.138	3.505	Y
TC0360	.141	3.581	
TC0370	.145	3.683	Y
TC0380	.149	3.785	
TC0390	.153	3.887	
TC0400	.157	3.988	Y

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Multi-channel Tubing

Brass and Copper Small-hole Drills

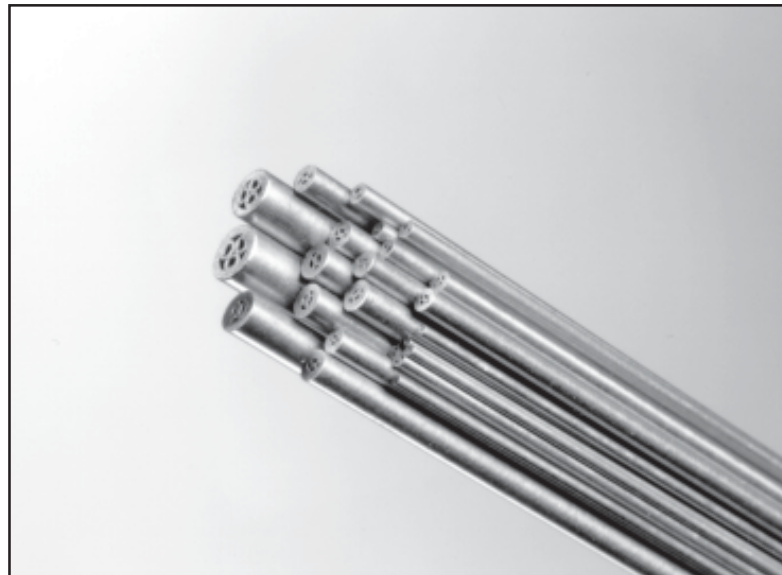
Dia. Tolerance: $+0/-0.0005"$ ($+0/-0.013\text{mm}$). **Length:** 300 or 400mm, as shown.
1 Pack = 10 Pieces Any intermediate diameter can be centerless ground.

Catalog No.				Diameter	
Brass		Copper			
300mm	400mm	300mm	400mm	mm	Inch
TMB3050	TMB4050	TMC3050	TMC4050	0.5	.0197
TMB3060	TMB4060	TMC3060	TMC4060	0.6	.0236
TMB3070	TMB4070	TMC3070	TMC4070	0.7	.0276
TMB3080	TMB4080	TMC3080	TMC4080	0.8	.0315
TMB3090	TMB4090	TMC3090	TMC4090	0.9	.0354
TMB3100	TMB4100	TMC3100	TMC4100	1.0	.0394
TMB3110	TMB4110	TMC3110	TMC4110	1.1	.0433
TMB3120	TMB4120	TMC3120	TMC4120	1.2	.0472
TMB3130	TMB4130	TMC3130	TMC4130	1.3	.0512
TMB3140	TMB4140	TMC3140	TMC4140	1.4	.0551
TMB3150	TMB4150	TMC3150	TMC4150	1.5	.0591
TMB3160	TMB4160	TMC3160	TMC4160	1.6	.0630

Catalog No.				Diameter	
Brass		Copper			
300mm	400mm	300mm	400mm	mm	Inch
TMB3170	TMB4170	TMC3170	TMC4170	1.7	.0669
TMB3180	TMB4180	TMC3180	TMC4180	1.8	.0709
TMB3190	TMB4190	TMC3190	TMC4190	1.9	.0748
TMB3200	TMB4200	TMC3200	TMC4200	2.0	.0787
TMB3210	TMB4210	TMC3210	TMC4210	2.1	.0827
TMB3220	TMB4220	TMC3220	TMC4220	2.2	.0866
TMB3230	TMB4230	TMC3230	TMC4230	2.3	.0906
TMB3240	TMB4240	TMC3240	TMC4240	2.4	.0945
TMB3250	TMB4250	TMC3250	TMC4250	2.5	.0984
TMB3300	TMB4300	TMC3300	TMC4300	3.0	.1181
TMB3350	TMB4350	TMC3350	TMC4350	3.5	.1378
TMB3400	TMB4400	TMC3400	TMC4400	4.0	.1575



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Tubular Small-hole Drills - Brass

Inch Sizes

Diameter Tolerance: $\pm 0.0005"$ ($\pm 0.013\text{mm}$)
Length: 12" (304.8mm) **1 Pack = 10 Pieces**

Catalog No.	Diameter	
	Inch	mm
T10015	.006	0.152
T10020	.008	0.203
T10022	.009	0.229
T10025	.010	0.254
T10027	.011	0.279
T10030	.012	0.305
T10033	.013	0.330
T10035	.014	0.356
T10038	.015	0.381
T10040	.016	0.406
T10043	.017	0.432
T10045	.018	0.457
T10048	.019	0.483
T10050	.020	0.508
T10053	.021	0.533
T10055	.022	0.559
T10058	.023	0.584
T10061	.024	0.610
T10063	.025	0.635
T10066	.026	0.660
T10068	.027	0.686
T10071	.028	0.711
T10076	.030	0.762
T10078	.031	0.787
T10081	.032	0.813
T10083	.033	0.838
T10086	.034	0.864
T10088	.035	0.889
T10091	.036	0.914
T10094	.037	0.940
T10096	.038	0.965
T10099	.039	0.991
T10101	.040	1.016
T10104	.041	1.041
T10106	.042	1.067
T10109	.043	1.092
T10114	.045	1.143
T10116	.046	1.168
T10119	.047	1.194
T10121	.048	1.219

