

CM-500 / CM-800



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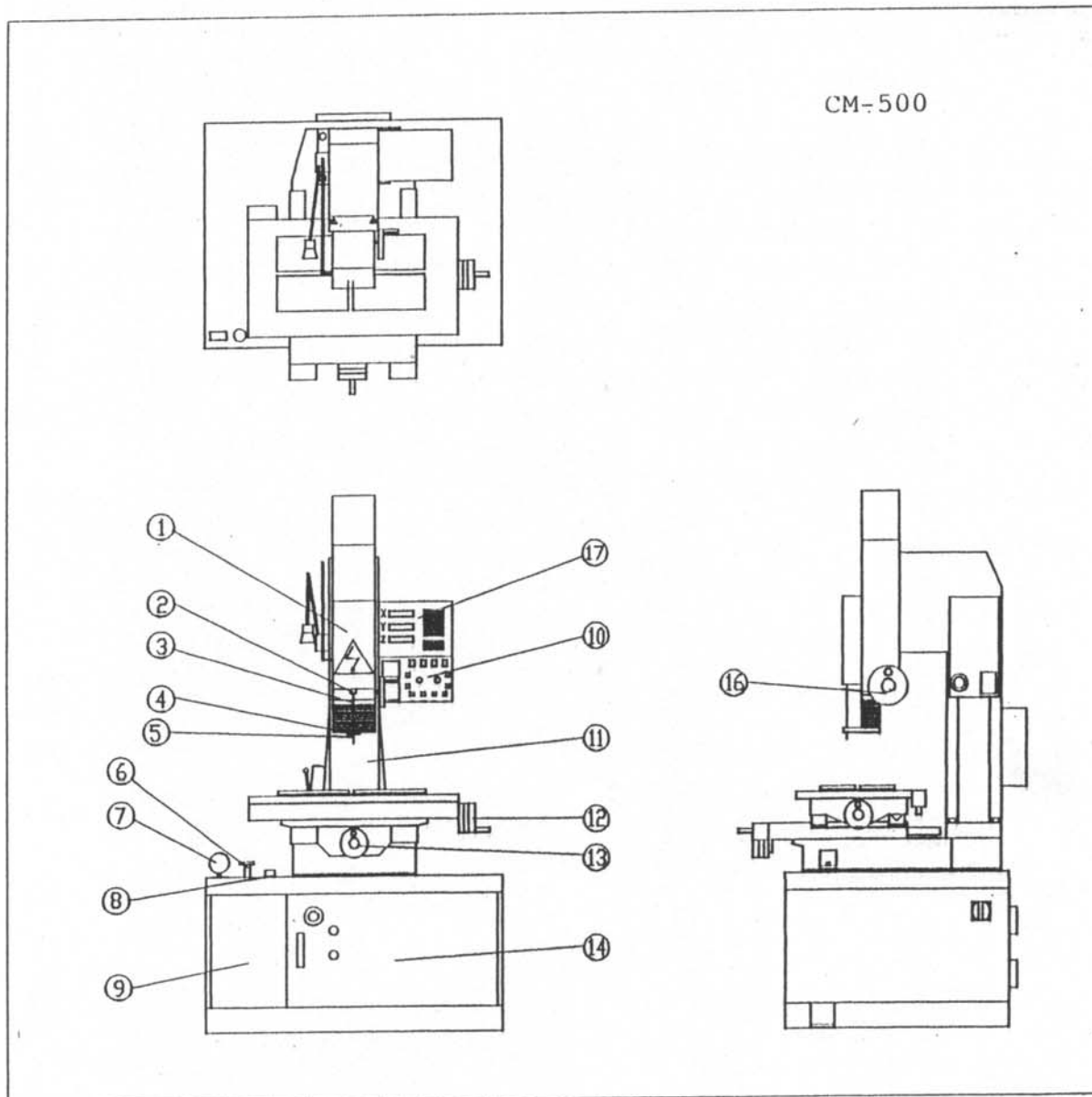
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* NEW TECHNOLOGY TABLE ESTABLISHED BY OCT. '96

4.1 MACHINERY INTRODUCTION

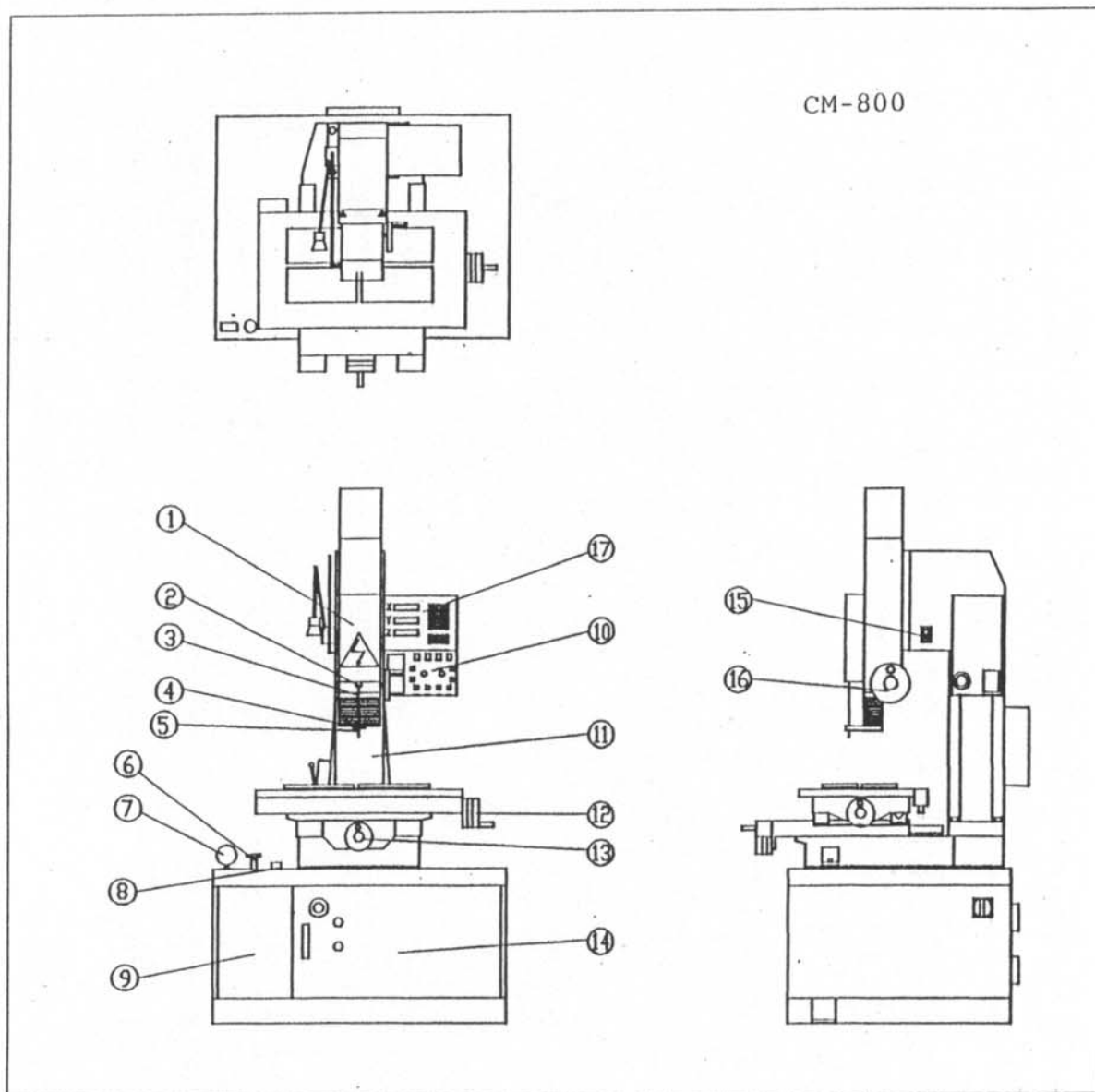
4.1.1 MACHINE ASSEMBLY



- | | |
|------------------------------|---|
| 1. ROTARY AXIS (SPINDLE) | 10. CONTROL PANEL |
| 2. ELECTRODE HOLDER | 11. COLUMN |
| 3. ELECTRODE TUBE | 12. X AXIS HANDLE WHEEL |
| 4. FIX PAD FOR CERAMIC GUIDE | 13. Y AXIS HANDLE WHEEL |
| 5. CERAMIC GUIDE | 14. POWER SUPPLY UNIT |
| 6. SEAL FOR PREVENT LEAKING | 15. W AXIS UP AND DOWN SWITCH (CM-800) |
| 7. PRESSURE METER | 16. HANDWHEEL FOR CERAMIC GUIDE UP AND DOWN |
| 8. PRESSURE CONTROL VALVE | 17. DIGITAL READOUT WITH AUTO DEPTH CONTROL |
| 9. PUMP UNIT | (OPTIONAL ACCESSORIES) |

4.1 MACHINERY INTRODUCTION

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4.1.2 MACHINE SPECIFICATION

DRILLING EDM CM-Series :

Machine Specification :

NO.	PARTS NAME		CM-500	CM-800	Units
1-1	External dimension	width	1,000	1,000	mm
		depth	1,000	1,000	mm
		height	2,100	2,200	mm
1-2	Net weight with CM-Series	weight	500	800	Kg
1-3	Max. workpiece dimension	width	650	650	mm
		depth	300	300	mm
		height	175	300	mm
	Max. workpiece weight	weight	150	200	Kg
1-4	Capacity of dielectric		20	20	ℓ
	Filter (cotton material)		10	10	U
1-5	Worktable size	width	460	460	mm
		depth	210	210	mm
1-6	Worktable travel	X-axis	300	300	mm
		Y-axis	200	200	mm
	Ram servo travel	Z-axis	350	350	mm
	Work head travel	W-axis	-	200	mm
	Spindle rotary speed	C-axis	200	200	RPM
1-7	Electrode pipe		φ 0.3 to φ 3.0		mm
	Electrode pipe length		400	400	mm
	Ceramics guide to work table		50-150	70-240	mm
1-8	Required air pressure		6 - 8	6 - 8	Kg/cm ²
1-9	Required water pressure		20 - 100	20 - 100	Kg/cm ²
1-10	Precision of X,Y,Z axes (VDI-DGQ-3441)				
	Positional variation	Pa			mm
	Mean position spread	Ps			mm
	Mean reversal distance	U			mm
	Resolution				mm

DRILLING EDM CM-Series :

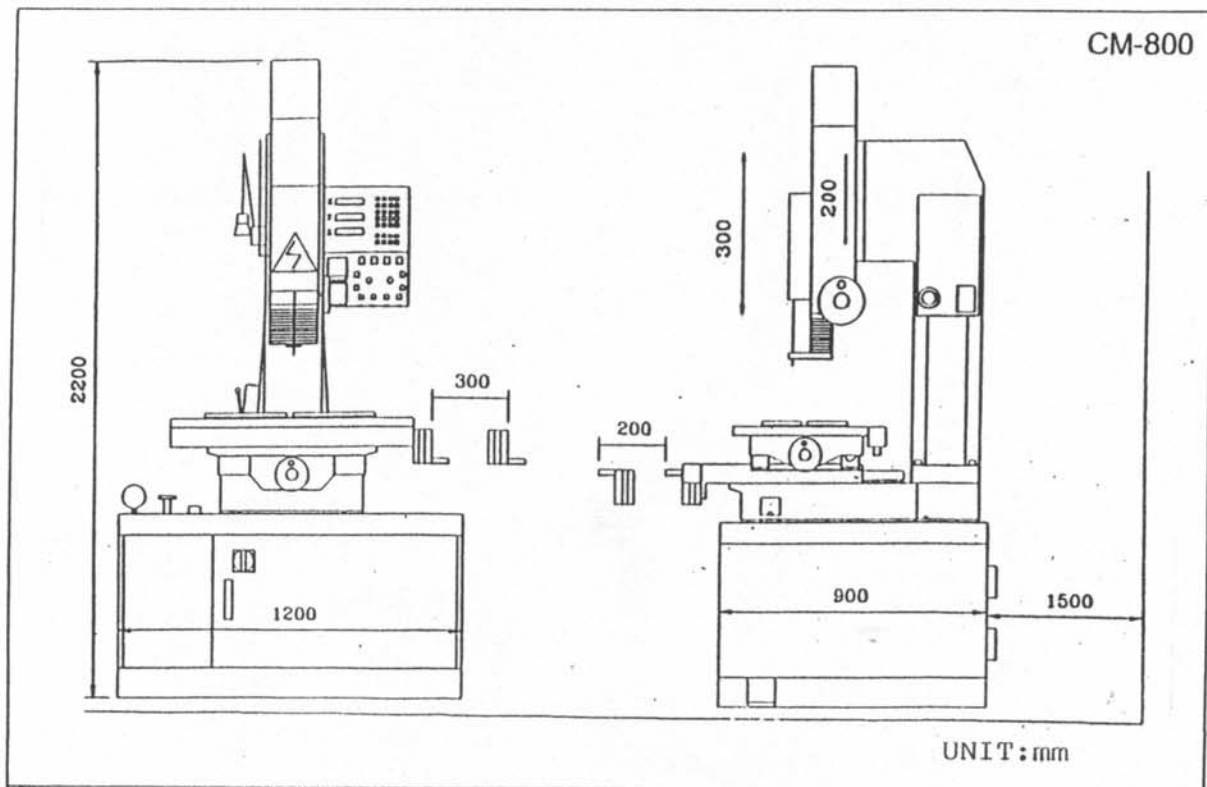
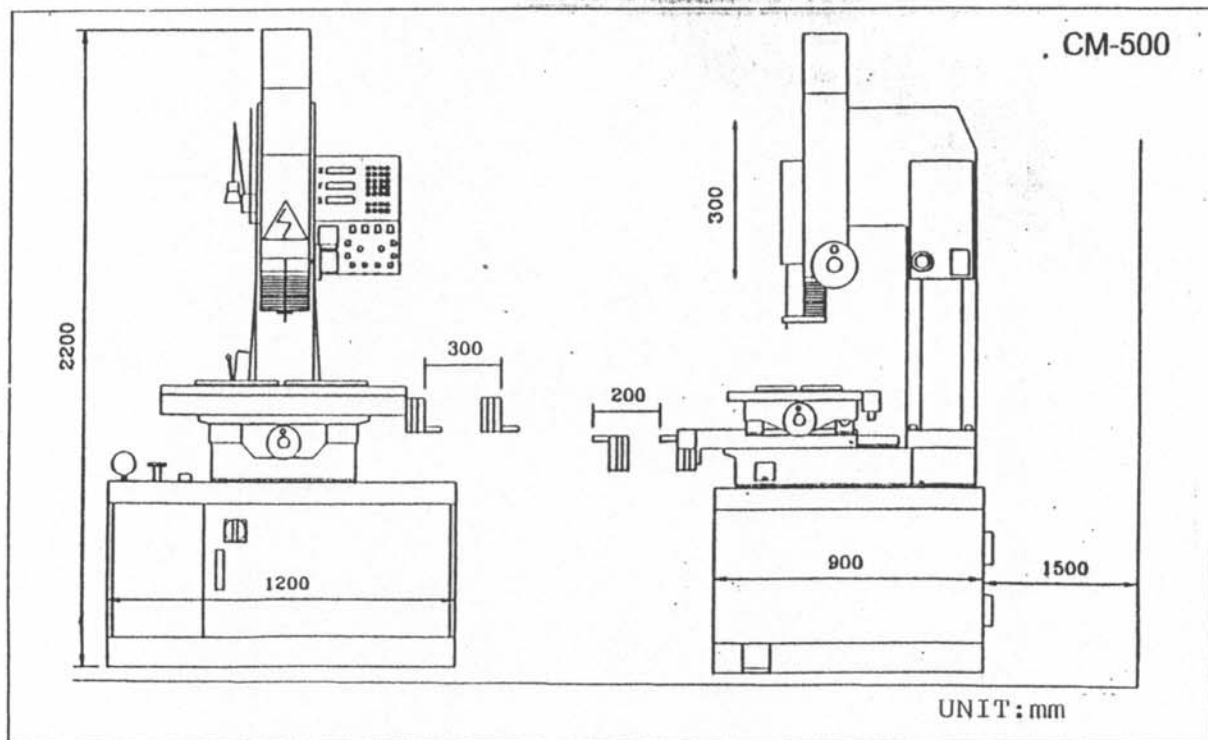
NC Specification :

