

FX Series

WIRE-CUT EDM SYSTEMS

MACHINING CHARACTERISTICS DATA BOOK

BQN-W-70207-D

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6.1 Standard Finishing Machining	
Die Steel (SKD11) Brass wire $\varnothing 0.2\text{mm}$ (5~100mmt)	B-1~B-11
	$\varnothing 0.25\text{mm}$ (5~150mmt)
	$\varnothing 0.3\text{mm}$ (40~250mmt)
Tungsten Carbide Brass wire $\varnothing 0.2\text{mm}$ (5~70mmt)	B-38~B-45
(WC-Co)	$\varnothing 0.25\text{mm}$ (5~70mmt)
Copper (Cu) Brass wire $\varnothing 0.2\text{mm}$ (5~100mmt)	B-54~B-64
	$\varnothing 0.25\text{mm}$ (5~150mmt)
	$\varnothing 0.3\text{mm}$ (40~150mmt)
Aluminum Brass wire $\varnothing 0.2\text{mm}$ (5~100mmt)	B-87~B-97
	$\varnothing 0.25\text{mm}$ (5~150mmt)
	$\varnothing 0.3\text{mm}$ (40~250mmt)
6.2 Finishing machining for accuracy priority	
Die Steel (SKD11) Brass wire $\varnothing 0.2\text{mm}$ (5~60mmt)	B-124~B-130
	$\varnothing 0.25\text{mm}$ (20~100mmt)
6.3 Finishing machining for speed priority	
Die Steel (SKD11) Brass wire $\varnothing 0.2\text{mm}$ (5~100mmt)	B-138~B-148
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Die Steel (SKD11) Brass wire $\varnothing 0.2\text{mm}$ (5~60mmt)	B-149
	$\varnothing 0.25\text{mm}$ (5~60mmt)
Tungsten Carbide Brass wire $\varnothing 0.2\text{mm}$ (5~60mmt)	B-151
(WC-Co)	$\varnothing 0.25\text{mm}$ (5~60mmt)
6.5 Fine wire finishing machining (option)	
Die Steel (SKD11) Brass wire $\varnothing 0.1\text{mm}$ (3~30mmt)	B-153~B-157
	$\varnothing 0.15\text{mm}$ (3~40mmt)
Tungsten Carbide Brass wire $\varnothing 0.1\text{mm}$ (3~30mmt)	B-164~B-168
(WC-Co)	$\varnothing 0.15\text{mm}$ (3~40mmt)

※ The $\varnothing 0.1$ and $\varnothing 0.15$ specifications are options (later installation is possible).

SUPPLEMENTARY MATERIAL 1:

PM Machining Know-how Collection	C-1~C-5
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