Catalog No.	Diameter	
	Inch	mm
T10127	.050	1.270
T10129	.051	1.295
T10132	.052	1.321
T10137	.054	1.372
T10139	.055	1.397
T10142	.056	1.422
T10144	.057	1.448
T10147	.058	1.473
T10149	.059	1.499
T10152	.060	1.524
T10154	.061	1.549
T10157	.062	1.575
T10160	.063	1.600
T10165	.065	1.651
T10170	.067	1.702
T10175	.069	1.753
T10185	.073	1.854
T10188	.074	1.880
T10190	.075	1.905
T10193	.076	1.930
T10198	.078	1.981
T10200	.079	2.007
T10203	.080	2.032
T10208	.082	2.083
T10213	.084	2.134
T10215	.085	2.159
T10218	.086	2.184
T10221	.087	2.210
T10223	.088	2.235
T10228	.090	2.286
T10233	.092	2.337
T10236	.093	2.362
T10238	.094	2.388
T10317	.125	3.175
T10475	.187	4.750
T10515	.203	5.156
T10635	.250	6.350

Metric Sizes

Diameter Tolerance: 0/-0.013mm
1 Pack = 10 Pieces

Catalog No.	Dia.	Length
	mm	mm
TB40030	0.30	400
TB40040	0.40	400
TB40050	0.50	400
TB40070	0.70	400
TB40080	0.80	400
TB40090	0.90	400
TB40100	1.00	400
TB40120	1.20	400
TB40130	1.30	400
TB40140	1.40	400
TB40150	1.50	400
TB40200	2.00	400
TB40210	2.10	400
TB40220	2.20	400
TB40230	2.30	400
TB40300	3.00	400
TB40550	5.50	400

Other sizes/increments, both inch and metric, are readily available; please call Customer Service for more information.

Tubular Small-hole Drills - Copper

Diameter Tolerance: $\pm .0005"$ ($\pm 0.013\text{mm}$). **Length:** 12" (304.8mm). **1 Pack = 10 Pieces**

Superset: contains 150 tubular copper electrodes; 5 pieces each of 30 different diameters as indicated by Y in table below. **Catalog No. – TS3015**

Catalog No.	Diameter		In Set
	Inch	mm	
TA0020	.008	0.203	Y
TA0025	.010	0.254	
TA0030	.012	0.305	Y
TA0038	.015	0.381	
TA0040	.016	0.406	
TA0043	.017	0.432	
TA0045	.018	0.457	
TA0048	.019	0.483	
TA0050	.020	0.508	Y
TA0053	.021	0.533	
TA0055	.022	0.559	
TA0058	.023	0.584	
TA0060	.024	0.610	
TA0063	.025	0.635	Y
TA0066	.026	0.660	
TA0068	.027	0.686	
TA0070	.028	0.711	
TA0073	.029	0.737	
TA0076	.030	0.762	
TA0080	.031	0.787	Y
TA0090	.035	0.889	Y
TA0100	.039	0.991	Y
TA0101	.040	1.016	
TA0110	.043	1.092	Y
TA0114	.045	1.143	
TA0120	.047	1.194	
TA0127	.050	1.270	
TA0130	.051	1.295	Y
TA0137	.054	1.372	
TA0140	.055	1.397	
TA0150	.059	1.499	Y
TA0157	.062	1.575	
TA0160	.063	1.600	Y
TA0170	.067	1.702	Y
TA0180	.071	1.803	
TA0188	.074	1.880	
TA0190	.075	1.905	Y
TA0200	.079	2.007	Y
TA0210	.083	2.108	Y
TA0218	.086	2.184	
TA0220	.087	2.210	Y
TA0230	.091	2.311	Y
TA0236	.093	2.362	
TA0240	.094	2.388	
TA0250	.098	2.489	Y
TA0260	.102	2.591	
TA0264	.104	2.642	
TA0270	.106	2.692	Y
TA0276	.109	2.769	
TA0280	.110	2.794	Y

Catalog No.	Diameter		In Set
	Inch	mm	
TA0284	.112	2.845	
TA0290	.114	2.896	
TA0300	.118	2.997	Y
TA0304	.120	3.048	
TA0310	.122	3.099	
TA0317	.125	3.175	Y
TA0320	.126	3.200	
TA0325	.128	3.251	
TA0330	.130	3.302	
TA0340	.134	3.404	
TA0342	.135	3.429	Y
TA0350	.138	3.505	
TA0355	.140	3.556	
TA0360	.142	3.607	
TA0365	.144	3.658	Y
TA0370	.146	3.709	
TA0380	.150	3.810	Y
TA0390	.153	3.887	
TA0396	.156	3.962	Y
TA0400	.157	3.988	
TA0406	.160	4.064	
TA0410	.161	4.089	
TA0420	.165	4.191	Y
TA0430	.169	4.293	
TA0434	.171	4.343	
TA0440	.173	4.394	
TA0444	.175	4.445	Y
TA0450	.177	4.496	
TA0460	.181	4.597	
TA0470	.185	4.699	
TA0475	.187	4.750	Y
TA0480	.189	4.801	
TA0487	.192	4.877	
TA0490	.193	4.902	
TA0500	.197	5.004	
TA0510	.201	5.105	
TA0515	.203	5.156	
TA0520	.205	5.207	
TA0530	.209	5.309	
TA0538	.212	5.385	
TA0540	.213	5.410	
TA0550	.216	5.486	
TA0553	.218	5.537	
TA0560	.220	5.588	
TA0570	.224	5.690	
TA0580	.228	5.791	
TA0590	.232	5.893	
TA0594	.234	5.944	
TA0600	.236	5.994	
TA0635	.250	6.350	Y



