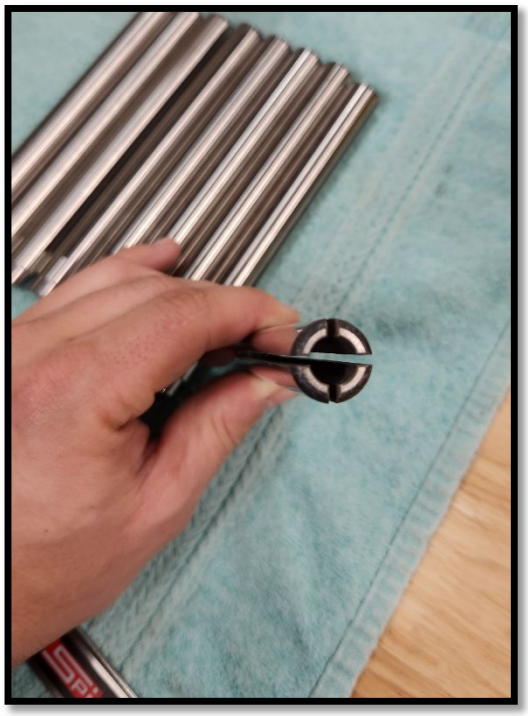
EDM PERFORMANCE ACCESSORIES

HB Series EDM Case Study

Die Pin Slotting



Application: Simple pin slotting operation that the customer traditionally did with a brass EDM. These pins where made with D2 tool steel and then needed expansion slits cut down the middle. 5.2" long slot at .080" wide. This cut was averaging about .320" per minute on a brass EDM to mitigate wire breaks. Approximately 32 minutes per slot.

The customer set this job up on a HB400. The tolerance of +/-.005" was easily held and the wire cut speed was maintained at .600" per minutes. The machine would burn even faster but they didn't want to sacrifice the surface finish and edge quality.

The total operation was completed in approximately 16 minutes per cut, 32 minutes per part. Doubling the cut speed and cutting the cut cost by 90%. This also allowed the brass EDM's to remain open for work better suited for that technology.

Machine: HB400

Cut Time: 16 minutes per slot (50% reduction)

Cut Cost: $0.40-.050 each (90%+ reduction)

Wire: .007" Molybdenum

Fixturing/Set-up Time: Under 5 minutes.

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