

MITSUBISHI

WIRE CUT ELECTRIC DISCHARGE MACHINE

〈F-1 Series〉

OPERATION MANUAL-2

GENERAL CONTENTS

A ... ELECTROMAGNETIC INTERFERENCE OF ELECTRIC DISCHARGE
MACHINE AND COUNTERMEASURES

B ... OPTION

1. TAPER MACHINING EQUIPMENT
2. AUTOMATIC WIRE FEED DEVICE
3. AUTOMATIC SECOND CUT
4. INTERSECTION CALCULATION TYPE OFFSET PROCESSING
CNC CONTROL
5. CRT DISPLAY

A ELECTROMAGNETIC INTERFERENCE OF ELECTRIC
DISCHARGE MACHINE AND COUNTERMEASURES

CONTENTS

	PAGE
1. OCCURRENCE OF ELECTROMAGNETIC INTERFERENCE	1
2. PROPAGATION ROUTE OF DISTURBING WAVE	4
3. ELECTROMAGNETIC INTERFERENCE AND CONDITIONS OF INSTALLATION OF WIRE-CUT ELECTRIC DISCHARGE MACHINE	5
4. PREVENTING METHOD OF ELECTROMAGNETIC INTERFERENCE	8
4.1 Examination of Installing Place of Machine	8
4.2 Examination of Receiving Position	9
4.3 Shielding Cover of Work Tank	11
4.4 Shielded Room	11
(1) Selection of materials	12
(2) Entrance and exit of shielded room	14
(3) Construction of joints	16
(4) Earth of shielded room	18
(5) Shielding of floor	18
(6) Size of shielded room	21
4.5 Dust-Proof Chamber which Doubles as Shielded Room (thermostatic chamber)	23
4.6 Installation of Line Filter	27

	PAGE
5. LAWS AND REGULATIONS RELATED TO ELECTRO- MAGNETIC INTERFERENCE	31
5.1 Wireless and Telegraph Act	32
5.2 Enforcement Regulations of the Wireless and Telegraph Act	34
5.3 Regulations for Radio Equipment	35
6. WORK EXECUTION EXAMPLES OF SHIELDED ROOM	37
(Photos)	

B OPTION

1 TAPER MACHINING EQUIPMENT

CONTENTS

	PAGE
1. DESCRIPTION OF FUNCITON	1-1
2. TAPER DIMENSIONS	1-17
3. MEASURING METHOD OF UPPER GUIDE SPAN (Z_3) AND LOWER GUIDE SPAN (Z_4)	1-18
3.1 Measuring Points and the Equations	1-18
3.2 Operating Procedure and Calculation Method	1-20
4. SETTING OF DIMENSIONS DURING TAPER MACHINING	1-26
4.1 Setting of Programmed Height Dimension (Z_1)	1-26
4.2 Setting the Height at Feed Rate (Z_2)	1-27
4.3 Setting the Upper Guide Span (Z_3)	1-28
4.4 Setting the Lower Guide Span (Z_4)	1-29
4.5 Setting Method of Taper Angle A	1-29
5. TAPER DIMENSIONS ENTRY METHOD	1-31
6. PLOT CHECK METHOD	1-32
7. ENTRY OF ANGLE $+A$ ACCORDING TO OFFSET DIRECITON	1-34
8. PRECAUTIONS FOR PROGRAMMING	1-35
8.1 To Return Inclined Wire to Perpendicular State after Completion of Machining	1-35
8.2 Machining Advance Direction Should be Perpendicular to the Shape	1-36

8.3	Limitations in the Corner R Machining	1-36
8.4	Limitations on In-Corner/Out-Corner R	1-38
8.5	Determination of the Corner R to Present Undercut	1-39
8.6	Angle Change in Taper Machining	1-40
8.7	Distance Required for Angle Change on Straight Line	1-41
8.8	Typical Distance Program Required for Angle Change on the Straight Line	1-43
9.	MACHINING PROCEDURE	1-44
10.	SAME UPPER/LOWER R FOR TAPER CUT (OPTION)	1-50

2 AUTOMATIC WIRE FEED DEVICE

CONTENTS

1.	DESCRIPTION OF OPERATION	2-1
1.1	Outline	2-1
1.2	Automatic Wire Supply Device Specifications	2-3
1.3	Construction of Automatic Wire Feed Device	2-5
1.4	Automatic Wire Feed Device Operation Panel	2-7
1.5	Explanation of Programming	2-13
1.6	Operating Procedure	2-22
1.7	Maintenance and Inspection	2-53
2.	EXPLANATION OF PROGRAMMING	2-82
2.1	Programming Method	2-82
2.2	Application of Programming	2-98
2.3	Machining Method	2-110

3 AUTOMATIC SECOND CUT

CONTENTS

	(page)
1. DESCRIPTION OF OPERATION	3-1
1.1 OUTLINE	3-1
1.2 DESCRIPTION OF FUNCTIONS	3-2
1.3 STANDARD MACHINING CONDITION PATTERN	3-7
1.4 MACHINING METHOD	3-10
1.5 EXPLANATION OF PROGRAM	3-11
1.6 EXAMPLES OF MACHINING CONDITION PATTERNS	3-20
1.7 CAUTIONS	3-21

4 INTERSECTION CALCULATION TYPE OFFSET

PROCESSING CNC CONTROL

CONTENT

	(page)
1. GENERAL	4-1
2. START OF TOOL RADIUS COMPENSATION	4-2
3. OPERATION IN THE TOOL RADIUS COMPENSATION MODE	4-4
4. CANCEL OF TOOL RADIUS COMPENSATION	4-7
5. OPERATION WHEN THERE IS NO INTERSECTION BETWEEN CIRCLE AND STRAIGHT LINE (CIRCLE)	4-10
6. ADVANCED READING PROCESSING DURING TOOL RADIUS COMPENSATION	4-11
7. PRECAUTIONS FOR TOOL RADIUS COMPENSATION	4-12

5 CRT DISPLAY

CONTENTS

	Page
1. INTRODUCTION	5-1
2. CRT OFF	5-5
3. COMMAND	5-5
4. MDI-SET	5-8
5. SETTING	5-10
6. POSITION	5-14
7. OFFSET	5-17
8. MEMORY SEARCH	5-18
9. EDIT	5-20
10. MEMORY CYCLE	5-24
11. MEMORY CYCLE SEARCH	5-25
12. SELF-DIAGNOSIS FUNCTION	5-27