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Rototubes

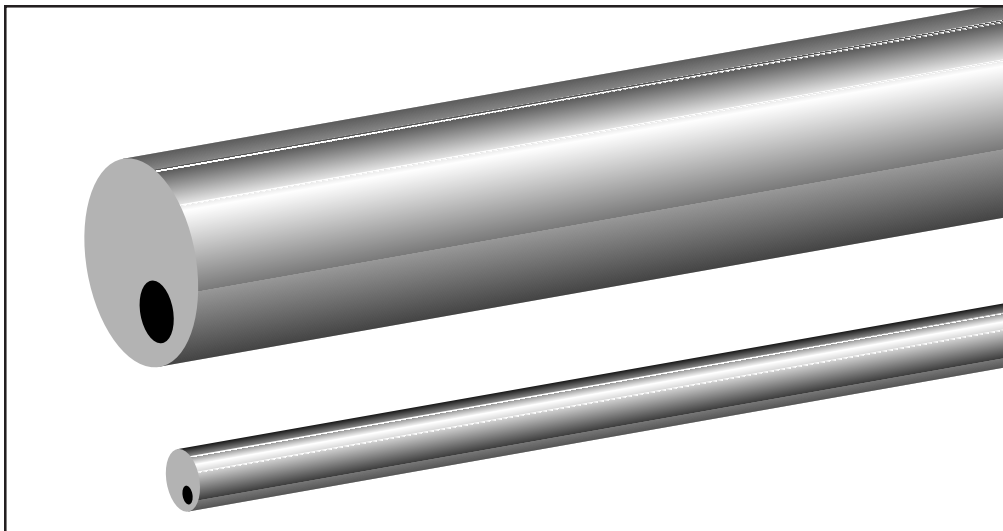
Micro-graph 5C Graphite Hole Drills

- Tubular graphite electrodes designed for use in rotating heads
- Offset flushing holes leave no core
- Cuts blind holes with flat, square bottoms
- Cuts thru holes faster – no core to impede flushing
- All sizes are sold in packs of 5 pieces.

Dia. Tolerance: $+0.001/-0.000$ " ($+0.013/-0$ mm).

Length: 6" (152.40mm).

Catalog No.	Diameter	
	Inch	mm
TR0032	0.125	3.175
TR0040	0.156	3.962
TR0048	0.187	4.750
TR0055	0.218	5.537
TR0064	0.250	6.350
TR0071	0.281	7.137
TR0079	0.312	7.925
TR0087	0.343	8.712
TR0095	0.375	9.525



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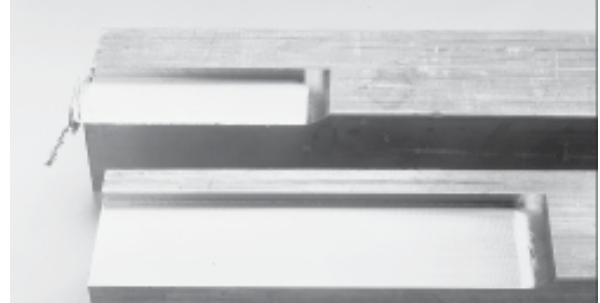
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Tellurium Copper Electrodes

Rectangles

Catalog No.	Thickness (In)	Width (In)	Length (In)
T41203	1/4	4	6
T41223	1/4	4	12
T41232	1/4	6	12
T41204	3/8	4	6
T41212	3/8	6	6
T41224	3/8	4	12
T41233	3/8	6	12
T41201	1/2	2	6
T41205	1/2	4	6
T41213	1/2	6	6
T41221	1/2	2	12
T41225	1/2	4	12
T41234	1/2	6	12
T41206	3/4	4	6
T41220	3/4	1-1/4	12
T41226	3/4	4	12
T41235	3/4	6	12
T41202	1	3	6
T41207	1	4	6
T41215	1	6	6
T41222	1	3	12
T41227	1	4	12
T41236	1	6	12
T41208	1-1/4	4	6
T41216	1-1/4	6	6
T41228	1-1/4	4	12
T41237	1-1/4	6	12
T41209	1-1/2	4	6
T41217	1-1/2	6	6
T41229	1-1/2	4	12
T41238	1-1/2	6	12
T41210	1-3/4	4	6
T41230	1-3/4	4	12
T41239	1-3/4	6	12
T41211	2	4	6
T41231	2	4	12
T41240	2	6	12

Intech EDM's copper electrode material contains 1/2% tellurium, which improves machinability and fabrication properties to approximately 90% of free-cutting brass.



