

HB Series EDM Case Study

Large Collet Production

Application: Customer was tasked with machining a large collet style part. The part had a fairly robust and heavy clapping section and a very thinned out and lighter base section. This was proving to be very challenging to machine traditionally.

The customer opted to use there HB800 Moly Cut EDM as a secondary operation. He first created a turned blank with 3 threaded mounting holes. This finished all the external faced of the part. The part was then mounted into an indexer where the pictured cut profile was repeated 3 times for a total of 6 equally spaced openings. Once finished the part was simple cut from the base and it was complete.

The total operation was completed in under an hour including indexing time.

Machine: HB800

Cut Time: 45-50 minutes, including indexing

Cut Cost: \$1.00 per part

Wire: .007" Molybdenum

Fixturing/Set-up Time: Under 10 minutes.

