

FA-S Series

WIRE-CUT EDM SYSTEMS

BRN-66372-*

CHAPTER 1 OUTLINE OF MACHINE

1-1 Configuration	1-1
1-2 Specifications	1-3
1-2-1 Machine Unit	1-3
1-2-2 Power Supply Section, Control Unit Section Specifications (Common for all models)	1-3
(1) Power supply section (WFAV)	1-3
(2) Control unit section (W21FAV-2)	1-4
(3) Automatic wire feeder AT	1-5
1-3 Installation	1-6
1-3-1 Installation Layout	1-6
1-3-2 Installation Location	1-6
1-3-3 Power Supply	1-6
(1) Primary power wiring	1-6
(2) Grounding	1-6
(3) Shielded room	1-7
1-3-4 Dimensional Outline Drawing	1-8
1-3-5 Radio Frequency Interference Caused by Wire-Cut EDM System and Its Preventive Measures ..	1-12
(1) Occurrence of radio frequency interference	1-12
(2) Propagation route of radio frequency interference	1-13
(3) Radio frequency interference caused by wire-cut EDM systems and installation conditions	1-13
(4) How to prevent radio frequency interference	1-14
① System installation location selection	1-14
② Locating television receivers	1-14
③ Insulation cover for the working tank	1-15
④ Shielded room	1-15
1) Selection of materials	1-15
2) Doorway of shielded room	1-16
3) Joint section structure	1-17
4) Shielded room grounding	1-18
5) Floor insulation	1-18
6) Dimensions of shielded room	1-19
⑤ Shielded room serving also as dustproof room (Constant temperature room)	1-19
⑥ Installation of line filter	1-21
(5) Regulations related to radio frequency interference	1-23
① About EMC directive conformity for CE marking	1-23
1-3-6 Waste Fluid Treatment	1-23
1-4 Operation Panel	1-24
1-4-1 Outline of Operation Panel	1-24
1-4-2 Lamps and Operation Keys	1-25
1-4-3 Basics of Inputting Data	1-29
① Changing the screen	1-29
② Using the overlap window	1-29
1-4-4 Inputting Data	1-32
1-5 Machine System	1-38
1-5-1 Names and Functions of The Components	1-38
1-5-2 Mounting the Workpiece	1-38
1-5-3 Specifications of Automatic Wire Feeder	1-42
(1) Explanation of main functions	1-42
(2) Auxiliary functions for insertion	1-43
1-5-4 Mechanical System Standard Accessories	1-44

1-6 Dielectric Fluid Reservoir.....	1-45
1-6-1 Major Component Names.....	1-45
1-6-2 Dielectric Fluid Reservoir Operation.....	1-48
(1) Resistivity adjustment & operation	1-48
(2) Water purifier (Ion exchange resin)	1-49
(3) Replenishing dielectric fluid	1-49
(4) Replacing filter element.....	1-51
(5) Water drainage (Freeze prevention measure)	1-52
1-6-3 Dielectric Fluid Temperature Control Unit.....	1-52
(1) Outline	1-52
(2) For Safe Use	1-53
(3) Specifications.....	1-54
(4) Names and Functions of Each Part.....	1-54
① Outline	1-55
② Display section	1-56
③ Various sensors	1-56
④ Dielectric fluid path diagram	1-57
⑤ Electrical wiring diagram	1-58
(5) Precaution for Installation Work.....	1-58
① Installing the exhaust duct.....	1-59
(6) Precaution for Use.....	1-59
(7) Other Functions	1-60
(8) Installing Outside a Constant Temperature Room.....	