Top – Regular copper with characteristic burr;
Bottom – Tellurium copper

Squares

Catalog No.	Inch Square	Length (In)
T41401	3/8	12
T41402	1/2	
T41403	5/8	
T41404	3/4	
T41405	1	
T41406	1-1/2	
T41407	2	

Rounds

Catalog No.	Diameter (In)	Length (In)
T41001	1/4	12
T41002	3/8	
T41003	1/2	
T41004	5/8	
T41005	3/4	
T41006	1	
T41007	1-1/4	
T41008	1-1/2	
T41009	2	
T41010	2-1/2	
T41011	3	
T41012	3-1/2	
T41013	4	



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Tungsten Wire Electrodes

Cleaned & Straightened

Length: 12" **Diameter Tolerance:** $\pm 1\frac{1}{2}\%$ **1 Pack = 10 Pieces**

Catalog No.	Diameter		Catalog No.	Diameter		Catalog No.	Diameter	
	Inch	mm		Inch	mm		Inch	mm
T51013	.005	.127	T51038	.015	.381	T51076	.030	.762
T51015	.006	.152	T51041	.016	.406	T51081	.032	.813
T51018	.007	.178	T51043	.017	.432	T51086	.034	.864
T51020	.008	.203	T51046	.018	.457	T51091	.036	.914
T51023	.009	.229	T51048	.019	.483	T51097	.038	.965
T51025	.010	.254	T51051	.020	.508	T51102	.040	1.016
T51028	.011	.279	T51056	.022	.559	T51114	.045	1.143
T51030	.012	.305	T51061	.024	.610	T51127	.050	1.270
T51033	.013	.330	T51066	.026	.660	T51152	.060	1.524
T51036	.014	.356	T51071	.028	.711			

Tungsten Carbide Rods

Length: 2"/50.8mm **Diameter Tolerance:** $\pm .0005"/.013\text{mm}$ **1 Pack = 10 Pieces**

- Stable Cutting
- Excellent wear ratio
- Centerless ground
- True, straight and round
- High metal removal rate

Catalog No.	Diameter	
	Inch	mm
T21012	.005	.127
T21015	.006	.152
T21017	.007	.177
T21020	.008	.203
T21022	.009	.229
T21025	.010	.254
T21027	.011	.279
T21030	.012	.305

Catalog No.	Diameter	
	Inch	mm
T21033	.013	.330
T21035	.014	.356
T21038	.015	.381
T21040	.016	.406
T21043	.017	.432
T21045	.018	.457
T21048	.019	.483
T21050	.020	.508

Other Sizes: the following lengths and diameters are available. Please call Customer Service for price and delivery information.

- 4" length; diameters from .021 to .030"
- 6" length; diameters from .031 to .040"

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Tungsten Carbide Tubing

Precision Centerless Ground

Length: 6"/152.4mm **Outside Diameter Tolerance:** ± .0005"/.013mm **1 Pack=5 Pieces**
Special Sizes – Ground on Request

Catalog No.	Outside Diameter (O.D.)	
	Inch	mm
T20030*	.012	.305
T20033*	.013	.330
T20035*	.014	.356
T20038	.015	.381
T20040	.016	.406
T20043	.017	.432
T20046	.018	.457
T20048	.019	.483
T20051	.020	.508
T20053	.021	.533
T20056	.022	.559
T20058	.023	.584
T20061	.024	.610
T20064	.025	.635
T20066	.026	.660
T20068	.027	.686
T20071	.028	.711
T20073	.029	.737
T20076	.030	.762
T20078	.031	.787
T20081	.032	.813
T20083	.033	.838
T20086	.034	.864
T20088	.035	.889
T20091	.036	.914
T20094	.037	.940
T20096	.038	.965
T20099	.039	.991
T20101	.040	.016
T20104	.041	1.041
T20106	.042	1.067
T20109	.043	1.092
T20111	.044	1.118
T20114	.045	1.143
T20116	.046	1.168
T20119	.047	1.194
T20121	.048	1.219
T20124	.049	1.245

Catalog No.	Outside Diameter (O.D.)	
	Inch	mm
T20127	.050	1.270
T20129	.051	1.295
T20132	.052	1.321
T20135	.053	1.346
T20137	.054	1.372
T20139	.055	1.397
T20142	.056	1.422
T20145	.057	1.448
T20147	.058	1.473
T20149	.059	1.499
T20152	.060	1.524
T20154	.061	1.549
T20157	.062	1.575
T20160	.063	1.600
T20170	.067	1.702
T20180	.071	1.803
T20188	.074	1.880
T20196	.077	1.956
T20203	.080	2.032
T20213	.084	2.134
T20226	.089	2.261
T20239	.094	2.388
T20251	.099	2.515
T20259	.102	2.591
T20277	.109	2.769
T20287	.113	2.870
T20297	.117	2.972
T20310	.122	3.099
T20318	.125	3.175
T20358	.141	3.581
T20396	.156	3.962
T20437	.172	4.369
T20467	.184	4.674
T20516	.203	5.156
T20556	.219	5.563
T20594	.234	5.944
T20627	.247	6.274
T20635	.250	6.350

* These sizes come in random lengths of 4-6"



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Copper Tungsten Electrodes

Strips

Catalog No.	Inch			mm			Thickness Tolerance
	Thickness	Width	Length	Thickness	Width	Length	
T34101	.005	1	8	.127	25.40	203.20	+/- .0003"
T34102	.006			.152			
T34103	.007			.178			
T34104	.008			.203			
T34105	.009			.229			
T34106	.010			.254			+/- .0005"
T34107	.011			.279			
T34108	.012			.305			
T34109	.013			.330			
T34110	.014			.356			
T34111	.015	3	8	.381	76.20	203.20	+/- .001"
T34112	.020			.508			
T34113	.025			.635			+/- .002"
T34114	.030			.762			
T34115	.035			.889			
T34116	.040	3	8	1.016	76.20	203.20	+/- .004"
T34117	.045			1.143			
T34118	.050			1.270			
T34119	.062			1.524			



