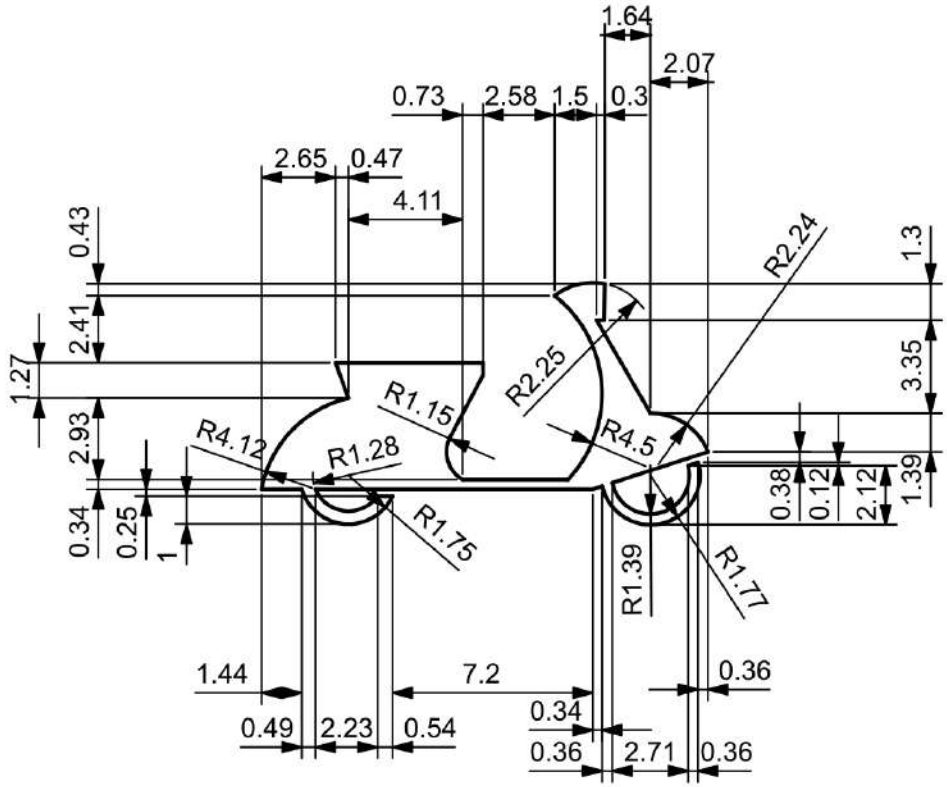
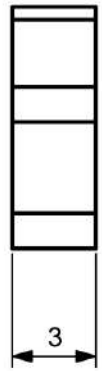
LENGTH OR DIA	MACHININIG DEVIATION TO ISI:2102(MEDIUM GRADE) UNLESS SPECIFIED OTHERWISE															
	UP TO 6	6 30	30 120	120 315	315 1000	1000 2000	2000 4000	4000 ABOVE	LENGTH IN mm OF SHORTER SIDE OF ANGLE				MACHINING FINISH MICRONS			
									UP TO 6	6-30	30-120	120-400	▽	▽▽	▽▽▽	▽▽▽▽
	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0	±60'	±30'	±20'	±10'	8-25	1.6-8	0.025-1.6	<0.025





NOTE
DO NOT SCALE THE DRAWING .
ALL DIMENSIONS ARE IN MILLIMETERS .
REMOVE SHARP EDGES AND BURRS

http://www.facebook.com/afsalabba.in
http://www.youtube.com/c/afsalabbaabba

	TITLE :	
DRAWN BY :	TKMCE	
CHECKED BY :	MATERIAL : STAINLESS STEEL	DRG NO : ME/CIM/CNC/M2
APPROVED BY:	SCALE : 5:1	QTY :

CNC WIRECUT EDM

VARIABLE PARAMETERS IN WIRE EDM

Default values

Allowance	Pulse ON	Puls OFF	GPon	GPoff	IP	Wire	Volt	V-F	Max Speed
0*	35	10	1*	0*	2	2*	Low*	5*	150*