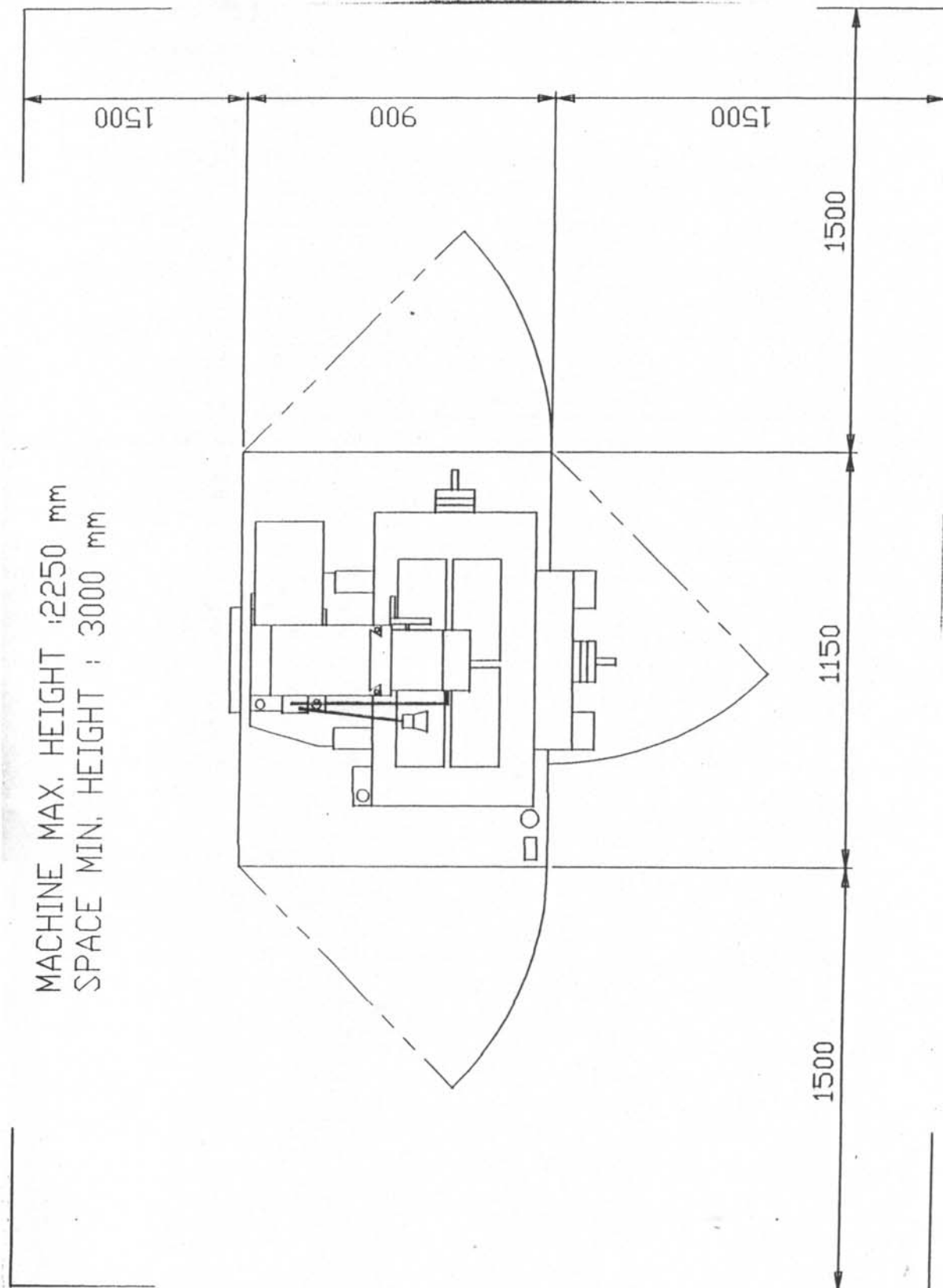
NO.	PARTS NAME	CM-500	CM-800	Units
2-1	CORISMA Controller	-	-	
	Max. power consumption	3.5	3.5	KVA
	Pulse generator	Power Mosfet		
	Current	0 - 15	0 - 15	step
	On time	0 - 99	0 - 99	step
	Off time	0 - 99	0 - 99	step
	Gap	0 - 10	0 - 10	step
	Max. machine current	25	25	Amp.
	Capacitor	0 - 15	0 - 15	step
	Stab	Variable	Variable	
	Power Input (V)	200/220/346/380/420/440/575		

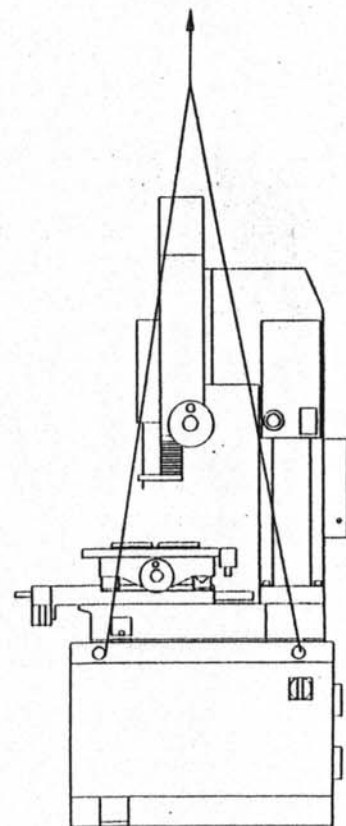
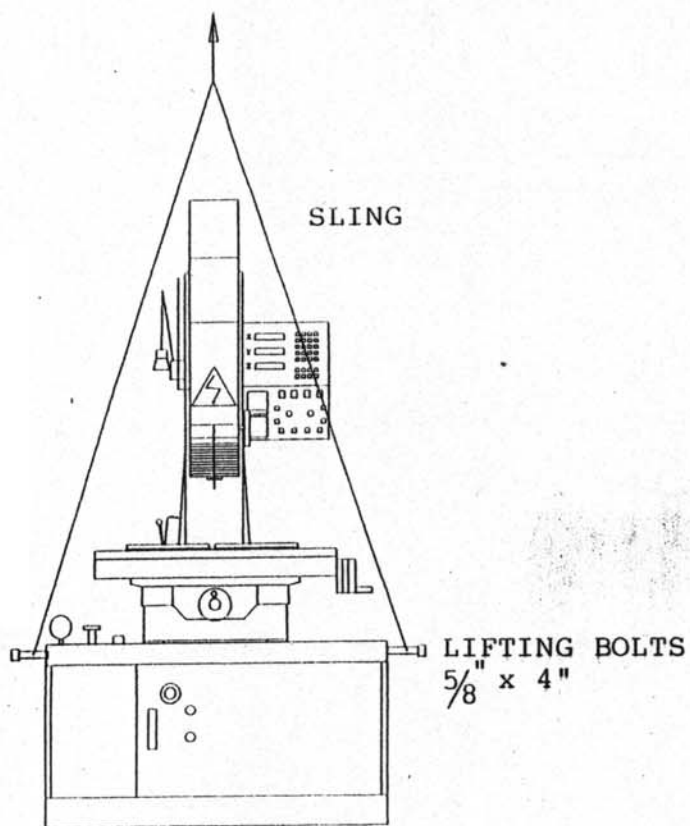
4.2 MACHINERY

4.2.1 MACHINE DIMENSION

CAUTION : The space distance indicated is for good cooling, the space is not smaller than indicated.







4.3 INSTALLATION

4.3.1 INSTALLATION AREA

- A. Stable ground is basic requirement.
- B. Far away from press machine, otherwise shake-proof is necessary.
- C. Far away from dust, do not install together with grinding M/C.
- D. To keep 2.5 M distance at least with neighbor machine.

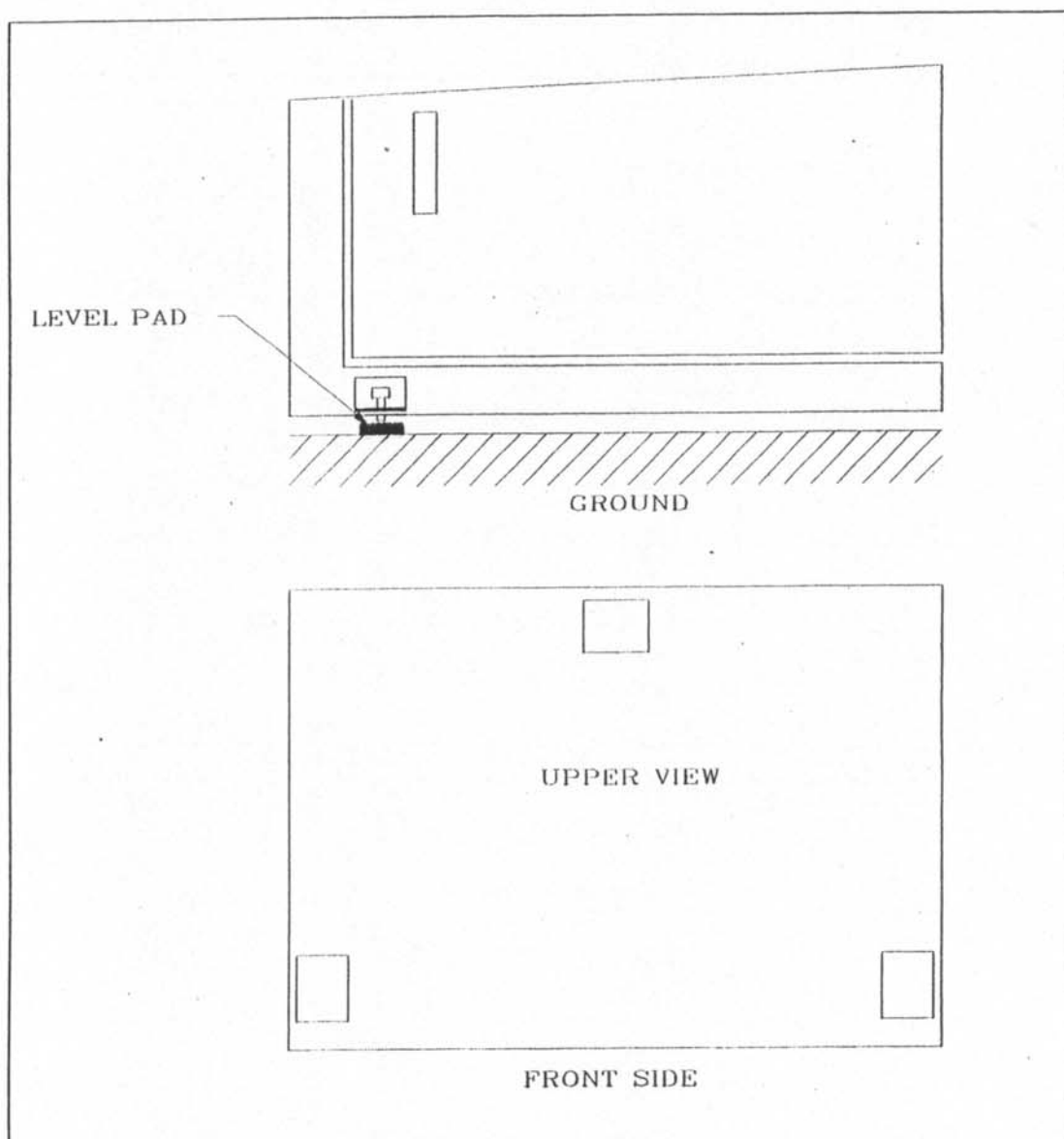
4.3.2 ELECTRIC

- A. Power input specification must be same with machine.
- B. Power input : 200V , 220V , 346V , 380V , 415V , 440V or 575V , 50/60 Hz
3 phase.
- C. Power input cable do not longer 3 M from power supply switch.
- D. Do not use same power switch with the air compressor.

4.3.3 LEVELING CHECK

How to check level.

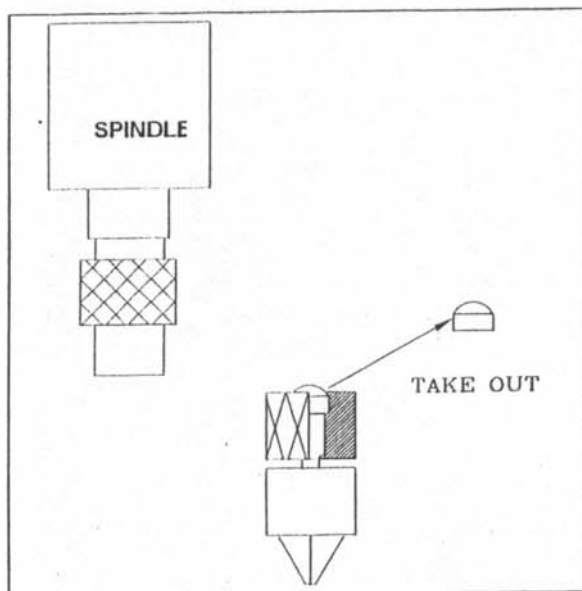
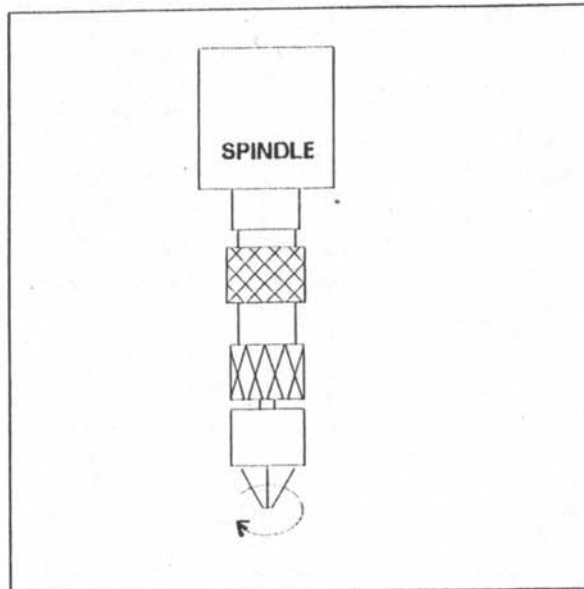
The machine has three pads for level adjusting, left and right two bolts for X axis movement level, the 3rd bolt for Y axis, after adjusting, fix the screw nut and bolt as below :



4.3.3.1 TAKE OFF SEAL PREVENT LEAKING :

There is a rubber inside spindle, it can prevent water out from spindle during transportation.

How to take out seal.



4.3.4 MAIN POWER CABLE CONNECTION

Main power cable is consist of 4 colors' L1. L2. L3. PE wires, green-yellow color wire is connected to ground, the other wire no polarity and phase difference.

Make sure the power input and machine electric is same before wire connection, and protected by an independent no fuse braker (NFB), do not use the same N.F.B. with other machine.

4.4. COORDINATE SYSTEM

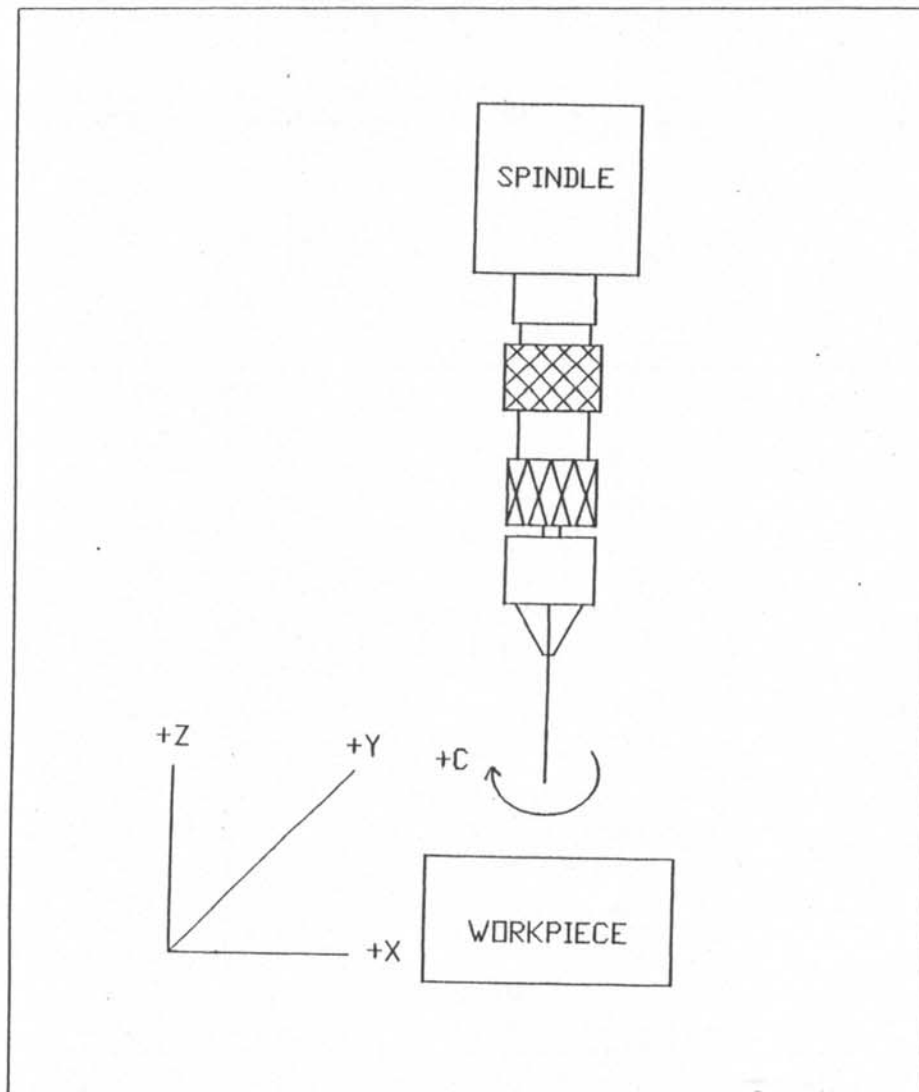
X axis for left and right movement.

Y axis for forward and backward movement.

Z axis for up and down movement.

C axis for spindle rotary.