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Tubing

Catalog No.	Inch		mm		O.D. Tolerance
	O.D.	Length	O.D.	Length	
T33001	.020	7	.508	177.80	+ .001"/-0
T33002	.025		.635		
T33003	.030		.762		
T33004	.035		.889		
T33005	.040		1.016		
T33006	.045		1.143		
T33007	.050		1.270		
T33008	.054		1.372		
T33009	.062		1.575		
T33010	.074		1.880		
T33011	.086		2.184		
T33012	.093		2.632		
T33013	.125		3.175		
T33014	.187		8		
T33015	.250	6.350			
T33017	.375	9.525			
T33019	.500	12.700			

Copper Tungsten Electrodes

Catalog No.	Inch		mm	
	Thickness	Width	Thickness	Width
T33201	3/32	2	2.38	50.80
T33203	1/8		3.18	
T33205	3/16		4.76	
T33207	1/4		6.35	
T33209	3/8		9.53	
T33211	1/2		12.70	
T33213	5/8		15.88	
T33215	3/4		19.05	
T33217	1		25.40	
T33219	1-1/4		31.75	
T33202	3/32	4	2.38	101.60
T33204	1/8		3.18	
T33206	3/16		4.76	
T33208	1/4		6.35	
T33210	3/8		9.53	
T33212	1/2		12.70	
T33214	5/8		15.88	
T33216	3/4		19.05	
T33218	1		25.40	
T33220	1-1/4		31.75	
T33221	1-1/2		38.10	
T33223	2		50.80	

Rectangles

Length: 8" (203.20mm)

Tolerance: +.010"/-0 (+.254mm/-0)

Catalog No.	Inch Square	mm Square
T33401	1/8	3.18
T33402	3/16	4.76
T33403	1/4	6.35
T33404	5/16	7.94
T33405	3/8	9.53
T33406	7/16	11.11
T33407	1/2	12.70
T33409	5/8	15.88
T33410	3/4	19.05
T33411	7/8	22.23
T33412	1	25.40
T33416	2	50.80

Squares

Length: 8" (203.20mm)

Tolerance: +.010"/-0 (+.254mm/-0)



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Copper Tungsten Electrodes

Rods (Small Diameter)

Diameter Tolerance: $\pm .0005"$ (.013mm)

Note: 1/8" or under = 60 Tungsten/40 Cu
Over 1/8" = 70 Tungsten/30 Cu

Catalog No.	Inch		mm	
	Diameter	Length	Diameter	Length
T33501	.022	7	.559	177.80
T33502	.024			
T33503	.026			
T33504	.028			
T33505	.030			
T33506	.035			
T33507	.040			
T33508	.045			
T33509	.050			
T33510	.055			
T33511	.060			
T33512	.065			
T33513	.070			
T33514	.075			
T33515	.080			
T33516	.085			
T33517	.090	8	2.268	203.20
T33518	.095		2.413	
T33519	.100		2.540	
T33520	.105		2.667	
T33521	.110		2.794	
T33522	.115		2.921	
T33523	.120	3.048		

Rounds

Length: 8" (203.20mm)

Diameter Tolerance:
 $+.010"/-0$ (+.254mm/-0)

Catalog No.	Inch Diameter	mm Diameter
T33601	1/8	3.18
T33602	3/16	4.76
T33603	1/4	6.35
T33604	5/16	7.94
T33605	3/8	9.53
T33606	7/16	11.11
T33607	1/2	12.70
T33608	9/16	14.29
T33609	5/8	15.88
T33610	11/16	17.46
T33611	3/4	19.05
T33612	7/8	22.23
T33613	1	25.40
T33614	1-1/8	28.58
T33615	1-1/4	31.75
T33617	1-1/2	38.10
T33619	1-3/4	44.45
T33621	2	50.80

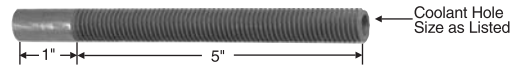


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EDM Tapping Electrodes

Copper Graphite POCO EDM-C3 for Tapping Carbide & Steel - Metric

- Thread size and pitch are metric; all other dimensions are inch.
- Shank diameter tolerance: $+.000/-.001$ ".
- Tapping electrode sizes up to and including M10x1.5 are shipped in packs of 5; all larger sizes are shipped individually.



These sizes are sold in packs of 5 pieces.

Metric Tapping Electrodes				
Catalog No.	Thread Size and Pitch	Pitch Diameter Undersize	Shank Diameter	Coolant Hole
GX7000	M3x.5	.001	.118	None
GX7001	M3.5x.6	.001	.138	None
GX7002	M4x.7	.001	.158	1/16
GX7003	M4.5x.75	.001	.177	1/16
GX7004	M5x.8	.001	.197	1/16
GX7005	M6x1	.002	.236	1/16
GX7006	M7x1	.002	.276	3/32
GX7007	M8x1.25	.002	.315	1/8
GX7008	M10x1.5	.002	.394	5/32

These sizes are sold individually.

GX7009	M12x1.75	.003	.473	3/16
GX7010	M14x2	.003	.551	11/32
GX7011	M16x2	.004	.630	3/8
GX7012	M18x2.5	.004	.709	7/16
GX7013	M20x2.5	.004	.788	1/2

NOTE: To facilitate core removal when tapping blind holes, it is recommended to make a cut through the center of the core with a flat electrode wider than the core diameter; both halves will then break at the root with a sharp tap.

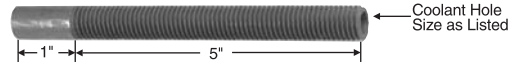
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EDM Tapping Electrodes

Copper Graphite POCO EDM-C3 for Tapping Carbide & Steel - Inch

- All dimensions are inch.
- Shank diameter tolerance: $+.000/-.001$ ".
- Sizes up to and including 3/8-24 are shipped in packs of 5; all larger sizes are shipped individually.