CHAPTER 2 BASIC OPERATIONS

2-1 Flow of Operations.....	2-1
2-2 Turning the Power ON	2-2
2-3 Loading the Data Supplied from the Maker	2-3
2-3-1 Loading the Pitch Error Compensation Amount, etc., Parameter Data.....	2-3
2-3-2 Loading the Maker-supplied Machining Conditions	2-4
2-4 Manually Moving the Axes	2-4
2-4-1 Manual Operation Box Keys used to Move the Axes	2-5
2-4-2 Basic Operations for Axis Movement	2-6
2-4-3 Details of Manual Operation Box Functions	2-9
2-4-4 High-function Manual Operation Box (option) Keys and Lamp Functions	
2-5 Preliminary Check.....	2-12
2-5-1 Checking the Diamond Die.....	2-13
2-5-2 Checking the Power Feed Terminal.....	2-15
2-5-3 Checking the Dielectric Fluid Nozzle.....	2-15
2-5-4 Checking the Tank Fluid Level.....	2-16
2-5-5 Checking the Specific Resistivity	2-16
2-5-6 Checking the Filter Pressure	2-17
2-5-7 Checking the Collection Roller Pressing Force	
2-6 Installing the Wire	2-18
2-6-1 Selecting the Wire	2-19
2-6-2 Threading the Wire	2-23
2-6-3 Setting the Wire Material and Wire Diameter screens	

2-7 Aligning the Wire.....	2-24
2-7-1 Installing the Wire Alignment Device	2-24
2-7-2 Aligning the Wire	2-25
2-8 Installing the Workpiece	2-27
2-8-1 Installing the Workpiece	2-27
2-8-2 Using the Clamp Jig	2-27
2-8-3 Installing the Workpiece	2-29
2-9 Positioning the Wire to the Workpiece	2-31
2-9-1 Positioning using the Workpiece Edge as Reference (Edge positioning)	2-31
2-9-2 Positioning using the Workpiece Machining Start Hole as Reference (Center positioning)	2-33
2-10 Inputting and Calling the Program	2-35
2-10-1 Inputting the Program	2-36
2-10-2 Calling the Program	2-39
2-11 Inputting the Machining Conditions.....	2-40
2-12 Preparing for Machining.....	2-41
2-12-1 Setting the Gap between the Upper Nozzle and Workpiece.....	2-41
2-12-2 Closing (opening) the Working Tank Door	2-43
2-12-3 Filling the Working Tank with Dielectric Fluid (discharging the fluid).....	2-46
2-13 Starting Machining.....	2-47
2-14 Ending Machining	2-49
2-15 Cleaning Each Machine Section.....	2-51
2-15-1 Cleaning the Working Tank.....	2-51
2-15-2 Cleaning the Seal Plate.....	2-52
2-15-3 Using the Washing Gun Nozzle.....	2-53
2-16 Turning the Power OFF.....	2-55

CHAPTER 3 APPLICATION OPERATION

3-1 Machining using the automatic wire feeder.....	3-1
3-1-1 Initially setting the wire electrode	3-1
3-1-2 Setting to the Automatic Wire Feeder.....	3-2
3-1-3 Automatically Inserting the Wire	3-4
3-1-4 Using the Automatic Wire Feeder.....	3-6
3-1-5 Automatic Wire Feeder Q&A	3-10
3-1-6 Machining Using Automatic Wire Feeder	3-13
3-2 Automatic Connection of the $\phi 0.1$ and 0.15 Wire.....	3-19
3-2-1 Specifications.....	3-19
3-2-2 Changeover items (When using $\phi 0.2$ to 0.36 wire $\Leftrightarrow$ when using $\phi 0.1$, 0.15 wire)	3-20
3-2-3 Settings for using $\phi 0.1$ diameter wire (Change from $\phi 0.2$ to 0.3 wire to 0.1 wire)	3-21
3-2-4 Settings for using $\phi 0.15$ diameter wire (Change from $\phi 0.2$ to 0.36 wire to 0.15 wire)	3-23
3-2-5 Settings for using $\phi 0.2$ or more diameter wire (Change from $\phi 0.1$ wire to 0.2 to 0.3 wire)	3-24