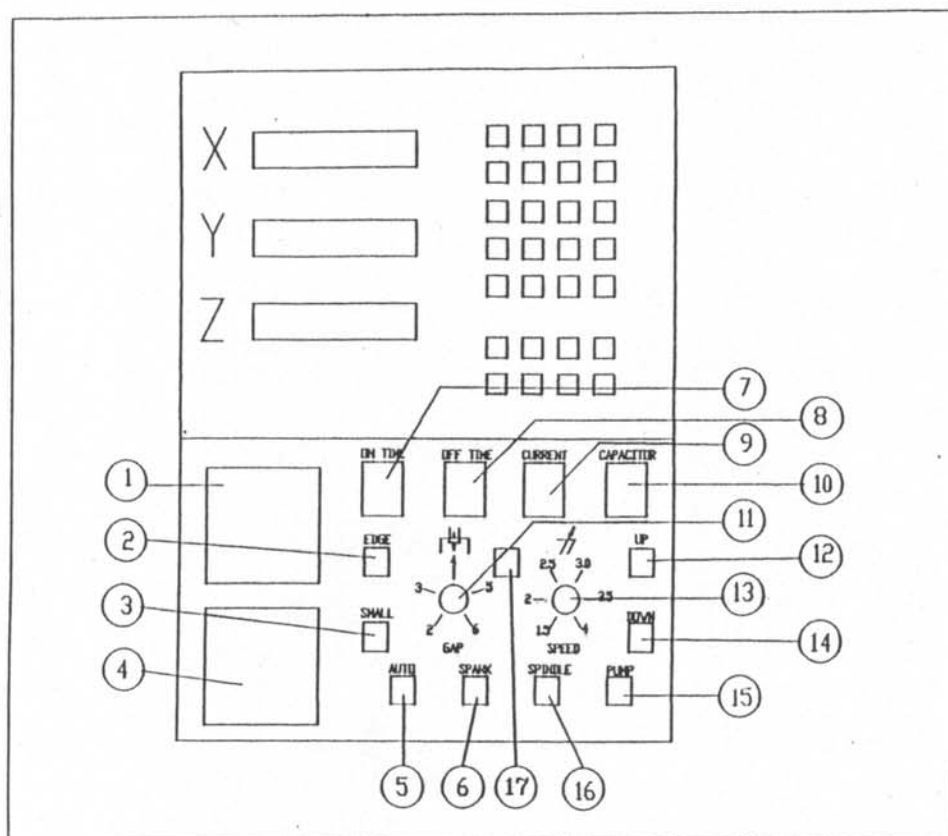
By electrode as the center for +/- movement :



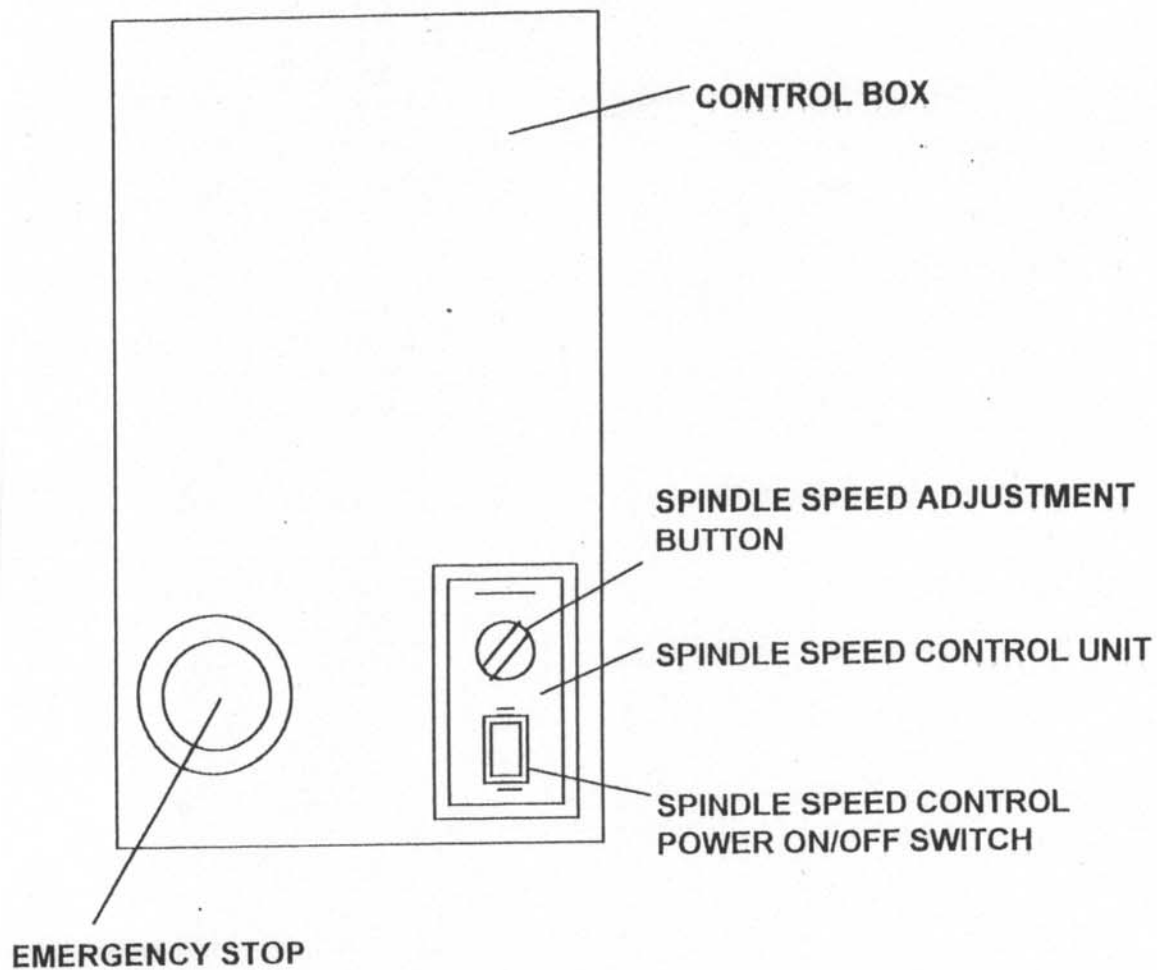
4.5 CONTROL PANEL

4.5.1 CONTROL PANEL

- | | |
|--|---|
| 1. V METER | 10. CAPACITOR |
| 2. EDGE FINDER | 11. GAP (VOLTAGE BETWEEN ELECTRODE AND WORKPIECE) |
| 3. SMALL | 12. UP |
| 4. A METER | 13. SERVO SPEED |
| 5. AUTO (SPARKING, SPINDLE AND PUMP POWER ON SIMULTANEOUSLY) | 14. DOWN |
| 6. SPARKING | 15. PUMP |
| 7. ON TIME | 16. SPINDLE ROTARY |
| 8. OFF TIME | 17. 60A CURRENT SELECT SWITCH |
| 9. CURRENT | |



18. SPINDLE SPEED CONTROL UNIT



4.5.1.1 EXPLAIN OF CONTROL PANEL**1. V METER**

The dial of voltage meter shows the working voltage while machining

2. EDGE (for edge finding)

This button is for EDGE ON/OFF, when you press it, first time is ON, the next time is OFF. When EDGE button is at ON position, AUTO SPARK are all stop function, push spindle down until electrode touch workpiece, the buzzer will be alarm. Use this EDGE FINDER can measure the center line of workpiece with Digital readout system.

3. SMALL (for small diameter electrode machining)

When you press it, first time is ON, the next time is OFF, for the electrode diameter smaller than 0.5mm sparking, use this button for decrease electrode wear, if the electrode diameter bigger than 0.5mm, use this function will slow machining speed.

4. A METER

The dial of ampere meter shows the working while machining.

5. AUTO (sparking, spindle and pump power ON simultaneously)

Press this button for AUTO switch ON, the lamp of button will light, press one more time then switch OFF.

When AUTO switch ON SPARK SPINDLE PUMP will be switch ON same time, however, SPARK SPINDLE PUMP can be switch OFF independent under AUTO at ON position, SPINDLE and PUMP must also at switch ON position.

6. SPARK

This button is for SPARK ON/OFF, when you press down, it is switch ON, one more time it is switch OFF, be sure when the SPARK at ON position, SPINDLE and PUMP must be also at switch ON position.

7. ON TIME

This selector is controlled the pulse width of sparking, the steps are from 00,01,02,-----11, 12,----99, the unit of each step is one microsecond.

The sparking time and surface roughness of hole are depends on ON TIME setting, small ON TIME setting for fine surface machining, but the sparking time is longer.

8. OFF TIME

This selector is controlled the rest width of sparking, the steps are from 00,01,02,---11,12,----99, the unit of each step is one microsecond. OFF TIME adjustment is depends on ON TIME setting, for best sparking condition formula as below: ON TIME/OFF TIME : 3/2

The OFF TIME is setting smaller for faster machining, but it is easy to arcing and damage workpiece because there is no enough rest time of sparking cycle.

9. CURRENT

This selector is controlled the sparking current, steps are from 00,01,02 03--15.amperes range are from 1 ampere to 25 amperes. The adjustment of current is depends on the size of electrode and ON TIME. The influence of CURRENT is including surface roughness of hole, sparking time, and electrode wear.

Current Step	60A Current Select Table	
	Actual Current While Lamp Light (On)	Actual Current While Lamp Distinguished (Off)
1	1.5A	4A
2	3A	8A
3	4.5A	12A
4	6A	16A
5	7.5A	20A
6	9A	24A
7	10.5A	28A
8	12A	32A
9	13.5A	36A
10	15A	40A
11	16.5A	44A
12	18A	48A
13	19.5A	52A
14	21A	56A
15~99	22.5A	60A

※Caution: Do not change 60A current select lamp during sparking, change it when sparking stop.

10. CAPACITOR

This selector is controlled internal capacitors, the steps are from 00,01,02,03,---15, the microfarad range is from 0 to 3.7. The adjustment of CAPACITOR is depends on material of workpiece. For tungsten steel, SKD-11 steel.....etc, the hardened material machining to use enough CAPACITOR for faster machining. Best machining condition s good setting at CAPACITOR, CURRENT, ON TIME and OFF TIME, please refer to the machining setting parameter to gain the ideal setting.

11. GAP(voltage between electrode and workpiece)

To adjust the voltage of sparking, normally, setting is at 3-7 and V-meter is approximate 25V-35V. During the sparking, if the Z axis can not be slowly down, this GAP maybe set too high, so we decease the GAP voltage until electrode can machine the hole and be slowly down. Deceasing voltage too smaller the working current will be high for sparking efficiency, but the electrode and workpiece will be frequently short and bending electrode, for this reason, please increase the voltage of sparking.

12. UP

Press this button for electrode chuck up moving, the speed of movement can be adjusted by SERVO SPEED switch.

13. SERVO SPEED

The speed of SPARK, EDGE, UP and DOWN function to be controlled by this SERVO SPEED switch, normally, the SERVO SPEED setting is at 2.5 - 3.0 position, faster speed for quick machining, but the high electrode wear, and the bad stability of servo moving.

14. DOWN

Press this button for electrode chuck down moving, the speed of movement can be adjusted by SERVO SPEED switch.

15. PUMP

This button is for PUMP ON/OFF, when you press down, it is switch ON, one more time it is switch OFF. During the SPARKING ON, PUMP must be also at ON position, because the PUMP will generate the high pressure water to flush out the carbon chip in small hole. Check the gate of pressure whether at ON position, indicate by the meter of pressure.

16. SPINDLE ROTARY

This button is for SPINDLE ON/OFF, when you press it, first time is ON, the next time is OFF. During sparking on, the SPINDLE must be also at ON position.

17. 60A CURRENT SELECT SWITCH

Please refer to 60A current select table, only 60A type has this switch.

18. SPINDLE SPEED CONTROL UNIT

This is a control unit for c axis spindle speed adjustment, when you switch on spindle before must to power on it.

<i>spindle speed control unit each speed data</i>				
<i>speed rotary button/section</i>	<i>pressure 0kg/rpm</i>	<i>pressure 50kg/rpm</i>	<i>pressure 75kg/rpm</i>	<i>pressure 100kg/rpm</i>
0	0	0	0	0
1	0	0	0	0
2	5	4	4	3
3	32	31	31	30
4	65	64	64	63
5	95	94	93	92
6	120	119	118	117
7	158	157	156	155
8	185	183	182	180
9	188	186	185	183
10	189	187	186	184

4.5.1.2 MACHINING TECHNOLOGY DATA REFERENCE

Best setting : 1. speed fast

2. servo speed stable

3. electrode low wear

Methods :

1. GAP : 20 - 40V during machining (adjust GAP for 15 - 30V electrode stable without vibration, if unstable)

2. SERVO SPEED : 2.5 - 3.0

If the machining and electrode rotation is not stable, please adjust servo speed to best condition until electrode stable.

3. ON TIME :

55 - 75 steps are for bigger dia. electrode

10 - 25 steps are for smaller dia. electrode

4. OFF TIME :

25 - 35 steps are for bigger dia. electrode

10 - 25 steps are for smaller dia. electrode

5. CURRENT :

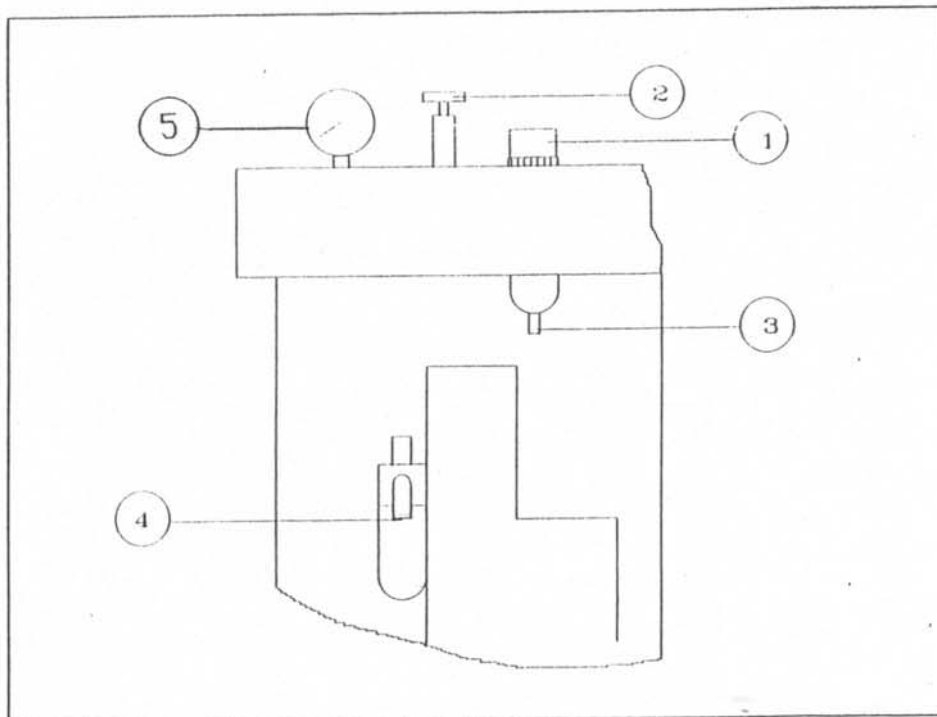
10 - 15 steps are for electrode ϕ 1.0 - ϕ 3.0 dia.

5 - 13 steps are for electrode ϕ 0.7 - ϕ 1.0 dia.

1 - 8 steps are for electrode ϕ 0.3 - ϕ 0.7 dia.

4.5.1.3 HOW TO CONTROL WATER PRESSURE

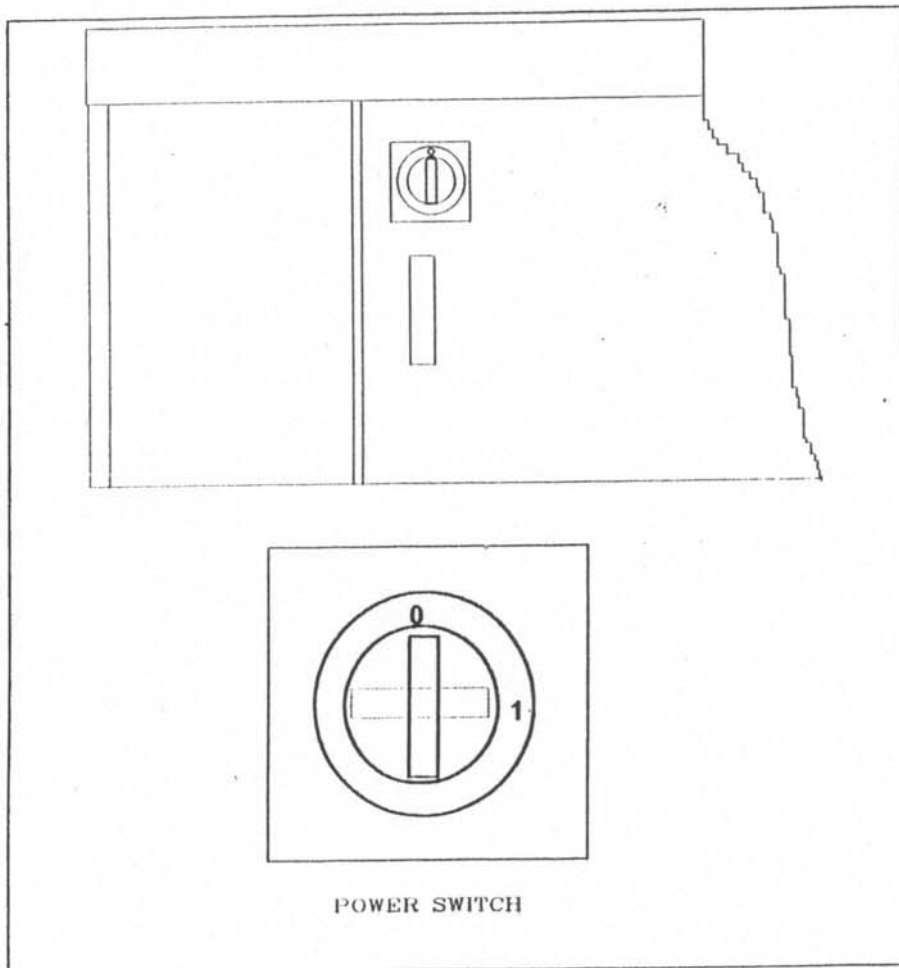
1. Pull up value 1 and rotate in anticlockwise is for decrease water pressure, clockwise is for increase water pressure for machining in good condition
2. To release air pressure value 2, when clockwise rotation is for keep water working pressure, anticlockwise rotation is for release water pressure and for stop machining.
3. The above operation please read from water pressure gage (5) and control both value to meet our requirement.
4. Maintenance: If there is some water keep in value glass cup, please press button 3 for drain out water, if there is not enough lubrication oil to keep in oil cup, please control rotation button 4 for input oil.



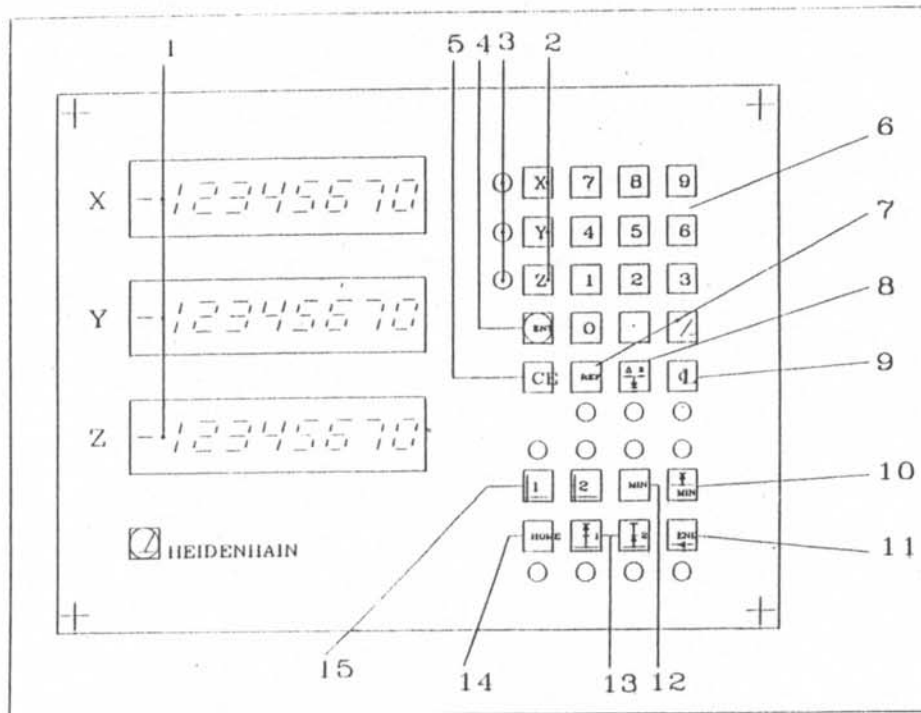
4.5.2 OTHER SWITCH

This switch is a safety switch, before open the door of control box, must be off this switch, this switch is for :

1. POWER ON
2. POWER OFF
3. OPEN CONTROL PANEL
4. LOCK POSITION IS NORMAL
5. CONTROL BOX can not be opened when this switch without power off, but the power is strong and dangerous, do not operate without good technology electric technician.