Catalog No.	Thread Size	Pitch Diameter Undersize	Shank Diameter	Coolant Hole
GX7050	4-40	.001	.109	None
GX7051	5-40	.001	.125	None
GX7052	6-32	.001	.140	None
GX7053	8-32	.001	.171	1/16
GX7054	10-24	.001	.187	1/16
GX7055	10-32	.001	.187	1/16
GX7056	1/4-20	.002	.250	1/16
GX7057	1/4-28	.002	.250	1/16
GX7058	5/16-18	.002	.312	1/8
GX7059	5/16-24	.002	.312	1/8
GX7060	3/8-16	.002	.375	5/32
GX7061	3/8-24	.002	.375	5/32

These sizes are sold in packs of 5 pieces.

GX7062	7/16-14	.003	.437	3/16
GX7063	7/16-20	.003	.437	3/16
GX7064	1/2-13	.003	.500	1/4
GX7065	1/2-20	.003	.500	1/4

These sizes are sold individually.

NOTE: To facilitate core removal when tapping blind holes, it is recommended to make a cut through the center of the core with a flat electrode wider than the core diameter; both halves will then break at the root with a sharp tap.

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EDM Orbiting Tapping Electrodes

Copper Graphite POCO EDM-C3 for Tapping Carbide & Steel - Metric

- All dimensions are in millimeters except for flushing hole, shank length and thread length (on drawing to right).
- Shank diameter tolerance: $+.000/-0.001$ ".
- Sizes up to and including M10X1.5 are shipped in packs of 5; all larger sizes are shipped individually.



Catalog No.	Thread Size	Shank Diameter mm/Inch	Tap Drill Size	Coolant Hole (Inch)
GY7200	M3.0 x 0.50	2.25 / .088	2.50	None
GY7201	M3.5 x 0.60	2.65 / .104	2.90	None
GY7202	M4.0 x 0.70	3.05 / .120	3.30	None
GY7203	M4.5 x 0.75	3.45 / .136	3.70	None
GY7204	M5.0 x 0.80	3.95 / .156	4.20	None
GY7205	M6.0 x 1.0	4.75 / .187	5.00	1/16
GY7206	M7.0 x 1.0	5.75 / .226	6.00	1/16
GY7207	M8.0 x 1.25	6.55 / .258	6.80	1/16
GY7208	M10.0 x 1.50	8.25 / .325	8.50	1/8

These sizes are sold in packs of 5 pieces.

GY7209	M12.0 x 1.75	9.95 / .392	10.20	1/8
GY7210	M14.0 x 2.0	11.75 / .462	12.00	1/8
GY7211	M16.0 x 2.0	13.75 / .541	14.00	1/4
GY7212	M18.0 x 2.5	15.25 / .600	15.50	1/4
GY7213	M20.0 x 2.5	17.25 / .679	17.50	1/4

These sizes are sold individually.

NOTE: To facilitate core removal when tapping blind holes, it is recommended to make a cut through the center of the core with a flat electrode wider than the core diameter; both halves will then break at the root with a sharp tap.



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EDM Orbiting Tapping Electrodes

Copper Graphite POCO EDM-C3 for Tapping Carbide & Steel - Inch

- All dimensions are inch.
- Shank diameter tolerance: $+.000/-.001$ ".
- Sizes up to and including 3/8-24 are shipped in packs of 5; all larger sizes are shipped individually.



Catalog No.	Thread Size	Shank Diameter	Tap Drill Size	Coolant Hole
GX7150	4-40	.078	.0890	None
GX7151	5-40	.091	.1015	None
GX7152	6-32	.096	.1065	None
GX7153	8-32	.125	.1360	None
GX7154	10-24	.137	.1470	None
GX7155	10-32	.149	.1590	3/64
GX7156	1/4-20	.191	.2010	1/16
GX7157	1/4-28	.203	.2130	1/16
GX7158	5/16-18	.247	.2570	3/32
GX7159	5/16-24	.262	.2720	3/32
GX7160	3/8-16	.302	.3125	1/8
GX7161	3/8-24	.322	.3320	1/8

*These sizes are sold in
packs of 5 pieces.*

GX7162	7/16-14	.358	.3680	3/16
GX7163	7/16-20	.379	.3906	3/16
GX7164	1/2-13	.411	.4218	1/4
GX7165	1/2-20	.443	.4530	1/4

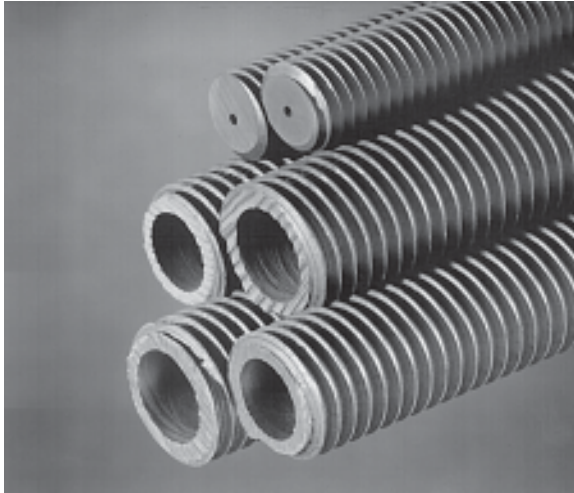
*These sizes are
sold individually.*

NOTE: To facilitate core removal when tapping blind holes, it is recommended to make a cut through the center of the core with a flat electrode wider than the core diameter; both halves will then break at the root with a sharp tap.

