

**NC ELECTRICAL DISCHARGE MACHINE**

**EDGE**

**INSTRUCTION MANUAL**

**(MECHANICAL EDITION)**

**MAKINO MILLING MACHINE CO., LTD.**

**ED8-M1-9107(E)**

## CONTENTS

1. GENERAL .....	1-1
1.1 Name and Function of Each Unit .....	1-1
1.1.1 Name of each unit .....	1-1
1.1.2 Function of each unit .....	1-2
2. SPECIFICATIONS .....	2-1
2.1 Machine Main Unit .....	2-1
2.2 Automatic Fire Extinguisher .....	2-2
2.3 Dielectric Fluid Supply Unit .....	2-2
2.3.1 Dielectric fluid supply unit .....	2-2
2.3.2 Dielectric fluid cooling unit (optional) .....	2-2
2.4 Dimensional Drawings .....	2-3
2.4.1 External dimensions .....	2-3
2.4.2 Table and work tank .....	2-4
2.4.3 Electrode attachment plate .....	2-5
2.4.4 Universal holder .....	2-6
2.4.5 Flushing and suction flange (optional) .....	2-7
3. ACCESSORIES .....	3-1
3.1 Standard Accessories .....	3-1
3.2 Optional Accessories .....	3-3
4. MACHINE INSTALLATION .....	4-1
4.1 Installation Place Requirements .....	4-1
4.2 Foundation .....	4-1
4.3 Power Supply Facility .....	4-1
4.4 Layout .....	4-2
5. PREPARATION BEFORE OPERATION .....	5-1
5.1 Wiping off Rust-Preventive Oil .....	5-1
5.2 Unclamping Dielectric Fluid Supply Unit .....	5-1
5.3 Supplying Dielectric Fluid .....	5-2
6. OPERATION .....	6-1
6.1 Precaution to Prevent Fire .....	6-1
6.1.1 Kind of dielectric fluid and fluid level .....	6-1

6.1.2	Safety devices .....	6-1
6.1.3	Working environment .....	6-2
6.2	Safety Precautions .....	6-2
6.3	Handling of Main Components .....	6-3
6.3.1	Power supply unit .....	6-3
6.3.2	Portable operation panel .....	6-4
6.4	Dielectric Fluid Control Unit .....	6-9
6.5	Dielectric Fluid Supply Unit .....	6-10
6.6	Automatic Fire Extinguisher .....	6-14
7.	MACHINING .....	7-1
7.1	Precautions on Machining .....	7-1
7.1.1	Inhibition of blow machining .....	7-1
7.1.2	Machining near fluid level .....	7-1
7.1.3	Supervising during automatic operation .....	7-1
7.1.4	Fire accident cases by electric discharge machines .....	7-1
7.2	Preparation of Machining .....	7-2
7.2.1	Installation of electrode .....	7-2
7.2.2	Installation of workpiece .....	7-2
8.	INSPECTION .....	8-1
8.1	Inspection before Operation .....	8-1
8.2	6-Month Inspection .....	8-2
8.2.1	Dielectric fluid temperature sensor .....	8-2
8.2.2	Automatic fire extinguisher .....	8-3
8.2.3	Inspection of machine leveling .....	8-5
8.3	Yearly Inspection .....	8-6
8.3.1	Automatic fire extinguisher .....	8-6
8.3.2	Dielectric fluid supply unit .....	8-6
9.	MAINTENANCE .....	9-1
9.1	Dielectric Fluid Supply Unit .....	9-1
9.1.1	Filter replacement .....	9-1
9.1.2	Cleaning of aspirator .....	9-1
9.2	Automatic Fire Extinguisher .....	9-3
9.2.1	Container replacement .....	9-3