4.5.3 670E CONTROLLER PANEL

**670E NC CONTROLLER OPERATION:**

1. ACTUAL POSITION INPUT DISPLAY
2. ☐ X ☐ Y ☐ Z AXIS SELECTION.
3. X,Y,Z AXIS INDICATE LED
4. ENTER KEY, AFTER KEY IN PARAMETER, PRESS THIS KEY TO CONFIRM KEY IN
5. CE KEY, CLEAR ENTRY ADDRESS PARAMETER.
6. NUMERAL INPUT.
7. REFERENCE POINT SELECTION.
8. ADDING KEY FOR EROSION DEPTH (ELECTRODE WEAR COMPENSATION),
SUGGEST THIS COMPENSATION SET AT MACHINING DEPTH ,
DO NOT USE THIS KEY FOR SETTING.
9. CENTER LINE KEY.
10. NO FUNCTION.
11. DEPTH SETTING KEY.
12. SWITCHING FROM ACTUAL POSITION DISPLAY TO MIN POSITION DISPLAY.
13. NO FUNCTION.
14. NO FUNCTION.
15. DATUM POINTS.

1. POWER ON

START THE POWER, THE DISPLAY WILL FLASHING THAT IS MEANING THE POWER HAS STOP DURING MACHINING, PRESS **REF** KEY ONE TIME, DISPLAY WILL STOP FLASHING, ONLY DECIMAL POINT FLASHING.

MOVE THREE AXIS, TILL EACH AXIS DISPLAY START COUNTER, THEN SET ONE MACHINING REFERENCE POINT, AND RESET ZERO, SO, WHEN POWER STOP DURING SPARKING, ACCORDING TO ABOVE METHOD, MOVE 3 AXIS TO ZERO POSITION, IS THE REFERENCE POINT.

IF REFERENCE POINT IS NOT NECESSARY, PRESS **REF** TWO TIMES, THE LED LIGHT AND OFF, THE 3 AXIS WILL NOT FLASHING AND START TO COUNTER, BUT, THIS METHOD, CAN NOT FIND THE 1ST ONE MEMORY IF POWER STOP DURING MACHINING.

2. MACHINING POSITION SETTING

USE ONE PARAMETER FOR MACHINING TWO DIFFERENT POSITION, USE **Φ1** AND **Φ2** TO SET TWO DIFFERENCE POSITION, **Φ1** FOR 1ST MACHINING POSITION RESET ZERO. **Φ2** FOR 2ND MACHINING POSITION RESET ZERO, WHEN MACHINING FINISHED AT **Φ2**, CHOICE **Φ1** TO MOVE 3 AXIS TILL 0 POSITION, THEN MACHINING FIRST POINT.

3. MIN Z AXIS POSITION DISPLAY

DURING MACHINING, THE Z AXIS IS CHANGE QUICKLY, IT IS DIFFICULT TO SEE THE DEPTH, PRESS **MIN** KEY ONE TIME, CAN GET HOW DEPTH SET AND HOW DEPTH HAS ALREADY MACHINING, PRESS ONE MORE TIME TO DISPLAY 3 AXIS.

4. DEPTH SETTING

WHEN MACHINING NON-THROUGH-HOLE MOULD, SET THE MACHINING DEPTH AT . (MUST ADD ELECTRODE WEAR), THE METHOD:

PRESS ONE TIME, THE LED WILL LIGHT, Y AXIS WILL DISPLAY FIGURE, THE FIGURE IS DEPTH VALUE, IF WE NEED DEPTH 20MM, PRESS , AND KEY → .

TO CHECK WHETHER THE DEPTH IS CORRECT, PRESS AGAIN ONE TIME THE LED WILL LIGHT, CHECK WHETHER DISPLAY - 20, IF YES, PRESS TO CONFIRM, IF NOT CORRECT, KEY IN AGAIN THE CORRECT WAY. FOR THE THROUGH-HOLE MOULD, SET THE DEPTH BIGGER THAN WORKPIECE THICKNESS.

5. KEY EDGE FINDER FUNCTION

- (1) MOVE ELECTRODE TUBE TO TOUCH WORKPIECE (BIG DIAMETER ELECTRODE TUBE IS BETTER). PRESS EDGE SWITCH ONE TIME, ITS' LED WILL LIGHT, PRESS SPINDLE ONE TIME TO ROTARY THE SPINDLE.
- (2) PRESS ONE TIME, IT'S LED WILL LIGHT, PRESS KEY FOR Y AXIS EDGE FINDER.
- (3) PRESS ONE TIME, IT'S LED WILL LIGHT, MOVE X AXIS, TO MAKE ELECTRODE TUBE TOUCH WORKPIECE, THE BUZZER WILL ALARM.
- (4) PRESS KEY ONE TIME, KEY'S LED WILL LIGHT, MOVE X AXIS, THE ELECTRODE TUBE TOUCH ANOTHER SIDE OF WORKPIECE, THE BUZZER WILL ALARM.
- (5) PRESS KEY, ONE TIME, MOVE X AXIS, WHEN X DISPLAY 0 THAT IS THE X AXIS CENTER POINT.

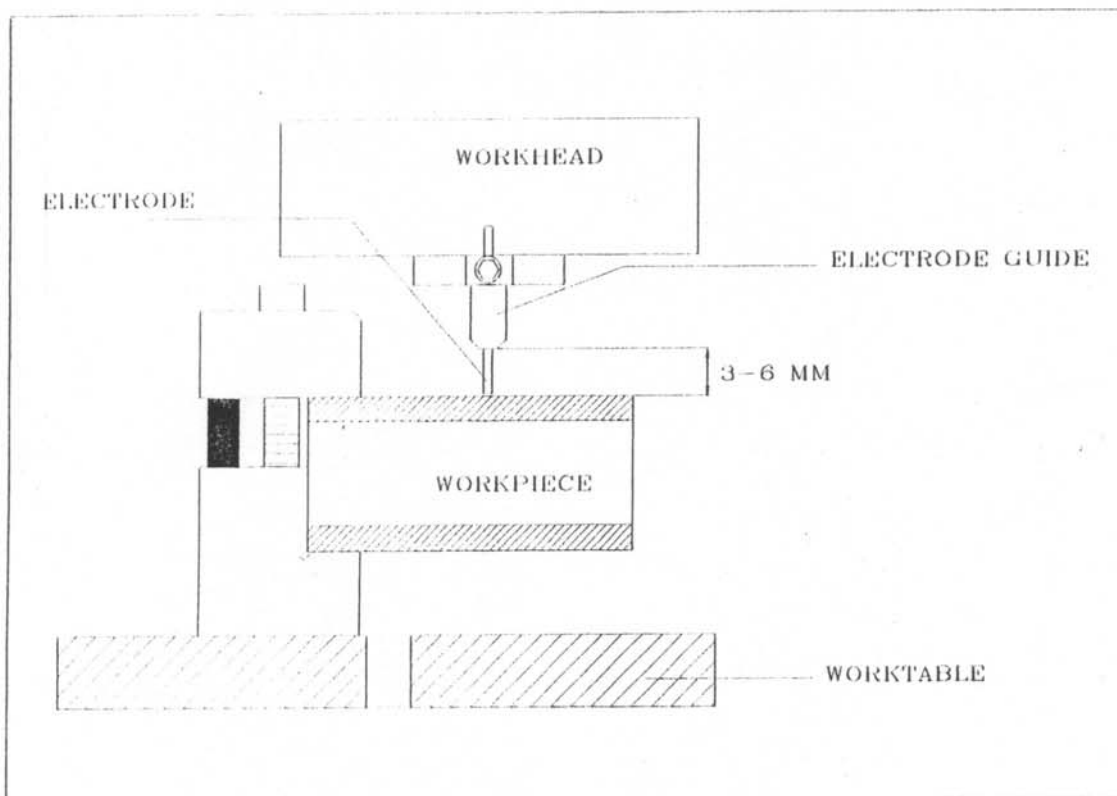
※ Y AXIS IS THE SAME WAY WITH X AXIS.

4.6 HOW TO OPERATION

4.6.1 QUALITY CHECK

Enclosed with machine operation manual is quality check report, make sure before operation whether machine quality is as good as report, and check the following before test M/C.

- A. 20L distilled water, pure degree between 50 $\mu\text{s}/\text{cm}$ and 100 $\mu\text{s}/\text{cm}$.
- B. Install workpiece as below :
- C. Install electrode please refer to page E-11.
- D. Machining condition setting : refer to machining data, after machining and test, any difference between manual machining data and actual test, please record and comparison.

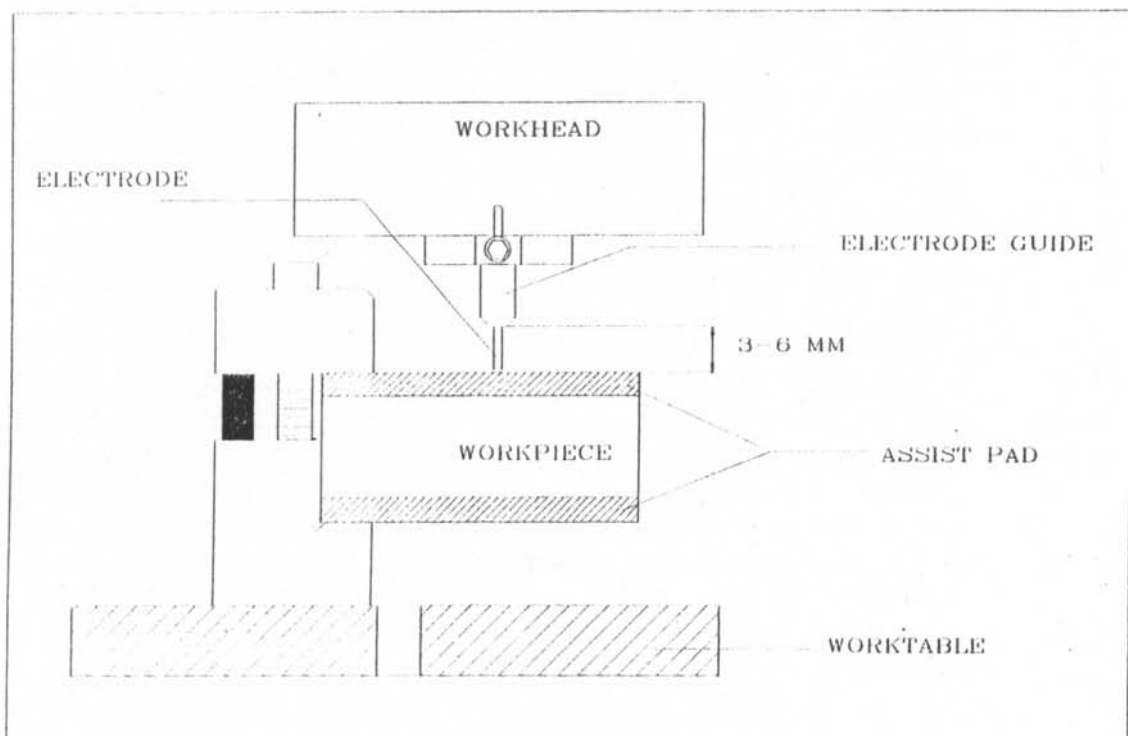


***** CAUTION :

- A. Do not set the servo speed too fast, servo speed will affect machining speed and electrode wear, fast servo speed, with fast machining speed, but more electrode wear.

Attention : The smaller diameter electrode tube is easy bending and not to work.

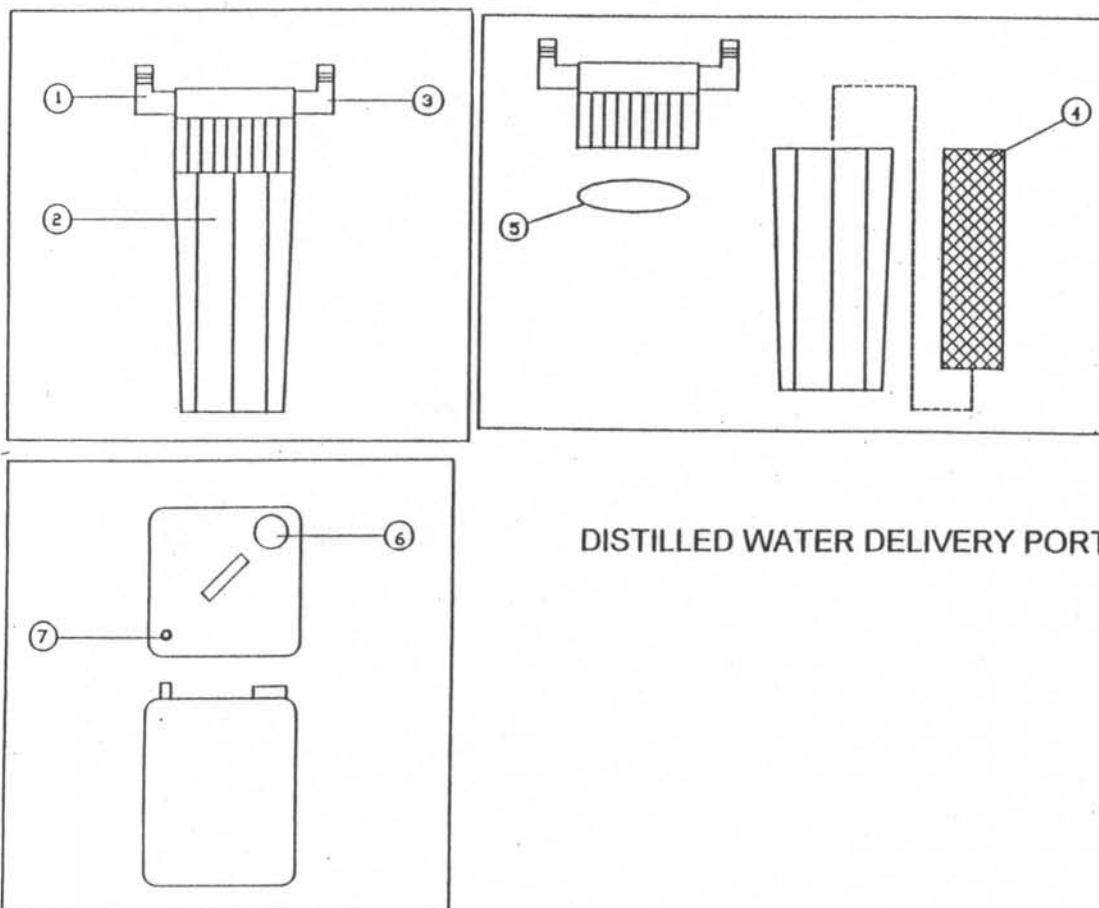
- B. Be sure the water is come out from electrode end and pressure is enough.
- C. In order to enhance the machining quality put two plate at workpiece



4.6.2 FILTER SYSTEM

According to the below steps to install filter.

1. WATER INLET
2. FILTER CAP
3. WATER OUTLET
4. FILTER
5. RUBBER SEAL
6. WORK TABLE RETURN (DISTILLED WATER DELIVERY PORT)
7. PUMP RELIEF RETURN

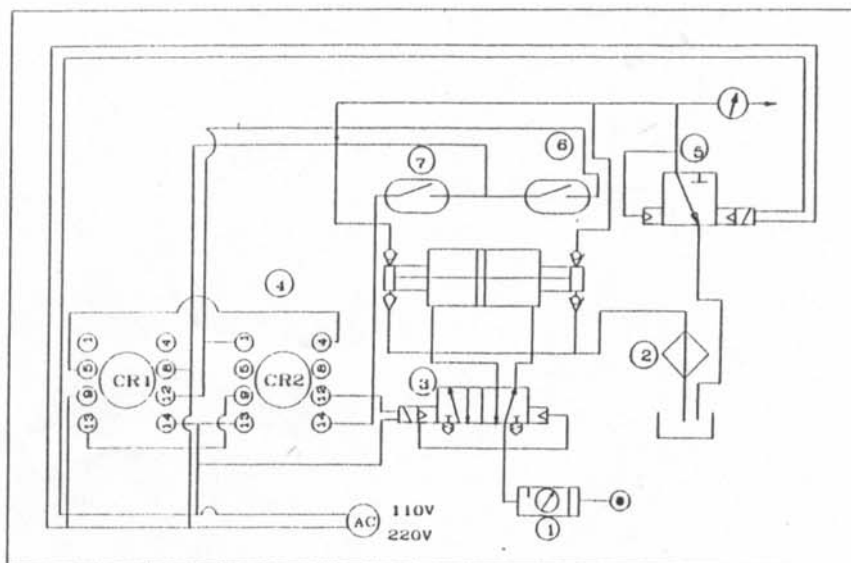


DISTILLED WATER DELIVERY PORT

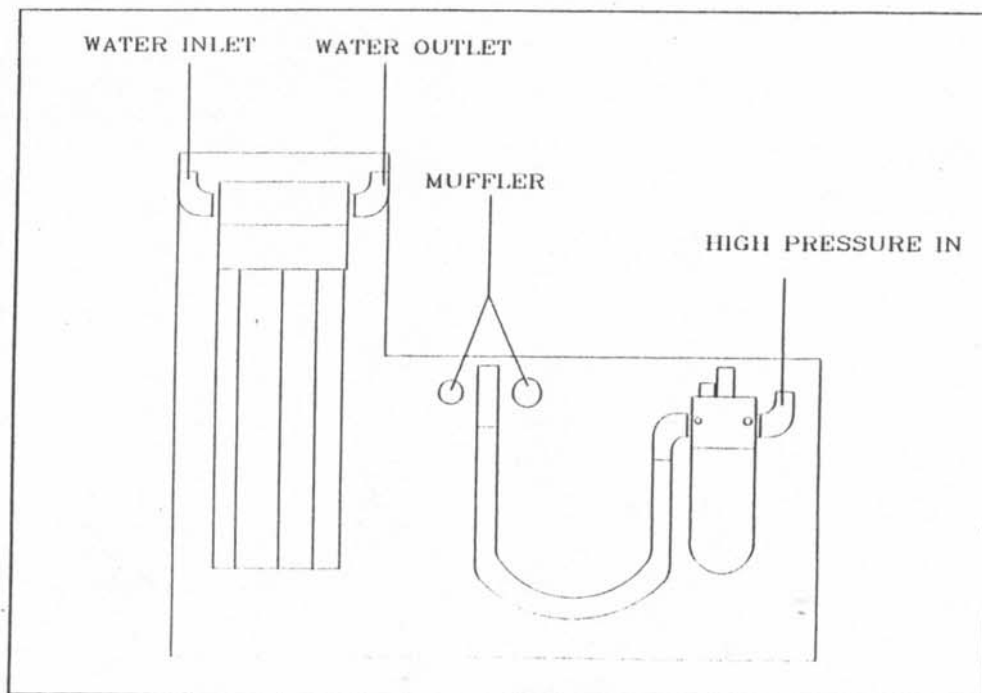
4.6.2.1 VALVE FOR ADJUSTING WATER PRESSURE