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EDM Tapping Electrodes

POCO EDM-200 w/Coolant Hole - Inch



These electrodes are manufactured with the Pitch Diameter undersized in the proper amount to allow for overcut, and to acquire the most efficient cutting current (amperage).

- U.S. standard sizes; metric sizes available on request.
- All dimensions in inches.
- Shank diameter tolerance: $+.000/-0.001$ ".
- Sizes up to and including 3/8-24 are shipped in packs of 5; all larger sizes are shipped individually.



Catalog No.	Thread Size	Pitch Diameter Undersize	Shank Diameter	Coolant Hole
GJ7056	1/4-20	.002	1/4	1/16
GJ7057	1/4-28			
GJ7058	5/16-18	.002	5/16	1/8
GJ7059	5/16-24			
GJ7060	3/8-16	.002	3/8	3/16
GJ7061	3/8-24			

These sizes are sold in packs of 5 pieces.

GJ7062	7/16-14	.003	7/16	3/16
GJ7063	7/16-20			
GJ7064	1/2-13	.003	1/2	1/4
GJ7065	1/2-20			
GJ7066	9/16-12	.003	9/16	3/8
GJ7067	9/16-18			
GJ7068	5/8-11	.004	5/8	3/8
GJ7069	5/8-18			
GJ7070	3/4-10	.004	3/4	1/2
GJ7071	3/4-16			

These sizes are sold individually.

NOTE: To facilitate core removal when tapping blind holes, it is recommended to make a cut through the center of the core with a flat electrode wider than the core diameter; both halves will then break at the root with a sharp tap.



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EDM Orbiting Pipe Tapping Electrodes

Copper Graphite POCO EDM-C3 w/Coolant Hole - NPT



Catalog No.	Thread Size - NPT	Shank Diameter
GY7300	1/16	.3125
GY7301	1/8	.4375
GY7302	1/4	.500
GY7303	3/8	.625
GY7304	1/2	.750
GY7305	3/4	1.000

- U.S. standard NPT sizes; other pipe threads available on request.
- Overall length: 3"
- All dimensions in inches.
- Shank diameter tolerance: +.000/-.001".

Special Alpha/Numeric Character Electrodes

Our custom electrodes department has developed the ability to very quickly manufacture electrodes in a wide variety of alpha/numeric characters – numbers, letters, symbols, etc.

Even though these are technically “special”, that does not mean long delivery or high cost. They use specialized CAD/CAM software which quickly generates a program for our CNC machines and guarantees a quick turnaround on customer requests; at an economical near-stock cost.

- Right reading or reverse.
- Male or female.
- Single or double ended.
- Any reasonable size.
- Over 50 TrueType fonts are available on our system.
- Available Materials: POCO EDM-3 or EDM-C3, and Tellurium Copper.
- We can also readily make electrodes from your logo, trade mark or other special design. Electronically transmitted IGES or DXF files welcomed.

Call, Fax or E-mail your request and we'll respond promptly.

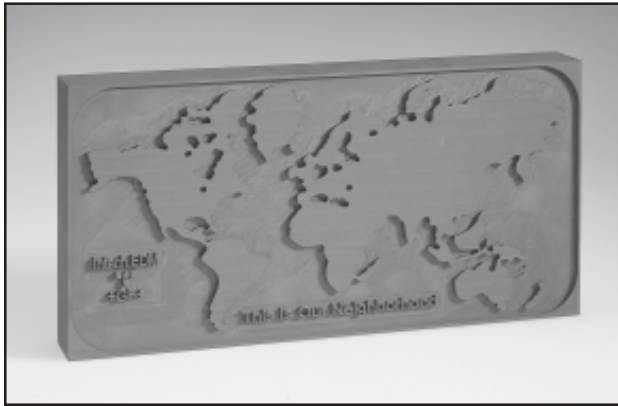


EDM

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Custom Electrodes

by Intech EDM, the world leader in EDM supplies and accessories



For over 40 years, Intech EDM has been a leader in manufacturing custom electrodes – a unique combination of experienced and talented people, working with current technology and equipment, with a “We Can Do That” attitude.

Experience?

“We’ve Got That!” Our shop team averages over 19 years of electrode manufacturing experience, and has accumulated more than 95 years of experience in graphite machining – they know how to get the job done right.

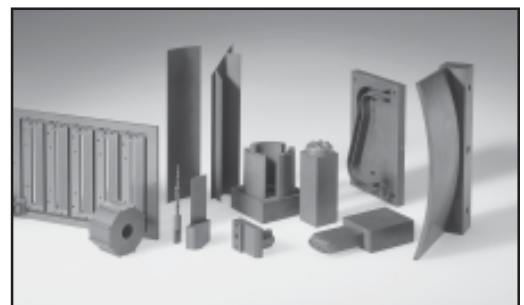
Equipment?

“We’ve Got That!” Our shop is completely equipped, with an array of electrode manufacturing machine tools that includes the latest Bostomatic 18G High Performance Machining Center, a 15" Mazak CNC Turning Center, Cincinnati CNC equipment, a Fadal High Speed Mill, and various centerless and surface grinding machines, including a 16 x 32" surface grinder. Our machining facility also includes special environmental systems to control the large amounts of dust generated in graphite machining. Utilizing the latest version of CAD/CAM software, we can work with any IGES or DXF CAD file, which you can send to us via the Internet. And, we’re SPC capable.