*Values are not intended for editing

Allowable Range that can be varied for the Values

Pulse ON : 30 - 40

Pulse OFF : 6 - 11

IP : 1-4

Procedure for Changing the Values

Click **Create path 2 wire**

Click **To Database**

Edit the Values

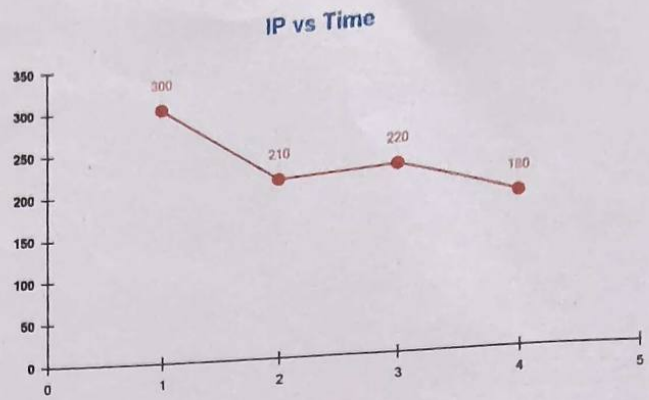
Click **OK**

1. Pulse on, means the pulse on time, the bigger you choose the Pon, the cutting speed will be higher, but the surface finishing will be worse and the wire easy to be broken.
2. Pulse off, means the pulse off time, the bigger you choose the Poff, the cutting speed will be lower, but the surface finishing will be better. And the chips will be easy to remove.
3. Please change Group On is “1”, Group Off is “0”,
4. Current is the IP ,you can choose 1-6, means the Power you choose, the higher you choose,The cutting speed will be faster, but easy to broken the wire and the surface finishing will be worse
5. Wire speed, means the wire winding drum running speed. During putting the wire to the drum, you should choose the lowest speed level “3”. For normal cutting, we always use level “0” the highest speed.
6. Voltage, you can choose low voltage (the max Voltage is around 80V), the higher Voltage is around 100V.
7. VF is the follow speed, which used for adjust the stability of cutting, the smaller you choose,the slower the follow speed. If you choose “0” means without setting follow speed.
8. Max speed, means the max cutting speed. You can choose 0-500. Normally, choose 300. If you cutting higher thickness,should choose bigger value, if you cutting thinner work piece,should choose big value. If you choose “0”, means without setting max cutting speed.

IP vs Time

Pulse ON = 35 **Puls OFF = 5**

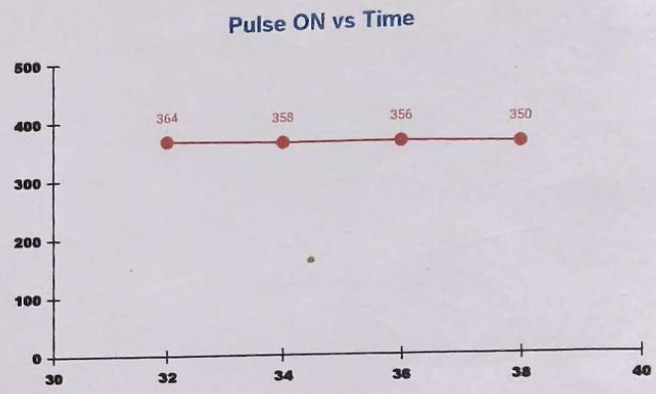
Sl. No	IP	Time
1	1	300
2	2	210
3	3	230
4	4	180



Pulse ON vs Time

IP = 3 **Puls OFF = 5**

Sl. No	Pulse ON	Time
1	32	364
2	34	358
3	36	356
4	38	350



Pulse OFF vs Time

Pulse ON = 35 **IP=3**

Sl. No	Puls OFF	Time
1	6	236
2	8	295
3	10	362
4	12	425