A. PUMP SYSTEM CHART :

- | | |
|------------------------------|-------------------|
| 1. PNEUMATIC UNIT | 5. MAGNETIC VALVE |
| 2. FILTER CAP | 6. LIMIT SWITCH |
| 3. DIRECTIONAL CONTROL VALVE | 7. LIMIT SWITCH |
| 4. RELAY | |

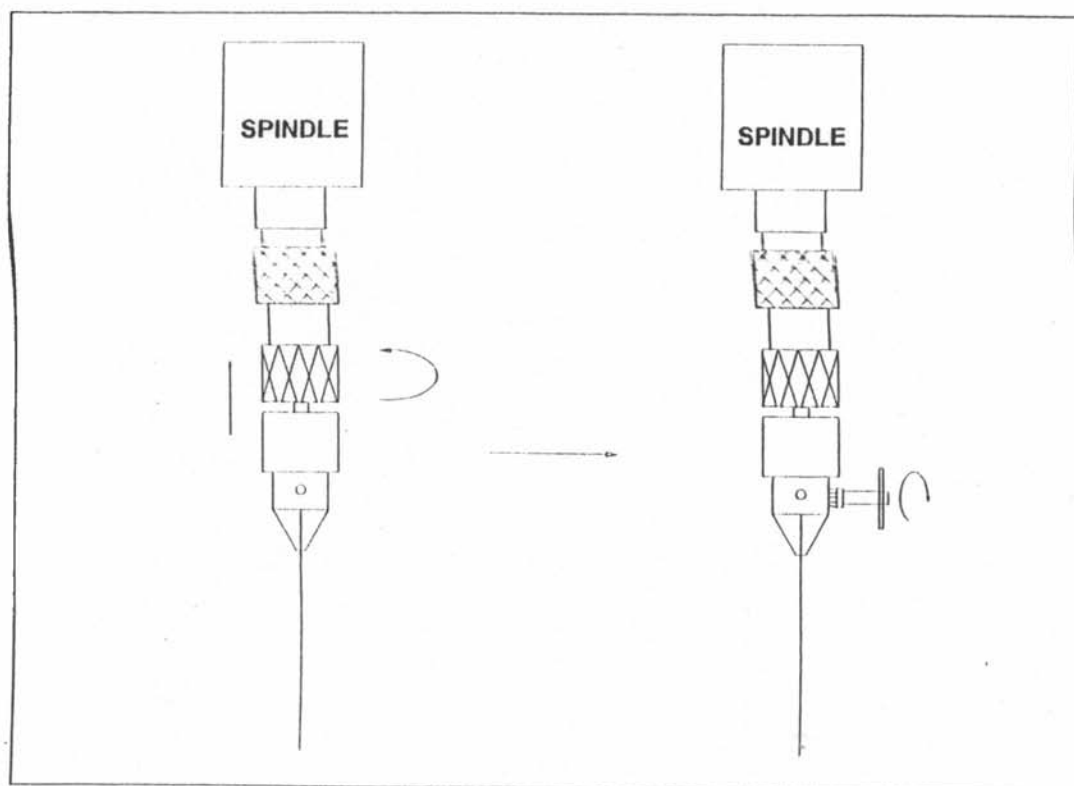
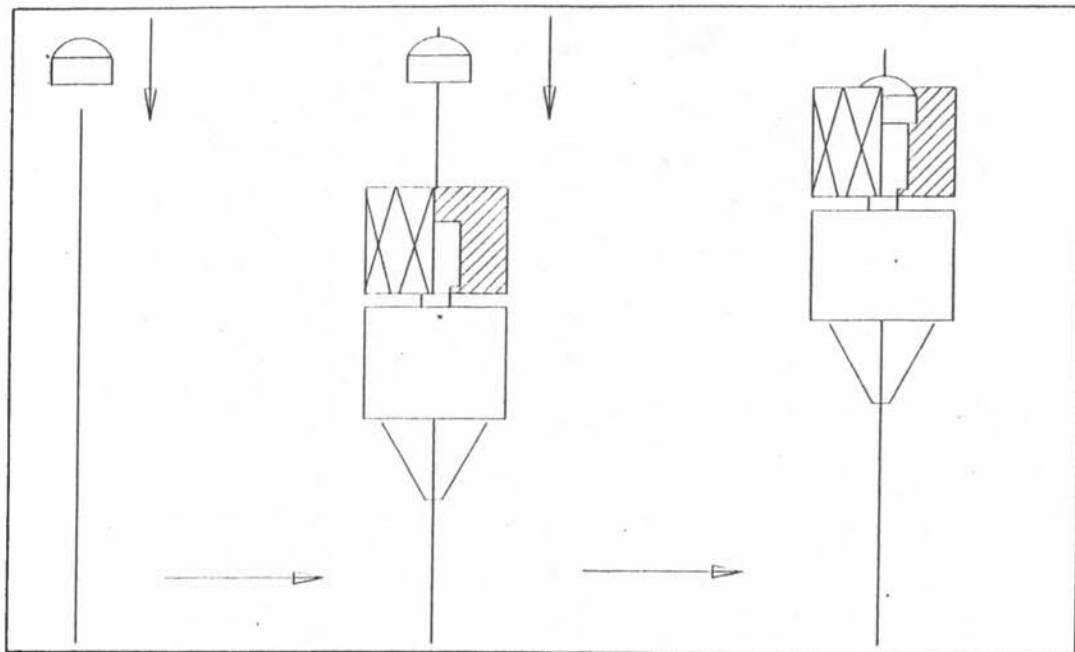


B. FILTER SYSTEM CHART :

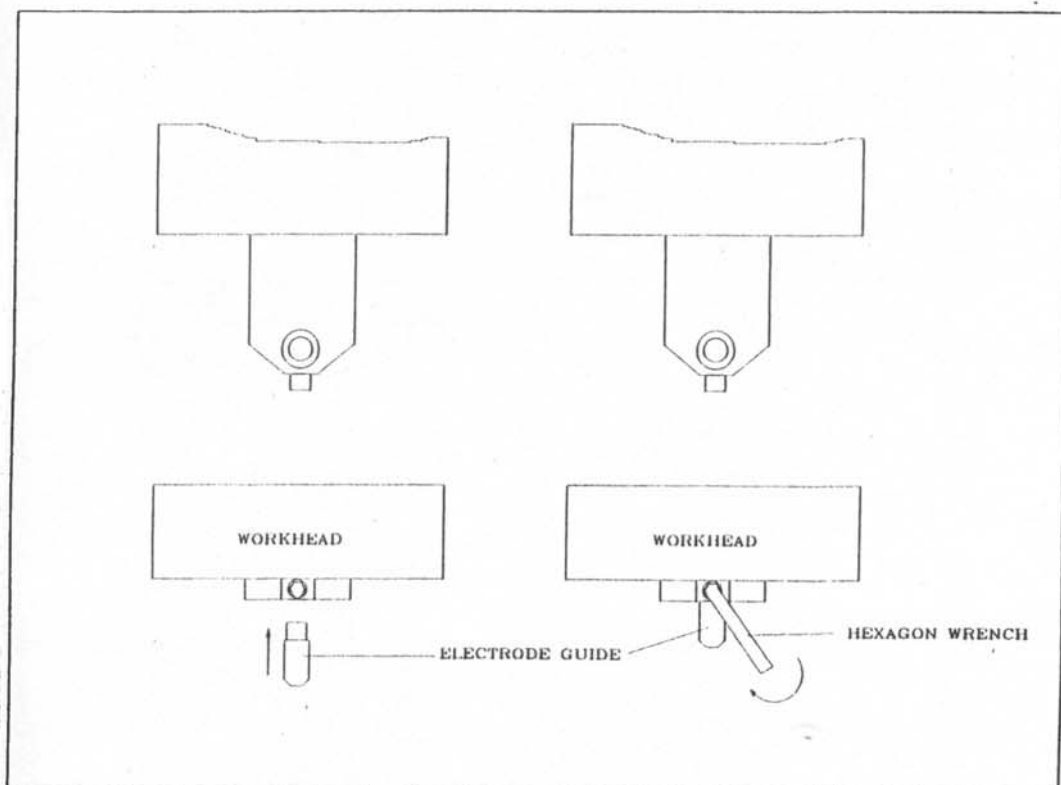
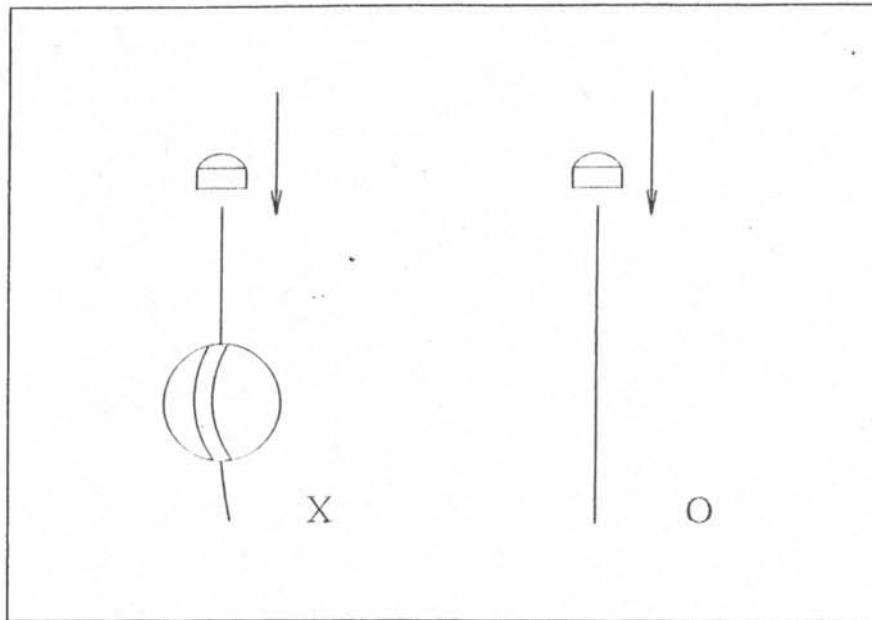


4.6.3 ELECTRODE INSTALLATION :

Please be according to the below drawing :

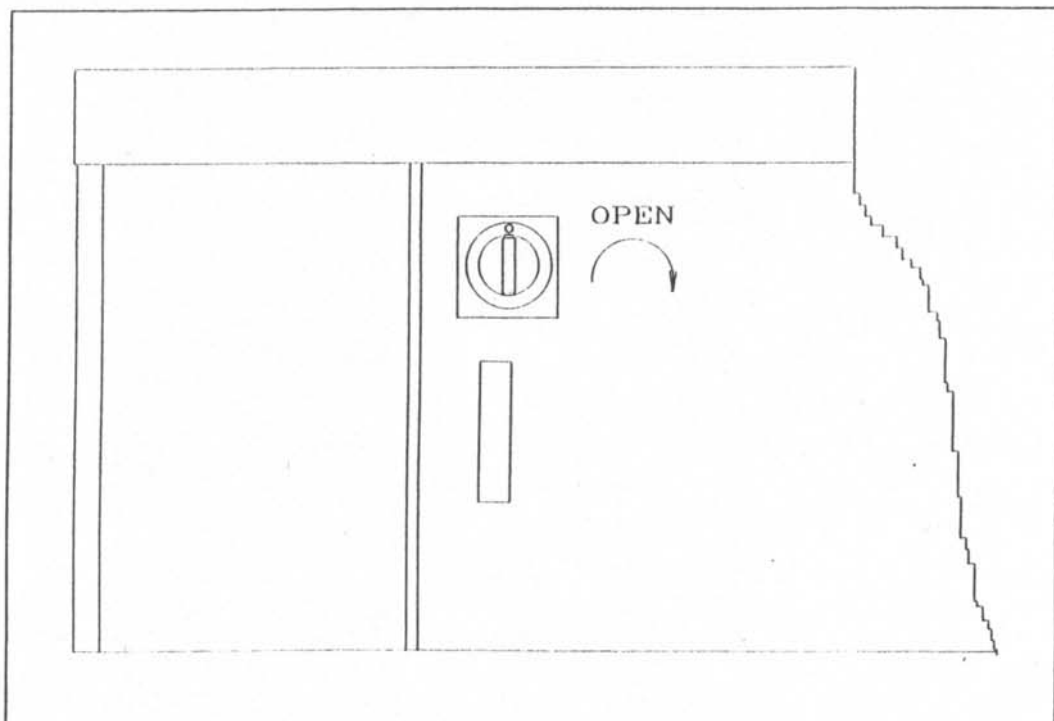


*** CAUTION: Be careful to install electrode pipe to avoid electrode pipe bending, and down the machining speed, install well according to the below chart:



4.6.4 MACHINING PREPARE

1. Switch on main power.
2. Set up workpiece at good position.
3. Up Z axis to top position.
4. Install electrode pipe.
5. Install ceramic guide.
6. Move work head or ceramic guide to keep good distance with workpiece
7. Spindle rotary.
8. Down Z axis thru ceramic guide with slow servo speed to avoid electrode pipe bending.
9. Switch on pump and be sure water to come out from electrode pipe end side with enough pressure, otherwise the electrode pipe maybe burn during machining.
10. Switch on the auto power.
11. You did.

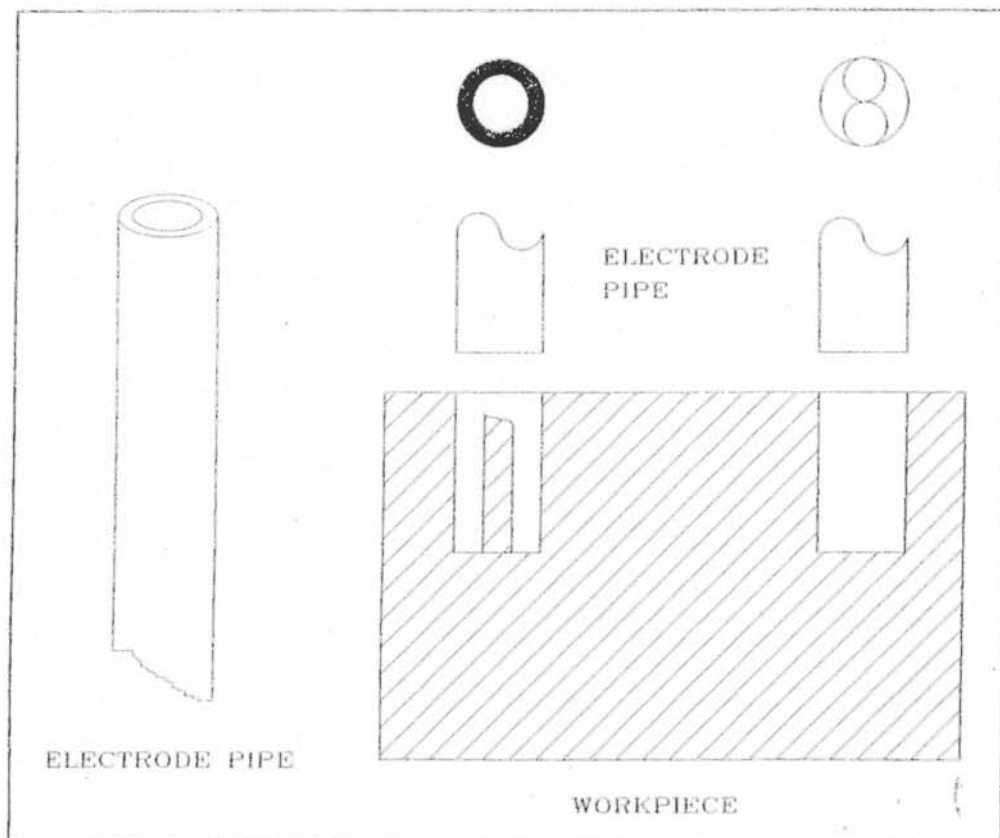


4.6.5 HOW TO MACHINING

1. Move the worktable to working position.
2. Down Z axis with slow speed.
3. Put water cover at ceramic to avoid water spray out.
4. Set machining data.
5. Switch AUTO power on.

4.6.6 CAUTION BEFORE OPERATION MACHINE

1. Whether distilled water is enough and water quality is available.
2. Whether filter continue to be use.
3. Avoid water freeze in cold area.
4. According to below chart to select good electrode pipe.
5. Avoid electrode pipe bending when installation.
6. Be sure workpiece and table touch and fixed well.
7. Do not set too fast servo speed on small diameter electrode pipe.
8. Be sure water is come out from electrode pipe end side.
9. Whether machining data setting is correct.
10. Use "8 shape" electrode pipe to get good machining quality when deep hole machining.



4.6.7 TROUBLE SHOOTING

A. Machining unstability please check the following steps.

1. Machining conditions are suitable or not ?
2. Water fluid is enough or not ?
3. Servo speed is suitable or not ?
4. Workpiece is fixed well or not ?
5. Electrode and ceramic guide size are same or not ?
6. The quality of water fluid is suitable or not ?

B. Electrode bending during machining (generally occur on small diameter electrode) :

1. Whether the workpiece and worktable are fixed well ?
2. Whether the machining data is setting good ?
3. Whether the electrode pipe size is correct and straight, check correct outside and inside diameter according to PAGE E-24.
4. Whether the ceramic guide inside dirty, wash it by cleaning solution.