3-2-6	Settings for using $\phi 0.2$ or more diameter wire (Change from $\phi 0.15$ to 0.2 to 0.3).....	3-25
3-2-7	Limits	3-26
3-2-8	Cautions.....	3-26
3-3	Machining with adaptive control (AM)	3-27
3-3-1	What is Adaptive Control (AM)?	3-27
3-3-2	Machining with PM Control.....	3-28
(1)	What is PM control?	3-28
(2)	Setting PM control	3-28
(3)	Applicable ranges of PM control.....	3-28
(4)	PM mode	3-29
(5)	Applicable Usages of PM Control.....	3-31
(6)	Q & A	3-32
(7)	Example of machining with PM control	3-35
3-3-3	Machining with CM control	3-37
(1)	What is CM control?	3-37
(2)	Setting CM control	3-37
3-3-4	Machining with TM Control	3-38
(1)	What is the TM control?	3-38
(2)	TM setting method	3-38
3-3-5	Machining with EM Control.....	3-38
(1)	What is the EM control?	3-38
(2)	Types of EM functions	3-38
(3)	EM setting methods.....	3-38
(4)	Finely adjusting the approach point shape.....	3-39
3-4	Taper Machining.....	3-40
3-4-1	Specifications.....	3-40
3-4-2	Taper specifications	3-41
(1)	Input of Cutter Height, Plate Thickness and Guide Span	3-41
3-4-3	Setting Specifications for Taper Machining.....	3-43
(1)	Program Dimensions: Setting Height (Z1)	3-43
(2)	Setting of Feedrate Height (Z2)	3-43
(3)	Setting of Upper Guide Span (Z3)	3-44
(4)	Setting of Lower Guide Span (Z4)	3-44
(5)	Setting of Random Shape Height (Z5)	3-44
3-4-4	Settings for Taper Machining	3-45
(1)	Taper angle.....	3-45
(2)	Corner interpolation mode.....	3-45
(3)	Angle +A or -A by offset direction	3-46
(4)	Notes concerning program composition for taper machining.....	3-47
3-4-5	Example of Taper Machining (Using PM function)	3-50
3-5	Machining with E.S.P.E.R Light.....	3-52
3-5-1	What is E.S.P.E.R Light?	3-52
3-5-2	Flow of Operations using E.S.P.E.R Light	3-52
3-5-3	Example of Machining with E.S.P.E.R Light 1 (Punch shape - single part/2nd cut machining)	3-53
3-5-4	Example of machining with E.S.P.E.R Light 2 (Die shape - single part/2nd cut machining (Uncut/cutoff machining))	3-55
3-5-5	Example of Machining with E.S.P.E.R Light 3 (Open shape/2nd cut machining)	3-57
3-6	Machining with Condition Search	3-59

3-6-1	Setting Machining with Condition Search and Creating the NC Program	3-59
(1)	Precautions for creating the NC program for machining with condition search	3-59
(2)	Settings for Machining	3-59
(3)	Operation example	3-60
(4)	Confirming the machining shape	3-83
3-6-2	Machining Applications	3-85
(1)	Use together with automatic wire feeder	3-85
(2)	Using the automatic wire feeder and expanded A.W.F. function	3-89
3-6-3	Example of machining with condition search	3-93
(1)	Example of machining with condition search 1 (Punch shape - multiple parts/2nd cut machining)	3-93
(2)	Example of machining with condition search (Die shape - multiple part/2nd cut machining (Uncut/cutoff))	3-96
3-7	Machining using Functions to reduce Running Costs.....	3-98
3-7-1	Using the CS (Cost Save) Mode	3-98
3-7-2	Using the Automatic Fluid Ready OFF Mode	3-100
3-8	High-speed Rough Machining	3-102
3-8-1	High-speed Rough Machining Wire.....	3-102
3-8-2	Dielectric Fluid Nozzle	3-102
3-8-3	Gap between Dielectric Fluid Nozzle and Workpiece	3-102
3-8-4	Cleaning Each Section	3-102
3-8-5	Correspondence of AT Unit and Wire Processing Unit.....	3-103
3-8-6	Maximum Machining Speed	3-104
3-8-7	Drop In Machining Speed and Wire Breakage	3-104
3-8-8	Consumable Parts	3-104

