

## ***HB Series EDM Case Study***

### **Part Blanking**

**Application:** CNC Machining vs EDM Blank. This customer had a batch of large parts to manufacture for heavy equipment weldments. The parts were both steel and aluminum and had basic shapes with fairly loose +/- .020" tolerances. While fairly easy to CNC machine traditionally they had other issues facing the project. All CNC machines in the shop were busy, they had little to no operator time available for months, and the project was also very tight on margin and the tooling costs for the steel parts would be substantial.

They approached us about using their HB600 Moly Cut EDM to produce the parts. Programming was simple using just basic DXF files for the wire paths and the Holes required a start hole but could quickly be manually threaded. While cut times were long the machines would run all day and over night with minimal need for operators.

The picture shown is about 1/2 of the parts in this project. They completed the entire project in 6 working days, with the vast majority of the work being done unattended in the machine during the day and overnight. Programming time was under 1 hour for all parts combined and operators were needed machine side for about 3-4 hours total throughout the week to pull slugs or set up the next part.



**Machine:** HB600

**Cut Time:** 85 hours total project time (95% unattended run time)

**Cut Cost:** \$200 or less for the whole project (Assuming worst case \$2.35 per hour running cost)

**Wire:** .007" Molybdenum

**Fixturing/Set-up Time:** 3-4 hours total