C. Electrode pipe burn (also occur on small diameter electrode pipe) :

1. Machining conditions are suitable or not ?
2. Whether dielectric come out from electrode pipe end side and pressure is enough ?

D. Z axis jump during machining :

1. Whether the machining data setting is good ?
2. Chip from single hole electrode pipe machining can not flush out ?
3. The electrode pipe is not straight.
4. The center of ceramic guide and worktable perpendicular uncorrect.

E. Abnormal electrode consumption :

1. Whether the machining conditions are suitable or not ?
2. Whether poor water quality ?
3. The electrode and ceramic guide size are different ?
4. The distilled water is not enough ?
5. The material of electrode is wrong ?
6. Whether the electrode is bending ?

F. Machining hole on down side big than upper side starting hole :

1. The electrode is bending.
2. The ceramic guide is fixed uncorrect or workpiece moved.

G. Machining hole big taper degree :

1. Conductivity of dielectric distilled water too high.
2. The material of electrode is wrong.

4.7 MAINTENANCE**4.7.1 LEVEL CHECK**

After installation, check level on 1st, 3rd, 6th month.

4.7.2 DAILY MAINTENANCE

Clean clamping tooling and table, covered by oil avoid rust because the dielectric is water.

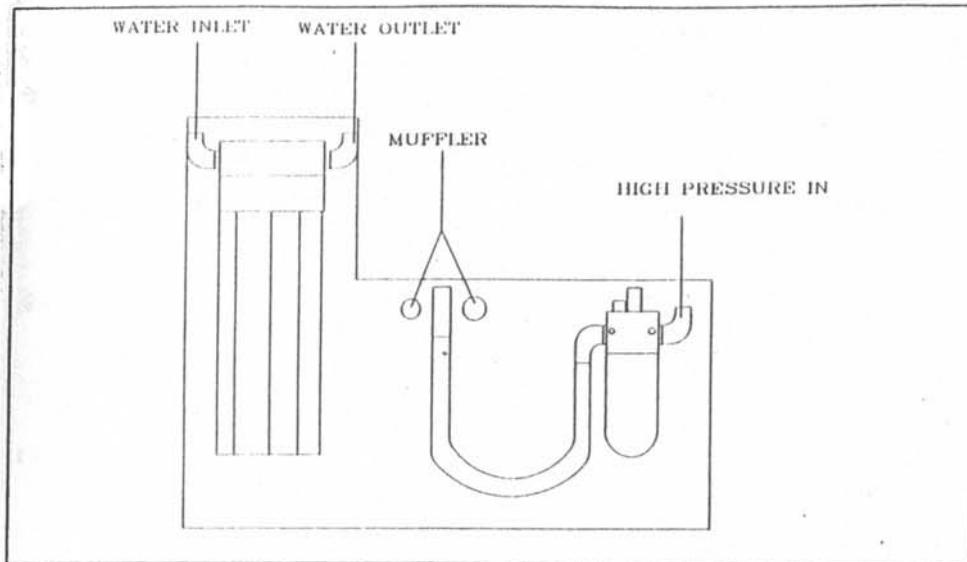
4.7.3 WEEKLY MAINTENANCE

Beside the above, check the water pure degree, lubrication system, pump lubrication oil and take out the water in pump.

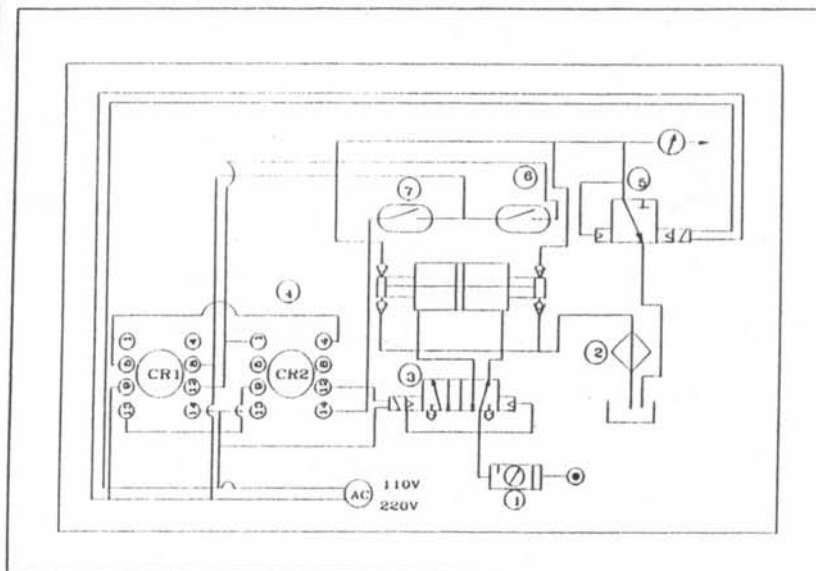
4.7.4 MONTHLY MAINTENANCE

Beside the above, also to check the perpendicular degree of ceramic guide.

4.7.5 PUMP



FILTER SYSTEM CHART :



★★★★★ CAUTION

1. On the air compressor circuit, there are the water drop filter and lubrication device, keep the filter cap clean and enough lubricator (use # 20 lubricator)
2. On the water inlet circuit, avoid air bubble, and drain broken, otherwise this circuit device will fast go and back moving badly, the pressure will be down to unavailable value, and consumpt big air source while it is serious.
3. If the filter is dirty, the above item 2 problem will be occurred, there are some problems and trouble shooting step :

Case 1 : The water pressure deficient and circuit device fast go and back moving :

- A. Anti-reverse valve trouble this device locate on the end of brass two sides.
- B. The pressure release valve is not fasten or trouble.
- C. There is water deficient in tank.

Case 2 : Pump in vain running, or no water out.

- A. Anti-reverse valve is trouble.
- B. The water pipe is broken or water deficient.
- C. The seal of air cylinder is broken.

Case 3 : Pump no function (no water pressure)

- A. Air compressor limit switch broken.
- B. The movement of indicator valve for air compressor not work completely, (i.e, two muffler all exhaust), use screw driver to touch limit switch, in order to return indicator valve to appropriate position.
- C. Air inlet valve of air compressor trouble or air compressor no air source into.
- D. Air pressure adjusting valve not open (clockwise for increase air pressure).

4.7.6 CONSUMPTION PARTS

- A. Electrode pipe
- B. Filter
- C. Ceramic guide

The material of electrode pipe will affect machining quality, we suggest :

1. If workpiece is steel, the electrode select brass pipe.
2. If workpiece is Tungsten Carbide, the electrode select copper pipe.
3. If workpiece is copper, the electrode select copper pipe.

4.8 ELECTRODE SPECIFICATION AND TOLERANCE

The outside and inside diameter of electrode.

Tolerance within ± 0.01 mm for all size electrode pipe.

OUTSIDE DIA		INSIDE DIA		LENGTH	OUTSIDE DIA		INSIDE DIA		LENGTH
DIA	TOLERANCE	DIA	TOLERANCE	MM	DIA	TOLERANCE	DIA	TOLERANCE	MM
0.20	+ 0	0.00	+/-	200	0.20		0.08	+/-	200
0.30	- 0.01	0.12	0.02	300	0.30		0.11	0.02	300
0.40		0.15			0.40		0.20		400
0.50		0.18			0.50		0.20		
0.60		0.20		300	0.60		0.20		
0.70	+ 0	0.20	+/-		0.70		0.20		
0.80	- 0.02	0.30	0.02		0.80		0.30		
0.90		0.30			0.90		0.30		
1.00		0.30			1.00		0.30		
1.10		0.30			1.10	+ 0	0.30	+/-	400
1.20		0.40			1.20	- 0.03	0.40	0.03	
1.30		0.40			1.30		0.40		
1.40		0.40			1.40		0.40		
1.50		0.50			1.50		0.50		
1.60		0.50			1.60		0.50		
1.70		0.50			1.70		0.50		
1.80		0.60			1.80		0.60		
1.90		0.60			1.90		0.60		
2.00		0.60			2.00		0.60		
2.10		0.70		300	2.10		0.70		400
2.20	+ 0	0.70	+/-		2.20	+ 0	0.70	+/-	
2.30	- 0.03	0.70	0.03		2.30	- 0.03	0.70	0.03	
2.40		0.80			2.40		0.80		
2.50		0.80			2.50		0.80		
2.60		0.80			2.60		0.80		
2.70		0.90			2.70		0.90		
2.80		0.90			2.80		0.90		
2.90		0.90			2.90		0.90		
3.00		1.00			3.00		1.00		

4.9 TECHNOLOGY TABLE

T1: BRASS TO HARDEN STEEL

APPLICATION		WORKING CONDITION								PERFORMANCE		
MAT'L	DIA	TON	TOFF	IP	SMALL	SERVO SPEED	C	PRESSURE	SPINDLE SPEED	SPEED mm / PER MIN.	WEAR	REMARK
SKD11 AND HARDEN STEEL	φ0.3	15	10	02	ON	1.7-2.5	0	60-70	5 - 7	3-7	200% UP	
		25	10	04	ON	1.7-2.5	0	60-70				
		35	15	03	OFF	1.7-2.5	0	60-70				
	φ0.5	15	15	05	OFF	1.7-2.5	0	50-60	5 - 7	20-30	150% LOW	
		25	20	06	OFF	1.7-2.5	0	50-60				
		35	20	07	OFF	1.7-2.5	0	50-60				
	φ1.0	15	20	10	OFF	1.7-2.5	0	50-60	6 - 9	15-25	80% LOW	
		25	25	11	OFF	1.7-2.5	0	50-60				
		35	25	12	OFF	1.7-2.5	0	50-60				
	φ1.5	25	25	12	OFF	1.7-2.5	0	40-50	6 - 9	10-20	50% LOW	
		35	25	13	OFF	1.7-2.5	0	40-50				
		45	25	14	OFF	1.7-2.5	0	40-50				
	φ2.0	25	25	12	OFF	1.7-2.5	0	40-50	6 - 9	7-15	40% LOW	
		35	25	13	OFF	1.7-2.5	0	40-50				
		45	25	14	OFF	1.7-2.5	0	40-50				
	φ2.5	35	25	13	OFF	1.7-2.5	0	35-45	5 - 7	5-10	30% LOW	
		45	25	14	OFF	1.7-2.5	0	35-45				
		55	25	15	OFF	1.7-2.5	0	35-45				
	φ3.0	35	25	13	OFF	1.7-2.5	0	35-45	5 - 7	3-8	20% LOW	
		45	25	14	OFF	1.7-2.5	0	35-45				
		55	25	15	OFF	1.7-2.5	0	35-45				

WEAR PERCENT : $\frac{Z \text{ DISTANCE} - \text{WORKING HEIGHT}}{\text{WORKING HIGHT}} \times 100\%$

WATER PURITY : 10KΩ ~20KΩ

GAP SETTING: (BY MEANS OF VOLT-METER INDICATING)

WHEN IP<25A: PLEASE SET WORKING VOLTAGE ABOUT 25V~40V

WHEN IP>25A: PLEASE SET ABOUT 40V~60V

T2: COPPER TO TUNGSTEN CARBIDE OR HARDEN ALLOY

APPLICATION		WORKING CONDITION								PERFORMANCE		
MAT'L	DIA	TON	TOFF	IP	SMALL	SERVO SPEED	C	PRESSURE	SPINDLE SPEED	SPEED mm / PER MIN.	WEAR	REMARK
TUNGSTEN CARBIDE	φ0.3	15	10	02	ON	1.7-2.5	1	50-60	5 - 7	1-5	400% UP	
		25	10	04	ON	1.7-2.5	2	50-60				
		35	15	03	ON	1.7-2.5	2	50-60				
OR HARDEN ALLOY	φ0.5	15	15	03	OFF	1.7-2.5	2	50-60	5 - 7	2-5	40- 300%	
		25	20	04	OFF	1.7-2.5	3	50-60				
		35	20	05	OFF	1.7-2.5	4	50-60				
	φ1.0	15	20	06	OFF	1.7-2.5	3	40-50	6 - 9	3-6	20- 100%	
		25	25	07	OFF	1.7-2.5	4	40-50				
		35	25	08	OFF	1.7-2.5	4	40-50				
	φ1.5	25	25	07	OFF	1.7-2.5	3	40-50	6 - 9	2-4	10-80 %	
		35	25	09	OFF	1.7-2.5	4	40-50				
		45	25	10	OFF	1.7-2.5	5	40-50				
	φ2.0	25	25	10	OFF	1.7-2.5	4	40-50	6 - 9	1.5-3	10-60 %	CAN USE BRASS TUBE
		35	25	11	OFF	1.7-2.5	5	40-50				
		45	25	12	OFF	1.7-2.5	6	40-50				
	φ2.5	35	25	13	OFF	1.7-2.5	4	35-45	5 - 7	1-2	8-40%	CAN USE BRASS TUBE
		45	25	14	OFF	1.7-2.5	5	35-45				
		55	25	15	OFF	1.7-2.5	6	35-45				
	φ3.0	35	25	13	OFF	1.7-2.5	4	35-45	5 - 7	1-2	8-40%	CAN USE BRASS TUBE
		45	25	14	OFF	1.7-2.5	5	35-45				
		55	25	15	OFF	1.7-2.5	6	35-45				

WEAR PERCENT : $\frac{Z \text{ DISTANCE} - \text{WORKING HEIGHT}}{\text{WORKING HIGHT}} \times 100\%$

WATER PURITY : 10KΩ ~ 20KΩ

GAP SETTING: (BY MEANS OF VOLT-METER INDICATING)

WHEN IP < 25A: PLEASE SET WORKING VOLTAGE ABOUT 25V~40V

WHEN IP > 25A: PLEASE SET ABOUT 40V~60V

T3: BRASS TO STAINLESS STEEL

APPLICATION		WORKING CONDITION								PERFORMANCE		
MAT'L	DIA	TON	TOFF	IP	SMALL	SERVO SPEED	C	PRESSURE	SPINDLE SPEED	SPEED mm / PER MIN.	WEAR	REMARK
SUS304	φ0.3	15	10	02	ON	1.7-2.5	0	60-70	5 - 7	5-10	200% UP	
		25	10	04	ON	1.7-2.5	0	60-70				
		35	15	03	ON	1.7-2.5	0	60-70				
AND SUS420	φ0.5	15	15	05	OFF	1.7-2.5	0	50-60	5 - 7	20-35	80- 150%	
		25	20	06	OFF	1.7-2.5	0	50-60				
		35	20	07	OFF	1.7-2.5	0	50-60				
	φ1.0	15	20	10	OFF	1.7-2.5	0	50-60	6 - 9	20-30	40- 80%	
		25	25	11	OFF	1.7-2.5	0	50-60				
		35	25	12	OFF	1.7-2.5	0	50-60				
	φ1.5	25	25	12	OFF	1.7-2.5	0	40-50	6 - 9	15 -20	30-60 %	
		35	25	13	OFF	1.7-2.5	0	40-50				
		45	25	14	OFF	1.7-2.5	0	40-50				
	φ2.0	25	25	12	OFF	1.7-2.5	0	40-50	6 - 9	10-15	20-50 %	
		35	25	13	OFF	1.7-2.5	0	40-50				
		45	25	14	OFF	1.7-2.5	0	40-50				
	φ2.5	35	25	13	OFF	1.7-2.5	0	35-45	5 - 7	8-12	20-45 %	
		45	25	14	OFF	1.7-2.5	0	35-45				
		55	25	15	OFF	1.7-2.5	0	35-45				
	φ3.0	35	25	13	OFF	1.7-2.5	0	35-45	5 - 7	5-10	15-40 %	
		45	25	14	OFF	1.7-2.5	0	35-45				
		55	25	15	OFF	1.7-2.5	0	35-45				

WEAR PERCENT : $\frac{Z \text{ DISTANCE} - \text{WORKING HEIGHT}}{\text{WORKING HIGHT}} \times 100\%$

WATER PURITY : 10KΩ ~20KΩ

GAP SETTING: (BY MEANS OF VOLT-METER INDICATING)

WHEN IP<25A: PLEASE SET WORKING VOLTAGE ABOUT 25V~40V

WHEN IP>25A: PLEASE SET ABOUT 40V~60V

T4: COPPER TO COPPER OR BRASS

APPLICATION		WORKING CONDITION								PERFORMANCE		
MAT'L	DIA	TON	TOFF	IP	SMALL	SERVO SPEED	C	PRESSURE	SPINDLE SPEED	SPEED mm / PER MIN.	WEAR	REMARK
COPPER	φ0.3	15	10	02	ON	1.7-2.5	0	60-70	5 - 7	3-6	300% UP	
		25	10	04	ON	1.7-2.5	0	60-70				
		35	15	03	ON	1.7-2.5	0	60-70				
OR	φ0.5	15	15	05	OFF	1.7-2.5	0	50-60	5 - 7	6-15	200% UP	
		25	20	05	OFF	1.7-2.5	0	50-60				
		35	20	06	OFF	1.7-2.5	0	50-60				
BRASS	φ1.0	15	20	09	OFF	1.7-2.5	0	50-60	6 - 9	10-20	80% LOW	
		25	25	10	OFF	1.7-2.5	0	50-60				
		35	25	11	OFF	1.7-2.5	0	50-60				
	φ1.5	25	25	11	OFF	1.7-2.5	0	40-50	6 - 9	8-18	50% LOW	
		35	25	12	OFF	1.7-2.5	0	40-50				
		45	25	13	OFF	1.7-2.5	0	40-50				
	φ2.0	25	25	12	OFF	1.7-2.5	0	40-50	6 - 9	5-10	40% LOW	
		35	25	13	OFF	1.7-2.5	0	40-50				
		45	25	14	OFF	1.7-2.5	0	40-50				
	φ2.5	35	25	13	OFF	1.7-2.5	0	35-45	5 - 7	3-8	30% LOW	
		45	25	14	OFF	1.7-2.5	0	35-45				
		55	25	15	OFF	1.7-2.5	0	35-45				
	φ3.0	35	25	13	OFF	1.7-2.5	0	35-45	5 - 7	2-6	20% LOW	
		45	25	14	OFF	1.7-2.5	0	35-45				
		55	25	15	OFF	1.7-2.5	0	35-45				

WEAR PERCENT : $\frac{Z \text{ DISTANCE} - \text{WORKING HEIGHT}}{\text{WORKING HIGHT}} \times 100\%$

WATER PURITY : 10KΩ ~ 20KΩ

GAP SETTING: (BY MEANS OF VOLT-METER INDICATING)