Fast Turn Around? Tough Jobs?

“We Can Do That!” Pictured is just a small, representative sample of the kind of work we can do; 2-D or 3-D, complex compound angles, turbine blades, extremely small, delicate electrodes, very close tolerances, high surface finish requirements – you name it, we can do it. And we’re just as responsive on the *hot* jobs as we are on the big projects.



“We Can Do That.”

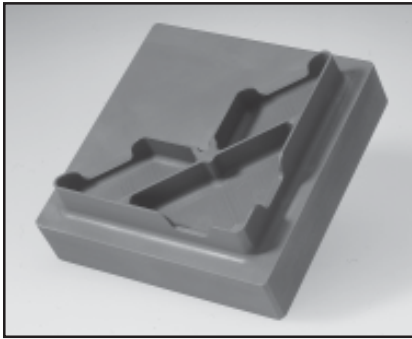
Give us a call at our toll-free number – 1-800-323-0295 – and try us out on the toughest, nastiest job you’ve got. Our people thrive on the “impossible” challenges.



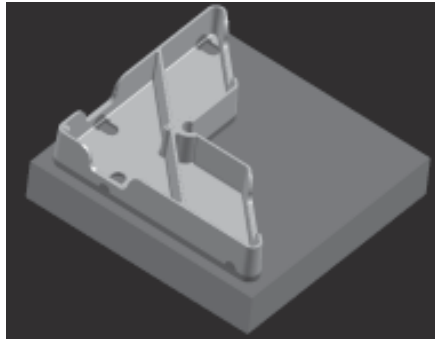
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Custom Electrodes

Examples



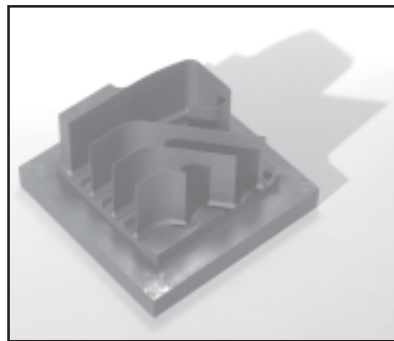
Actual Electrode



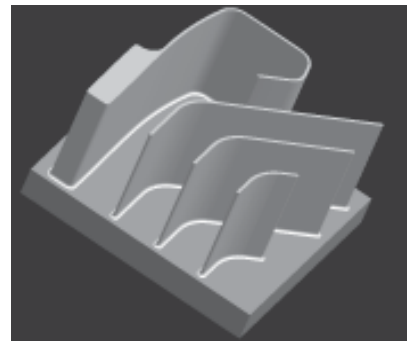
IGES CAD File

This injection molding electrode was originally processed from an IGES format CAD file received via the Internet. Our Custom Electrode team converted it into machine code for our machining center using SurfCAM.

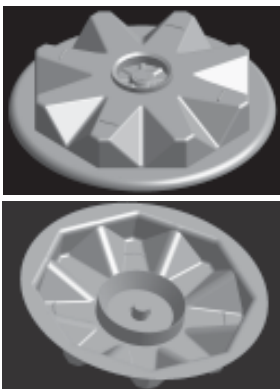
This Micro-graph 7 part was machined on a Bostomatic High Performance Machining Center with solid carbide endmills at 30,000 RPM. It has four ribs 30mm high and 0.3mm wide, and total machining/engraving time from solid block was 39.0 minutes. This demonstrates the capability of our Bostomatic H.P.M., and the excellent machinability of MG-7 fine-grained graphite.



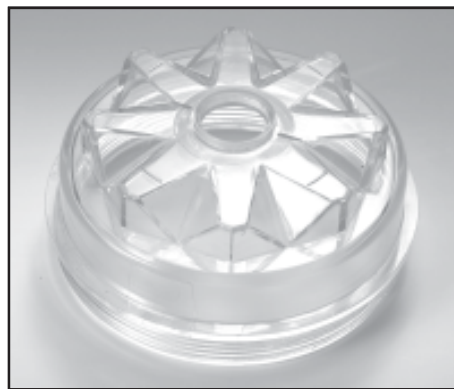
Actual Electrode



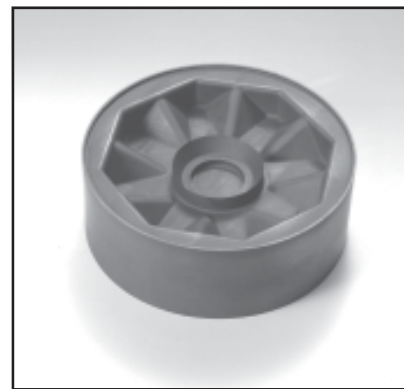
BMP CAD File



DXF CAD files of cavity and core.



Actual clear plastic part; a semi-trailer hub cap.



Actual electrode produced on our Bostomatic machine.

In many respects, this project is typical of the work done by our Custom Electrode department. The customer, Bear Plastics, Haltom City, Texas, sent us a CAD file of the finished piece part via the Internet, and shipped us a sample overnight. The part is a clear plastic hub cap for semitrailers, which allows the driver to readily see the level of oil in the axle hub.

In consultation with the customer, our programming team calculated the mold shrinkage and

overburn allowances to generate the machine program, using our advanced software system – a complex task. We recommended fine-grained TTK-4 graphite for this intricate job, and machined both core and cavity electrodes on our new Bostomatic 18G High Performance Machining Center.

The electrodes were completed and delivered in a timely manner, and all contact with the customer was carried out by phone and the Internet.



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