

MACHINING CHARACTERISTICS
DATA BOOK 1

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a) Brass Wire	0.1 mm (5 to 40 mm t)	23
b) Brass Wire	0.15 mm (5 to 60 mm t)	29
c) Brass Wire	0.2 mm (5 to 100 mm t)	37
d) Brass Wire	0.25 mm (5 to 100 mm t)	51
e) Brass Wire	0.3 mm (40 to 100 mm t)	68
f) Brass Wire	0.33 mm (60 mm t)	74

5-2 Copper (Cu)

a) Brass Wire	0.2 mm (5 to 100 mm)	76
b) Brass Wire	0.25 mm (5 to 100 mm)	90
c) Brass Wire	0.3 mm (40 to 100 mm)	104

5-3 Tungsten Carbide (WC-CO)

1) Brass Wire	0.1 mm (5 to 30 mm t)	115
2) Brass Wire	0.15 mm (5 to 50 mm t)	120
3) Brass Wire	0.2 mm (5 to 60 mm t)	127
4) Brass Wire	0.25 mm (5 to 60 mm t)	137

5-4 Hot Work Tool Steel

a) Die Steel (SKD-11)	Brass Wire	0.25 mm (125 - 250 mm t)	146~154
b) Die Steel (SKD-11)	Brass Wire	0.3 mm (125 - 250 mm t)	155~161

MACHINING CHARACTERISTICS
DATA BOOK 2

MITSUBISHI Wire-Cut EDM System "C-1" Series

Machining Conditions Data for Automatic Second Cut

This machining Conditions Table covers machining conditions for automatic second-cut functions. It is suggested that data be used for your standard second-cut operation. Accordingly it is further suggested that you use data after corrections when offset amount differs according to such factors as machined shape and setting circumstances. Also, hot work tool steel data can apply to other steel. If thickness of workpieces are not found in the Table, please use data applicable to those that are one size larger or smaller than such thicknesses.

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<Brass Wire 0.25 mm dia.>

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Hot work tool steel 50 mm t	21
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<Brass wire 0.2 mm dia.>

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