CHAPTER 4 MACHINING TECHNOLOGY

4-1	Setting Machining Conditions	4-1
4-1-1	Names of Notches	4-1
4-1-2	E Pack, Offset Amount, Machining Speed (FA) Settings.....	4-2
4-2	Setting Machining Conditions for Different Wire Electrodes	4-3
4-2-1	Wire Electrode Materials	4-3
4-2-2	Wire Electrode Selection	4-3
4-2-3	Notch Setting and Wire Tension	4-5
4-2-4	Machining Condition Settings for Different Wire Electrode Diameters.....	4-6
4-2-5	Estimates of Machining Time per 1 Wire Bobbin	4-7
4-3	Machining Condition Settings for Different Workpieces	4-8
4-3-1	Machining Condition Settings for Different Workpieces	4-8
4-3-2	Notch Setting and Dielectric Fluid Resistivity	4-9
4-4	Increase of Machining Speed and Prevention of Wire Breakage.....	4-11
4-4-1	Precautions for Rough Machining	4-11
4-4-2	Machining Condition Settings for Stepped and Taper Machining.....	4-11
4-4-3	Avoiding Wire Breakage Due to Trouble	4-12
4-5	Increasing Machining Accuracy	4-15
4-5-1	How to Do Test Machining	4-15
4-5-2	Number of Machining Operations as Related to Surface Roughness and Dimensional Accuracy.	4-16
4-5-3	Adjustment of the Dielectric Fluid	4-17

4-5-4	How to Adjust Machining Conditions for Automatic 2nd Cut	4-18
4-5-5	Programming for the Random 2nd Cut	4-19
4-5-6	Effect of Machining Distortion on Accuracy	4-20
4-5-7	Heat Treatment of Workpieces	4-21
4-5-8	Machining Distortion in the Wire Electrical Discharge	4-22
4-6	How to Repeat Machining Manually when the Wire Breaks	4-24
4-6-1	Reconnecting with Manual Operations <Using the standard manual operation box>	4-24
4-6-2	How to Reconnect Wiring Manually <Using the manual operation box with counter display (option)>	4-26
4-6-3	How to Repeat Machining Manually	4-27
4-7	Peripheral Technology	4-29
4-7-1	Tools and Jigs	4-29
4-7-2	Preventing Dielectric Fluid Splashing (During non-submerged machining)	4-31

CHAPTER 5 NC OPERATION DISPLAY SCREEN

5-1	Setup	5-1
5-1-1	What is the WORKPIECE SETUP Screen?	5-1
5-1-2	Explanation of Each Menu	5-2
(1)	Positioning	5-2
(2)	Contact positioning	5-4
1)	Outline	5-4
2)	Explanation of each positioning method	5-5
M1	Corner positioning (CORNER-P)	5-5
M2	3-point center positioning (THREE POINT CENTER)	5-6
M3	Groove center positioning (GAP)	5-8
M4	Width center positioning (WIDTH)	5-10
M5	Edge positioning (EDGE)	5-11
M6	Hole center positioning (CENTER)	5-12
M7	Workpiece slope (WORK SLOPE)	5-14
(3)	Coordinate preset	5-15
(4)	Zero point (origin) return	5-18
(5)	Wire alignment/Taper specifications	5-20
1)	ALIGN W/GAUGE	5-20
2)	Electrical-discharge wire alignment/origin setting	5-22
3)	Setting the taper specifications	5-27
(6)	Setting the Z axis gap	5-29
(7)	Soft limit	5-31
5-2	E.S.P.E.R.	5-34
5-2-1	What is the E.S.P.E.R Screen?	5-34
(1)	Outline	5-34
(2)	Machining data and checking data	5-34
(3)	Changing the pages	5-36
5-2-2	Searching for the Machining Conditions	5-37
(1)	Operation procedures	5-37
(2)	"SETTINGS/AUTO PG1" page	5-38
1)	Explanation of menus	5-38