WHEN IP < 25A: PLEASE SET WORKING VOLTAGE ABOUT 25V~40V

WHEN IP > 25A: PLEASE SET ABOUT 40V~60V

T5:BRASS TO STAINLESS STEEL、HARDEN STEEL OR SKD-

APPLICATION		WORKING CONDITION								PERFORMANCE		
MAT'L	DIA	TON	TOFF	IP	SMALL	SERVO SPEED	C	PRESSURE	SPINDLE SPEED	SPEED mm / PER MIN.	WEAR	REMARK
SUS304 AND SUS420 (HARDEN STEEL)	φ0.2	10	10	01	ON	2-3.5	0	50-70	5 - 7	3-6	300% UP	
		15	10	02	ON	2-3.5	0	50-70				
		20	15	03	ON	2-3.5	0	50-70				
	φ4.0	45	25	13	OFF	2-3	5	30-40	5 - 7	4-8	15-35 % LOW	
		55	25	14	OFF	2-3	6	30-40				
		65	25	15	OFF	2-3	7	30-40				
	φ5.0	55	25	13	OFF	2-3	5	25-35	5 - 7	3-6	10-30 % LOW	
		65	25	14	OFF	2-3	6	25-35				
		75	25	15	OFF	2-3	7	25-35				
	φ6.0	65	25	13	OFF	2-3	5	25-35	5 - 7	2 - 5	10-25 % LOW	
		75	25	14	OFF	2-3	6	25-35				
		85	25	15	OFF	2-3	7	25-35				
HARDEN STEEL OR SKD-	φ0.2	10	10	01	ON	2-3.5	0	50-70	5 - 7	2-6	300% UP	
		15	10	02	ON	2-3.5	0	50-70				
		20	15	03	ON	2-3.5	0	50-70				
	φ4.0	45	25	13	OFF	2-3	5	30-40	5 - 7	2-6	18% LOW	
		55	25	14	OFF	2-3	6	30-40				
		65	25	15	OFF	2-3	7	30-40				
	φ5.0	55	25	13	OFF	2-3	5	25-35	5 - 7	1-5	15% LOW	
		65	25	14	OFF	2-3	6	25-35				
		75	25	15	OFF	2-3	7	25-35				
	φ6.0	65	25	13	OFF	2-3	5	25-35	5 - 7	0.8-4	13% LOW	
		75	25	14	OFF	2-3	6	25-35				
		85	25	15	OFF	2-3	7	25-35				

GAP SETTING: (BY MEANS OF VOLT-METER INDICATING)

WHEN IP<25A: PLEASE SET WORKING VOLTAGE ABOUT 25V~40V

WHEN IP>25A: PLEASE SET ABOUT 40V~60V

T6: COPPER TO COPPER · TUNGSTEN CARBIDE OR HARDEN ALLOY

APPLICATION		WORKING CONDITION								PERFORMANCE		
MAT'L	DIA	TON	TOFF	IP	SMALL	SERVO SPEED	C	PRESSURE	SPINDLE SPEED	SPEED mm / PER MIN.	WEAR	REMARK
COPPER	φ0.2	10	10	01	ON	2-3.5	0	50-70	5 - 7	1-4	350% UP	
		15	10	02	ON	2-3.5	0	50-70				
		20	15	03	ON	2-3.5	0	50-70				
	φ4.0	45	25	13	OFF	2-3	5	30-40	5 - 7	1-5	18% LOW	
		55	25	14	OFF	2-3	6	30-40				
		65	25	15	OFF	2-3	7	30-40				
	φ5.0	55	25	13	OFF	2-3	5	25-35	5 - 7	0.8-4	15% LOW	
		65	25	14	OFF	2-3	6	25-35				
		75	25	15	OFF	2-3	7	25-35				
	φ6.0	65	25	13	OFF	2-3	5	25-35	5 - 7	0.5-3	13% LOW	
		75	25	14	OFF	2-3	6	25-35				
		85	25	15	OFF	2-3	7	25-35				
TUNGSTEN CARBIDE OR HARDEN ALLOY	φ0.2	10	10	01	ON	2-3.5	1	50-70	5 - 7	0.8-4	500% UP	
		15	10	02	ON	2-3.5	1	50-70				
		20	15	03	ON	2-3.5	1	50-70				
	φ4.0	45	25	13	OFF	2-3	5	30-40	5 - 7	0.8-2	15% LOW	
		55	25	14	OFF	2-3	6	30-40				
		65	25	15	OFF	2-3	7	30-40				
	φ5.0	55	25	13	OFF	2-3	5	25-35	5 - 7	0.5-1.5	13% LOW	
		65	25	14	OFF	2-3	6	25-35				
		75	25	15	OFF	2-3	7	25-35				
	φ6.0	65	25	13	OFF	2-3	5	25-35	5 - 7	0.5-1.5	10% LOW	
		75	25	14	OFF	2-3	6	25-35				
		85	25	15	OFF	2-3	7	25-35				

GAP SETTING: (BY MEANS OF VOLT-METER INDICATING)

WHEN IP<25A: PLEASE SET WORKING VOLTAGE ABOUT 25V~40V

WHEN IP>25A: PLEASE SET ABOUT 40V~60V

--APPENDIX

*

NEW TECHNOLOGY TABLE ESTABLISHED BY OCT. '96

TECHNOLOGY TABLE

APPLICATION	WORKPIECE	SKD-11															
	ELECTRODE PIPE	BRASS															
	PIPE DIA	Ø.3															
WORKING CONDITION	ON TIME	10	15	20	25	30	10	15	20	25	30	10	15	20	25	30	
	OFF TIME	10	10	15	15	15	10	10	15	15	15	10	10	15	15	15	
	CURRENT	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	
	CAPACITOR	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1	
	GAP	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	
	SPEED	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100	
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	
PERFORMANCE	WORKING VOLTAGE (V)	25 ~ 35															
	WORKING CURRENT (A)	3	3	4	4	4	4	4	4	4	4	4	5	5	4	4	
	ELECTRODE WEAR (%)	75	85	75	70	55	130	95	85	75	70	90	85	95	100	85	
	WORKING SPEED (MM/MIN)	11	20	27	8.3	5.8	4.3	5.8	7.9	6.3	7.2	8.3	32	14	14	8.6	
REMARK	Z DISTANCE - WORKING HEIGHT																
	WEAR PERCENT :	* 100%															
	WATER PURITY : BETWEEN 15 K AND 30 K																

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DRILLING EDM TECHNOLOGY TABLE

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TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	Ø.3														
WORKING CONDITION	ON TIME	10	15	20	25	30	10	15	20	25	30	10	15	20	25	30
	OFF TIME	10	10	15	15	15	10	10	15	15	15	10	10	15	15	15
	CURRENT	4	4	4	4	4	4	4	4	4	4	4	4	4	4	4
	CAPACITOR	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	GAP	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1
	SPEED	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	25 ~ 35														
	WORKING CURRENT (A)	5	5	4	5	5	5	5	5	4	4	5	5	4	5	6
	ELECTRODE WEAR (%)	130	95	85	75	70	90	85	95	100	85	100	90	100	65	80
	WORKING SPEED (MM/MIN)	4.3	5.8	7.9	6.3	7.2	8.3	32	14	14	8.6	15	17	22	5.7	7.4
REMARK	$\text{WEAR PERCENT : } \frac{\text{Z DISTANCE - WORKING HEIGHT}}{\text{WORKING HEIGHT}} \times 100\%$															
	WATER PURITY : BETWEEN 15 K AND 30 K															

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Date: December 25, 1996 Sheet of

TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	Ø.3														
WORKING CONDITION	ON TIME	10	15	20	25	30	10	15	20	25	30	10	15	20	25	30
	OFF TIME	10	10	15	15	15	10	10	15	15	15	10	10	15	15	15
	CURRENT	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5
	CAPACITOR	1	1	1	1	1	1	1	1	1	1	1	1	1	1	1
	GAP	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1
	SPEED	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	25 ~ 35														
	WORKING CURRENT (A)	6	6	5	5	5	7	6	5	5	5	5	5	5	5	5
	ELECTRODE WEAR (%)	115	100	100	135	110	95	115	90	100	115	110	115	115	115	110
	WORKING SPEED (MM/MIN)	5.4	5.3	5.6	3.4	4.2	18	11	7.1	6.7	6.9	5.7	9.4	20	26	31
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT :	$\frac{\text{WORKING DEPTH}}{\text{WORKING HEIGHT}} \times 100\%$														
WATER PURITY : BETWEEN 15 K AND 30 K																

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TECHNOLOGY TABLE

TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	Ø.5														
WORKING CONDITION	ON TIME	15	20	25	30	35	15	20	25	30	35	15	20	25	30	35
	OFF TIME	10	15	15	15	15	10	15	15	15	15	10	15	15	15	15
	CURRENT	5	5	5	5	5	5	5	5	5	5	5	5	5	5	5
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0
	SPEED	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	7	6	6	7	7	8	6	7	7	7	8	6	6	7	7
	ELECTRODE WEAR (%)	68	69	73	72	71	68	75	72	75	75	68	71	60	68	68
	WORKING SPEED (MM/MIN)	14	19	18	26	28	19	22	27	28	33	19	16	19	22	23
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT :	WORKING HEIGHT										* 100%				
	WATER PURITY : BETWEEN 15 K AND 30 K															

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TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	Ø.5														
WORKING CONDITION	ON TIME	15	20	25	30	35	15	20	25	30	35	15	20	25	30	35
	OFF TIME	10	15	15	15	15	10	15	15	15	15	10	15	15	15	15
	CURRENT	6	6	6	6	6	6	6	6	6	6	6	6	6	6	6
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0
	SPEED	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	9	7	7	7	7	9	7	7	7	7	8	6	7	7	7
	ELECTRODE WEAR (%)	81	94	92	91	94	87	87	84	86	92	80	87	86	86	86
	WORKING SPEED (MM/MIN)	20	32	34	36	38	21	23	28	33	33	24	28	29	29	31
REMARK	Z DISTANCE - WORKING HEIGHT WEAR PERCENT : $\frac{\text{Z DISTANCE - WORKING HEIGHT}}{\text{WORKING HEIGHT}} \times 100\%$															
	WATER PURITY : BETWEEN 15 K AND 30 K															

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REV

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Date: October 10, 1996 Sheet of

TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	Ø.5														
WORKING CONDITION	ON TIME	15	20	25	30	35	15	20	25	30	35	15	20	25	30	35
	OFF TIME	10	15	15	15	15	10	15	15	15	15	10	15	15	15	15
	CURRENT	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0
	SPEED	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	11	8	8	8	8	11	7	7	7	7	11	7	8	8	8
	ELECTRODE WEAR (%)	96	83	100	102	101	94	97	101	99	101	85	93	95	89	99
	WORKING SPEED (MM/MIN)	24	25	33	33	38	22	36	36	36	40	21	23	27	36	38
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT : $\frac{\text{WORKING HEIGHT}}{\text{Z DISTANCE - WORKING HEIGHT}} \times 100\%$															
REMARK	WATER PURITY : BETWEEN 15 K AND 30 K															

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DRILLING EDM TECHNOLOGY TABLE

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REV

1

Date: October 10, 1996 Sheet of

TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	0.5														
WORKING CONDITION	ON TIME	15	20	25	30	35	15	20	25	30	35	15	20	25	30	35
	OFF TIME	10	15	15	15	15	10	15	15	15	15	10	15	15	15	15
	CURRENT	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0
	SPEED	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	10	8	8	8	8	10	8	8	8	9	11	8	8	8	9
	ELECTRODE WEAR (%)	80	108	110	110	114	81	110	114	115	115	106	107	106	114	110
	WORKING SPEED (MM/MIN)	23	33	34	38	39	26	36	39	40	42	57	34	38	40	34
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT : $\frac{\text{WORKING DEPTH}}{\text{WORKING HEIGHT}} \times 100\%$															
REMARK	WATER PURITY : BETWEEN 15 K AND 30 K															

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DRILLING EDM TECHNOLOGY TABLE

Size Document Number

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0.5-4

REV

1

Date: October 11, 1996 Sheet of

TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	Ø.5														
WORKING CONDITION	ON TIME	15	20	25	30	35	15	20	25	30	35	15	20	25	30	35
	OFF TIME	10	15	15	15	15	10	15	15	15	15	10	15	15	15	15
	CURRENT	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0
	SPEED	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	11	9	9	9	9	11	8	8	8	9	12	9	9	9	9
	ELECTRODE WEAR (%)	110	115	116	127	128	108	134	143	116	124	133	135	139	135	134
	WORKING SPEED (MM/MIN)	50	36	36	39	40	23	36	36	34	36	61	36	36	37	40
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT : $\frac{\text{WORKING HEIGHT}}{\text{Z DISTANCE - WORKING HEIGHT}} \times 100\%$															
REMARK	WATER PURITY : BETWEEN 15 K AND 30 K															

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Date: October 11, 1996 Sheet

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TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	0.5														
WORKING CONDITION	ON TIME	15	20	25	30	35	15	20	25	30	35	15	20	25	30	35
	OFF TIME	10	15	15	15	15	10	15	15	15	15	10	15	15	15	15
	CURRENT	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0	3.0
	SPEED	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0	2.0
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	12	9	9	10	11	12	9	9	10	10	12	9	9	9	10
	ELECTRODE WEAR (%)	108	134	143	116	124	133	135	139	135	134	136	134	141	136	133
	WORKING SPEED (MM/MIN)	23	36	36	34	35	61	36	36	38	40	65	42	44	40	42
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT :	WORKING HEIGHT										* 100%				
	WATER PURITY : BETWEEN 15 K AND 30 K															

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Date: October 11, 1996 Sheet of

TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	Ø.7														
WORKING CONDITION	ON TIME	15	20	25	30	35	15	20	25	30	35	15	20	25	30	35
	OFF TIME	10	15	15	15	15	10	15	15	15	15	10	15	15	15	15
	CURRENT	7	7	7	7	7	7	7	7	7	7	7	7	7	7	7
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	10	8	9	9	10	10	8	9	9	10	10	7	8	9	10
	ELECTRODE WEAR (%)	42	59	63	61	60	56	60	63	62	60	55	59	66	67	65
	WORKING SPEED (MM/MIN)	12	17	21	21	22	15	19	21	20	20	16	19	25	26	27
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT :											* 100%				
	WATER PURITY : BETWEEN 15 K AND 30 K															

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TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	Ø.7														
WORKING CONDITION	ON TIME	15	20	25	30	35	15	20	25	30	35	15	20	25	30	35
	OFF TIME	10	15	15	15	15	10	15	15	15	15	10	15	15	15	15
	CURRENT	8	8	8	8	8	8	8	8	8	8	8	8	8	8	8
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	12	8	9	10	11	11	8	10	11	12	11	8	9	10	10
	ELECTRODE WEAR (%)	58	75	73	70	69	60	67	60	66	60	56	66	63	64	58
	WORKING SPEED (MM/MIN)	15	24	26	25	30	17	27	24	29	24	19	23	25	28	26
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT : $\frac{\text{WORKING DEPTH}}{\text{WORKING HEIGHT}} \times 100\%$															
REMARK	WATER PURITY : BETWEEN 15 K AND 30 K															

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TECHNOLOGY TABLE

APPLICATION	WORKPIECE	SKD-11															
	ELECTRODE PIPE	BRASS															
	PIPE DIA	Ø.7															
WORKING CONDITION	ON TIME	15	20	25	30	35	15	20	25	30	35	15	20	25	30	35	
	OFF TIME	10	15	15	15	15	10	15	15	15	15	10	15	15	15	15	
	CURRENT	9	9	9	9	9	9	9	9	9	9	9	9	9	9	9	
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
	GAP	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100	
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25															
	WORKING CURRENT (A)	12	9	10	11	11	12	9	9	10	10	12	8	9	10	10	
	ELECTRODE WEAR (%)	56	74	70	72	65	52	74	73	72	70	71	74	73	71	73	
	WORKING SPEED (MM/MIN)	18	26	27	32	27	17	25	26	26	27	18	27	26	29	32	
REMARK	Z DISTANCE - WORKING HEIGHT																
	WEAR PERCENT :	WORKING HEIGHT															* 100%
	WATER PURITY : BETWEEN 15 K AND 30 K																

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TECHNOLOGY TABLE

APPLICATION	WORKPIECE	SKD-11															
	ELECTRODE PIPE	BRASS															
	PIPE DIA	Ø.7															
WORKING CONDITION	ON TIME	20	25	30	35	40	20	25	30	35	40	20	25	30	35	40	
	OFF TIME	15	15	15	15	17	15	15	15	15	17	15	15	15	15	17	
	CURRENT	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10	
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
	GAP	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100	
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25															
	WORKING CURRENT (A)	10	11	12	12	12	9	9	11	11	12	9	10	11	11	11	
	ELECTRODE WEAR (%)	69	69	67	69	65	80	75	70	72	62	74	74	74	75	73	
	WORKING SPEED (MM/MIN)	27	27	29	27	26	29	29	29	33	30	30	32	32	36	35	
REMARK	Z DISTANCE - WORKING HEIGHT																
	WEAR PERCENT :	WORKING HEIGHT															* 100%
	WATER PURITY : BETWEEN 15 K AND 30 K																

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TECHNOLOGY TABLE

APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	Ø.7														
WORKING CONDITION	ON TIME	20	25	30	35	40	20	25	30	35	40	20	25	30	35	40
	OFF TIME	15	15	15	15	17	15	15	15	15	17	15	15	15	15	17
	CURRENT	11	11	11	11	11	11	11	11	11	11	11	11	11	11	11
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	9	10	12	12	13	9	11	12	13	13	10	10	11	12	12
	ELECTRODE WEAR (%)	74	76	76	74	75	76	74	81	82	81	81	80	84	82	80
	WORKING SPEED (MM/MIN)	24	30	32	31	33	31	33	36	36	38	31	33	36	39	39
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT :															* 100%
	WATER PURITY : BETWEEN 15 K AND 30 K															

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TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	Ø.7														
WORKING CONDITION	ON TIME	20	25	30	35	40	20	25	30	35	40	20	25	30	35	40
	OFF TIME	15	15	15	15	17	15	15	15	15	17	15	15	15	15	17
	CURRENT	12	12	12	12	12	12	12	12	12	12	12	12	12	12	12
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	10	10	11	12	12	10	12	14	14	14	11	11	13	14	14
	ELECTRODE WEAR (%)	85	68	76	60	59	68	67	68	67	65	70	72	76	71	67
	WORKING SPEED (MM/MIN)	32	33	33	40	36	40	43	49	50	43	43	43	44	47	44
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT : $\frac{\text{WORKING HEIGHT}}{\text{WORKING HEIGHT}} \times 100\%$															
	WATER PURITY : BETWEEN 15 K AND 30 K															

