

---

**AGIE**  
AGIECUT F HSS

**K11.6**  
EDM cutting with fine wires

**10.96**

---

AGIE  
CH-6616 Losone  
Tel.: + +41 / 91 / 806 91 11  
Telex: 84 61 71 agie ch  
Fax: + +41 / 91 / 806 92 60, Training center: 806 94 61, Diagnostic: 806 93 47

# Table of Contents

This documentation is valid from  
FW 13 for the following systems:  
AGIECUT 150 F HSS  
AGIECUT 250 SF +F HSS

<b>1</b>	<b>Introduction</b>	<b>3</b>
1.1	Accessories box + F	4
<b>2</b>	<b>Use of the system</b>	<b>5</b>
2.1	Preparation	5
2.1.1	Degreasing points of contact of the wire	5
2.1.2	Replacing the pressure wheel	6
2.1.3	Replacing the wire disposal unit	7
2.1.4	Demagnetization of the brake	9
2.1.5	Mounting the counterspring (150 F only)	9
2.1.6	Adjusting the brake	10
2.1.7	Modifications to the upper head	11
2.1.8	Modifications to the lower head	12
2.1.9	Replacing the weights on the jockey rollers	13
2.1.10	Adjusting the nozzle for threading in holes $\varnothing \geq 0,4$ mm	14
2.2	Erosion parameters	15
2.2.1	Setting the wire tension	15
2.2.2	Check parameter ACO	15
2.3	Last preparations	16
2.3.1	Drawing in the wire	16
2.3.2	Aligning the wire	17
2.3.3	Centering the wire in the start hole	17
<b>3</b>	<b>Programming</b>	<b>19</b>
<b>4</b>	<b>Planning tables</b>	<b>20</b>
4.1	Steel	21
4.2	Carbide	21
<b>5</b>	<b>Spare parts</b>	<b>23</b>