2) Explanation of setting items	5-41
3) HybridPack	5-45
(3) "AUTO PG2" page	5-62
1) Explanation of menus	5-62
2) Explanation of setting items	5-62
3) Carrying out pitch movement with program	5-65
5-2-3 To Not Search for the Machining Conditions	5-66
(1) Operation procedures	5-66
(2) "SETTING/AUTO PG1" page	5-66
1) Explanation of menus	5-66
2) Explanation of setting items	5-66
5-2-4 "PARAMETERS" page	5-68
(1) Explanation of menus	5-68
(2) Explanation of setting items	5-68
5-2-5 "PROG. CHECK/EST. TIME" page	5-71
(1) Outline	5-71
(2) Explanation of screen displays	5-71
1) Graphics	5-71
2) Machining estimate	5-76
(3) Main graphic operation procedures	5-77
(4) Explanation of menus	5-78
(5) Functions that can be simulated with graphic check	5-81
5-3 Monitor	5-82
5-3-1 Outline	5-82
5-3-2 Explanation of Menus	5-82
5-3-3 Explanation of Screens	5-90
(1) Graphics and setting area	5-90
(2) Machining results	5-92
(3) Setting the parameters	5-93
(4) VF monitor	5-94
(5) Program No.	5-95
5-4 Maintenance	5-100
5-4-1 Maintenance Information	5-100
(1) Work inspection monitor	5-100
1) Outline	5-100
2) Explanation of setting items	5-100
[1] REMAIN WIRE	5-100
(2) Total Time of Machining Condition	5-101
(3) AT maintenance guidance	5-102
1) [RETRY CRT] page	5-102
2) [MAINT TIMERS] page	5-104
5-4-2 Environment Settings (Preferences)	5-105
(1) AWF function list	5-105
1) Outline	5-105
2) Explanation of each function	5-109
1. FINE HO. INS.	5-109
2. JET OFF	5-110
3. RASE Z AT INS.	5-110
4. AUTO CLEANING	5-111
5. SUBMERGED CONNECTION	5-111
6. CUTTING CONDITIONS SETTING	5-111
7. WIRE STRAIGHT PROCESS	5-111
8. RETRACE W/ MACHINING	5-111

9. RETRACE SPEED	5-112
10. Function to prohibit retrace	5-113
11. E-CONTROL PARAM	5-116
12. INS W. AT W.B.	5-118
13. JET OFF	5-118
14. REVERSE PATH TO	5-119
15. Z PROTECTION	5-120
16. A.W.F. SKIP/BREAKAGE LIMIT/INSERT LIMIT	5-121
17. BYPASS RETRY Mode	5-123
18. UNCUT/CUT OFF	5-129
19. AVOID CONTACT	5-132
20. H850, H851: No. of skips/wire breakages read (There is no screen display)	5-133
21. H242: AWF MANUAL SELECTION (There is no screen display)	5-133
22. SEARCH AT WIRE BREAK POINT INSERTION OFF	5-133
23. Z AXIS MOVEMENT AT WIRE BREAK POINT INSERTION OFF	5-133
3) Examples of using AWF extension function according to state	5-134
(2) List of various switches	5-138
1) Outline	5-138
2) Explanation of setting items	5-139
(3) Environment Settings	5-151
1) Outline	5-151
2) Explanation of setting items	5-151
5-4-3 Management Information	5-156
(1) Status record	5-156
1) Outline	5-156
2) Explanation of screens	5-156
(2) VERSION	5-158
5-4-4 PITCH COMPE	5-159
5-4-5 MACHINE I/O	5-160
5-4-6 Positioning Parameters	5-161
(1) Outline	5-161
(2) Explanation of setting items	5-161
5-4-7 Updating the System	5-162
5-5 Overlap	5-163
5-5-1 E-PACK	5-163
(1) Outline	5-163
(2) Displaying an E-Pack	5-164
(3) Setting/releasing the E-Pack edit lock	5-166
(4) Editing data in an E-Pack	5-166
(5) Creating an E-Pack	5-167
1) Creating a new E-Pack	5-167
2) Copying an existing E-Pack	5-167
3) Current E-Pack copy	5-167
(6) Deleting an E-Pack	5-167
5-5-2 VARIABLE	5-168
(1) Outline	5-168
(2) Common variables	5-169
1) Displaying the common variables	5-169
2) Editing the common variables	5-170
3) List of common variables used with specific functions	5-171
(3) Local variables	5-172
(4) User variables	5-175
5-5-3 Program	5-177
(1) Outline	5-177