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TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	1.0														
WORKING CONDITION	ON TIME	20	25	30	35	40	20	25	30	35	40	20	25	30	35	40
	OFF TIME	15	15	15	15	20	15	15	15	15	20	15	15	15	15	20
	CURRENT	10	10	10	10	10	10	10	10	10	10	10	10	10	10	10
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	10	10	10	11	10	10	10	10	11	10	10	10	10	11	10
	ELECTRODE WEAR (%)	47	51	44	44	44	49	52	45	48	47	47	50	44	57	47
	WORKING SPEED (MM/MIN)	11	15	14	13	12	15	18	13	12	12	11	11	12	12	11
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT :	WORKING HEIGHT										* 100%				
	WATER PURITY : BETWEEN 10 K AND 20 K															

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TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	1.0														
WORKING CONDITION	ON TIME	20	25	30	35	40	20	25	30	35	40	20	25	30	35	40
	OFF TIME	15	15	15	15	20	15	15	15	15	20	15	15	15	15	20
	CURRENT	11	11	11	11	11	11	11	11	11	11	11	11	11	11	11
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	11	11	12	13	12	11	11	12	13	12	11	11	12	13	12
	ELECTRODE WEAR (%)	57	56	52	49	49	52	50	55	52	51	54	50	52	49	49
	WORKING SPEED (MM/MIN)	24	14	16	20	18	13	10	16	18	16	10	13	14	14	14
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT : $\frac{\text{WORKING HEIGHT}}{\text{WORKING HEIGHT}} \times 100\%$															
REMARK	WATER PURITY : BETWEEN 10 K AND 20 K															

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TECHNOLOGY TABLE

APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	1.0														
WORKING CONDITION	ON TIME	20	25	30	35	40	20	25	30	35	40	20	25	30	35	40
	OFF TIME	15	15	15	15	20	15	15	15	15	20	15	15	15	15	20
	CURRENT	12	12	12	12	12	12	12	12	12	12	12	12	12	12	12
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	12	13	13	14	13	12	13	13	14	13	12	13	13	14	13
	ELECTRODE WEAR (%)	60	61	61	53	57	57	53	69	64	62	58	57	56	61	60
	WORKING SPEED (MM/MIN)	17	20	15	13	14	25	19	17	19	16	17	15	14	10	12
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT :	WORKING HEIGHT														* 100%
	WATER PURITY : BETWEEN 10 K AND 20 K															

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TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	1.0														
WORKING CONDITION	ON TIME	20	25	30	35	40	20	25	30	35	40	20	25	30	35	40
	OFF TIME	15	15	15	15	20	15	15	15	15	20	15	15	15	15	20
	CURRENT	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	14	15	16	16	16	14	15	16	16	16	14	15	15	16	16
	ELECTRODE WEAR (%)	61	59	60	56	59	58	61	60	59	59	56	63	60	59	60
	WORKING SPEED (MM/MIN)	26	28	29	17	17	27	25	24	16	15	26	20	20	12	15
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT : $\frac{\text{WORKING HEIGHT}}{\text{WORKING HEIGHT}} \times 100\%$															
	WATER PURITY : BETWEEN 10 K AND 20 K															

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TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	1.0														
WORKING CONDITION	ON TIME	20	25	30	35	40	20	25	30	35	40	20	25	30	35	40
	OFF TIME	15	15	15	15	20	15	15	15	15	20	15	15	15	15	20
	CURRENT	14	14	14	14	14	14	14	14	14	14	14	14	14	14	14
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	16	17	17	18	17	16	17	17	18	17	16	17	17	18	17
	ELECTRODE WEAR (%)	61	75	78	83	79	62	69	74	76	78	66	69	67	69	68
	WORKING SPEED (MM/MIN)	24	29	24	22	22	25	27	22	35	25	23	23	18	27	24
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT :	WORKING HEIGHT										* 100%				
	WATER PURITY : BETWEEN 10 K AND 20 K															

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TECHNOLOGY TABLE

APPLICATION	WORKPIECE	SKD-11															
	ELECTRODE PIPE	BRASS															
	PIPE DIA	1.0															
WORKING CONDITION	ON TIME	20	25	30	35	40	20	25	30	35	40	20	25	30	35	40	
	OFF TIME	15	15	15	15	20	15	15	15	15	20	15	15	15	15	20	
	CURRENT	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
	GAP	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100	
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25															
	WORKING CURRENT (A)	17	18	18	19	20	17	18	18	19	20	17	18	18	19	20	
	ELECTRODE WEAR (%)	70	68	68	70	78	69	69	69	69	75	72	72	70	70	72	
	WORKING SPEED (MM/MIN)	27	30	28	35	33	28	29	28	35	34	27	27	27	31	30	
REMARK	Z DISTANCE - WORKING HEIGHT																
	WEAR PERCENT :											* 100%					
	WATER PURITY : BETWEEN 10 K AND 20 K																

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TECHNOLOGY TABLE

APPLICATION	WORKPIECE	SKD-11															
	ELECTRODE PIPE	BRASS															
	PIPE DIA	1.5															
WORKING CONDITION	ON TIME	20	25	30	35	40	20	25	30	35	40	20	25	30	35	40	
	OFF TIME	15	15	15	15	20	15	15	15	15	20	15	15	15	15	20	
	CURRENT	12	12	12	12	12	12	12	12	12	12	12	12	12	12	12	
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0	
	GAP	3	3	3	3	3	3	3	3	3	3	3	3	3	3	3	
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100	
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25															
	WORKING CURRENT (A)	13	14	15	16	15	13	14	15	16	15	13	14	15	16	15	
	ELECTRODE WEAR (%)	30	35	35	34	33	39	39	36	36	39	41	38	39	36	37	
	WORKING SPEED (MM/MIN)	12	13	11	10	10	14	11	12	13	12	13	13	12	12	12	
REMARK	Z DISTANCE - WORKING HEIGHT																
	WEAR PERCENT :	WORKING HEIGHT										* 100%					
	WATER PURITY : BETWEEN 10 K AND 20 K																

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TECHNOLOGY TABLE

APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	1.5														
WORKING CONDITION	ON TIME	20	25	30	35	40	20	25	30	35	40	20	25	30	35	40
	OFF TIME	15	15	15	15	20	15	15	15	15	20	15	15	15	15	20
	CURRENT	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3	3	3	3	3	3	3	3	3	3	3	3	3	3	
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	13	14	15	17	16	13	14	15	17	16	13	14	15	17	16
	ELECTRODE WEAR (%)	42	43	40	39	40	40	39	40	39	35	43	43	42	33	34
	WORKING SPEED (MM/MIN)	14	14	14	12	13	14	14	14	10	8	14	16	12	12	13
REMARK	$\text{WEAR PERCENT : } \frac{\text{Z DISTANCE - WORKING HEIGHT}}{\text{WORKING HEIGHT}} \times 100\%$															
	WATER PURITY : BETWEEN 10 K AND 20 K															

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TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	1.5														
WORKING CONDITION	ON TIME	20	25	30	35	40	20	25	30	35	40	20	25	30	35	40
	OFF TIME	15	15	15	15	20	15	15	15	15	20	15	15	15	15	20
	CURRENT	14	14	14	14	14	14	14	14	14	14	14	14	14	14	14
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	15	16	17	18	18	15	16	18	19	18	15	17	18	19	18
	ELECTRODE WEAR (%)	46	45	44	42	43	44	45	45	43	44	49	49	39	47	47
	WORKING SPEED (MM/MIN)	14	15	13	13	11	17	14	14	11	11	15	10	10	14	16
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT :	$\frac{\text{WORKING HEIGHT}}{\text{Z DISTANCE - WORKING HEIGHT}} \times 100\%$														
	WATER PURITY : BETWEEN 10 K AND 20 K															

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TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	1.5														
WORKING CONDITION	ON TIME	20	25	30	35	40	20	25	30	35	40	20	25	30	35	40
	OFF TIME	15	15	15	15	20	15	15	15	15	20	15	15	15	15	20
	CURRENT	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	50	50	50	50	50	75	75	75	75	75	100	100	100	100	100
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9	6-9
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	16	17	19	20	19	15	17	18	20	19	15	17	18	19	18
	ELECTRODE WEAR (%)	46	46	44	43	43	43	44	44	42	42	44	44	41	43	44
	WORKING SPEED (MM/MIN)	14	15	14	14	13	16	14	15	14	13	16	15	15	16	17
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT : $\frac{\text{WORKING DEPTH}}{\text{WORKING HEIGHT}} \times 100\%$															
REMARK	WATER PURITY : BETWEEN 10 K AND 20 K															

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TECHNOLOGY TABLE

APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	2.0														
WORKING CONDITION	ON TIME	25	30	35	40	45	25	30	35	40	45	25	30	35	40	45
	OFF TIME	15	15	15	20	20	15	15	15	20	20	15	15	15	20	20
	CURRENT	13	13	13	13	13	13	13	13	13	13	13	13	13	13	13
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	25	25	25	25	25	50	50	50	50	50	75	75	75	75	75
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	13	15	16	16	17	13	15	16	15	16	13	15	16	16	17
	ELECTRODE WEAR (%)	22	26	27	27	26	40	39	36	35	34	44	38	37	35	37
	WORKING SPEED (MM/MIN)	7.6	8.9	10	6.9	7.5	8.1	8.6	7.7	8.8	8.7	6.8	7.8	8.1	8.2	7.9
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT : $\frac{\text{WORKING HEIGHT}}{\text{Z DISTANCE - WORKING HEIGHT}} \times 100\%$															
REMARK	WATER PURITY : BETWEEN 15 K AND 30 K															

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TECHNOLOGY TABLE

APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	2.0														
WORKING CONDITION	ON TIME	30	35	40	45	50	30	35	40	45	50	30	35	40	45	50
	OFF TIME	15	15	20	20	20	15	15	20	20	20	15	15	20	20	20
	CURRENT	14	14	14	14	14	14	14	14	14	14	14	14	14	14	14
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	25	25	25	25	25	50	50	50	50	50	75	75	75	75	75
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	16	18	16	18	18	16	18	16	18	19	16	18	17	18	19
	ELECTRODE WEAR (%)	31	30	31	34	34	38	37	39	38	35	41	36	40	38	37
	WORKING SPEED (MM/MIN)	8.6	11	8.9	7.8	10	6.9	7.2	7	6.3	7.8	6	5.5	6.5	8.8	7.8
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT : $\frac{\text{WORKING HEIGHT}}{\text{Z DISTANCE - WORKING HEIGHT}} \times 100\%$															
REMARK	WATER PURITY : BETWEEN 15 K AND 30 K															

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TECHNOLOGY TABLE

APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	2.0														
WORKING CONDITION	ON TIME	30	35	40	45	50	30	35	40	45	50	30	35	40	45	50
	OFF TIME	15	15	20	20	20	15	15	20	20	20	15	15	20	20	20
	CURRENT	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15
	CAPACITOR	0	0	0	0	0	0	0	0	0	0	0	0	0	0	0
	GAP	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	25	25	25	25	25	50	50	50	50	50	75	75	75	75	75
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	18	20	19	20	20	18	20	19	20	20	20	20	18	20	20
	ELECTRODE WEAR (%)	38	36	28	31	36	41	40	40	38	38	41	37	40	41	40
	WORKING SPEED (MM/MIN)	5.9	5.6	5	5.8	7.4	6.8	7.9	6.9	6.5	7.5	6.9	6.3	6.4	6.6	7.5
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT : $\frac{\text{WORKING HEIGHT}}{\text{Z DISTANCE - WORKING HEIGHT}} \times 100\%$															
REMARK	WATER PURITY : BETWEEN 15 K AND 30 K															

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TECHNOLOGY TABLE

APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	2.5														
WORKING CONDITION	ON TIME	35	40	45	50	55	35	40	45	50	55	35	40	45	50	55
	OFF TIME	15	20	20	20	20	15	20	20	20	20	15	20	20	20	20
	CURRENT	14	14	14	14	14	14	14	14	14	14	14	14	14	14	14
	CAPACITOR	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2
	GAP	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	25	25	25	25	25	50	50	50	50	50	75	75	75	75	75
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	18	18	20	20	21	22	22	23	23	23	22	22	22	22	23
	ELECTRODE WEAR (%)	26	26	24	25	23	27	32	26	25	27	28	28	26	24	24
	WORKING SPEED (MM/MIN)	4.4	3.8	4.0	4.5	4.0	3.6	3.7	2.9	3.5	4.1	2.9	2.6	3.1	3.4	3.6
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT :	$\frac{\text{WORKING HEIGHT}}{\text{WORKING HEIGHT}} \times 100\%$														
	WATER PURITY : BETWEEN 15 K AND 30 K															

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TECHNOLOGY TABLE

APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	2.5														
WORKING CONDITION	ON TIME	35	40	45	50	55	35	40	45	50	55	35	40	45	50	55
	OFF TIME	15	20	20	20	20	15	20	20	20	20	15	20	20	20	20
	CURRENT	14	14	14	14	14	14	14	14	14	14	14	14	14	14	14
	CAPACITOR	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2
	GAP	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1	3.1
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	25	25	25	25	25	50	50	50	50	50	75	75	75	75	75
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	18	18	20	20	21	22	22	23	23	23	22	22	22	22	23
	ELECTRODE WEAR (%)	26	26	24	25	23	27	32	26	25	27	28	28	26	24	24
	WORKING SPEED (MM/MIN)	4.4	3.8	4.0	4.5	4.0	3.6	3.7	2.9	3.5	4.1	2.9	2.6	3.1	3.4	3.6
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT :	$\frac{\text{WORKING DEPTH}}{\text{WORKING HEIGHT}} \times 100\%$														
	WATER PURITY : BETWEEN 15 K AND 30 K															

CORISMA MACHINE TOOL CO., LTD.

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DRILLING EDM TECHNOLOGY TABLE

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REV

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TECHNOLOGY TABLE																
APPLICATION	WORKPIECE	SKD-11														
	ELECTRODE PIPE	BRASS														
	PIPE DIA	2.5														
WORKING CONDITION	ON TIME	35	40	45	50	55	35	40	45	50	55	35	40	45	50	55
	OFF TIME	15	20	20	20	20	15	20	20	20	20	15	20	20	20	20
	CURRENT	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15
	CAPACITOR	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2
	GAP	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5
	PRESSURE (KG)	25	25	25	25	25	50	50	50	50	50	75	75	75	75	75
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25														
	WORKING CURRENT (A)	22	22	22	23	23	21	20	21	22	23	21	20	20	21	22
	ELECTRODE WEAR (%)	24	27	26	25	25	28	31	35	27	28	30	26	26	31	25
	WORKING SPEED (MM/MIN)	5.0	4.0	4.4	5.6	4.8	5.2	4.7	4.8	4.9	5.1	5.6	5.6	4.8	4.6	5.0
REMARK	Z DISTANCE - WORKING HEIGHT															
	WEAR PERCENT :	$\frac{\text{WORKING DEPTH}}{\text{WORKING HEIGHT}} \times 100\%$														
	WATER PURITY : BETWEEN 15 K AND 30 K															

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DRILLING EDM TECHNOLOGY TABLE

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of

TECHNOLOGY TABLE

APPLICATION	WORKPIECE	SKD-11															
	ELECTRODE PIPE	BRASS															
	PIPE DIA	3.0															
WORKING CONDITION	ON TIME	35	40	45	50	55	35	40	45	50	55	35	40	45	50	55	
	OFF TIME	15	20	20	20	20	15	20	20	20	20	15	20	20	20	20	
	CURRENT	15	15	15	15	15	15	15	15	15	15	15	15	15	15	15	
	CAPACITOR	2	2	2	2	2	2	2	2	2	2	2	2	2	2	2	
	GAP	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	3.2	
	SPEED	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	2.5	
	PRESSURE (KG)	25	25	25	25	25	50	50	50	50	50	75	75	75	75	75	
	SMALL	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	OFF	
	SPINDLE SPEED	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	5-7	
	WORKING DEPTH (mm)	20	20	20	20	20	20	20	20	20	20	20	20	20	20	20	
PERFORMANCE	WORKING VOLTAGE (V)	20 ~ 25															
	WORKING CURRENT (A)	21	20	21	22	22	21	20	22	22	22	21	20	21	21	22	
	ELECTRODE WEAR (%)	22	26	21	24	24	27	31	27	24	25	29	32	30	30	28	
	WORKING SPEED (MM/MIN)	3.8	3.2	3.6	3.7	4.0	3.9	3.8	3.7	4.0	4.1	3.9	3.8	4.2	4.2	4.4	
REMARK	Z DISTANCE - WORKING HEIGHT																
	WEAR PERCENT : $\frac{\text{WORKING HEIGHT}}{\text{WORKING HEIGHT}} \times 100\%$																
REMARK	WATER PURITY : BETWEEN 15 K AND 30 K																

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DRILLING EDM TECHNOLOGY TABLE

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Anotronic-SKM EDMs
Manual, ZNC, CNC



Anotronic-Ocean
EDM Drilling Machines
Manual, ZNC, CNC



CNC Wire EDM Sub-Contract
On The Latest Technology
Machines



Anotronic Electrochemical
Deburring Machines (ECD)



Multi axis CNC Turning



Fully Automated 5axis cnc Milling



CNC CMM inspection



5axis cnc Milling



- Full High capacity Machine Shop including fully Automated 5axis cnc Milling, Multi axis CNC Turning, Grinding etc.
- Laser Part marking
- CNC CMM inspection
- Sale of Standard Electric Discharge Machines (Manual, ZNC & CNC) to take components up to 2500mm x 1200mm x 700mm.
- Design, Manufacture & Sale of Electrochemical Deburring Machines (ECM)
- Comprehensive After Sales Service.
- Design, Manufacture & Sales of EDM & ECM Tooling and Electrodes.
- Multi axis CNC EDM & ECM Sub-Contract Service.
- ECM Sub-Contract Service.
- Wire EDM Sub-Contract Service with cutting areas up to 500mm x 320mm x 420mm HIGH.
- EDM small hole drilling Machines and Sub-Contract Service.
- EDM/ECM Consultancy Service.



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