(2) Displaying a list of NC programs	5-178
(3) Setting/releasing the NC program edit lock.....	5-180
(4) Operating an NC program as a file.....	5-181
1) Replacing the file character strings	5-181
2) Copying a file.....	5-183
3) Deleting a file.....	5-183
(5) Editing an NC program	5-185
1) Outline	5-185
2) Opening the NC program editing screen.....	5-186
3) Editing the NC program	5-187
4) Saving the NC program	5-188
5) Closing the NC program editing screen	5-188
5-5-4 POSITION.....	5-189
(1) Explanation of screens	5-189
(2) Explanation of each coordinate value	5-190
5-5-5 Data I/O functions	5-191
(1) Outline	5-191
(2) Starting data input/output.....	5-193
(3) Canceling data input/output.....	5-193
(4) Operating data on a 3.5-inch floppy disk.....	5-194
(5) Setting FTP (This is an option function and may not be displayed in some cases)	5-196
(6) Communication parameters	5-197
(7) Data format	5-200
(8) HD I/O	5-202
1) I/O screen.....	5-202
2) HD screen.....	5-203
(9) Methods for converting data between 64-bit machine and conventional machine, MEDIAPT and MS20 using an FLD	5-205
1) Formats usable with each series	5-205
2) 64-bit machine ↔ 16-bit machine	5-205
3) 64-bit machine ↔ 32-bit machine	5-206
4) 64-bit machine ↔ MEDIAPT product.....	5-207
5) 64-bit machine ↔ MS-20 (CAD/CAM)	5-208

CHAPTER 6 PROGRAMMING

6-1 Introduction	6-1
6-2 Programming Procedure	6-2
6-3 Program Format	6-3
6-3-1 Program Codes	6-3
6-3-2 Program Format	6-3
(1) Words and addresses.....	6-3
(2) Block	6-3
(3) Programs	6-4
(4) NC Program Specification	6-4
6-3-3 Special Codes	6-4
(1) EOB (;) code	6-4
(2) EOR (%) code	6-4
(3) Significant information interval (label-skip function)	6-4
(4) Control out and control in comments (Putting comments)	6-4
(5) Block delete	6-5
6-3-4 Input Setting Unit	6-5
6-3-5 Decimal Point	6-6

6-3-6	Address Command Format List.....	6-7
6-4	Program Number L.....	6-9
6-5	Coordinate System	6-11
6-5-1	Coordinate Terms X, Y, U, V, I, and J	6-11
(1)	Axial direction and axial signs	6-11
(2)	Maximum command values per unit of input setting	6-11
6-5-2	Program Coordinate System	6-11
6-5-3	Coordinate System Setting (G92)	6-12
6-5-4	Position Command Procedure (G90, G91)	6-12
6-6	Move Command	6-14
6-6-1	Positioning and Rapid Traverse (G00)	6-14
6-6-2	Linear Interpolation (G01).....	6-15
6-6-3	Circular Interpolation (G02 and G03)	6-16
(1)	I, J command circular interpolation.....	6-16
(2)	R designation circular interpolation (G02,G03)	6-17
(3)	Q designation circular interpolation	6-18
(4)	Helical arc interpolation (G02.1, G03.1 and G69)	6-19
6-6-4	Zero Point Return	6-20
(1)	Machine zero point, and 2nd, 3rd, and 4th zero points	6-20
(2)	Dog-type zero point return (G60)	6-21
(3)	Zero point return (G28)	6-21
(4)	Zero point return (2nd, 3rd, and 4th) (G48)	6-22
(5)	Zero verification (G27)	6-22
6-6-5	Dwell (G04).....	6-23
6-7	Wire Diameter Compensation Function.....	6-24
6-7-1	Wire Diameter Compensation Function (G40, G41, G42)	6-24
(1)	Command format.....	6-24
(2)	Wire diameter compensation number (H Δ Δ Δ)	6-24
(3)	Start and end of wire diameter compensation.....	6-25
6-7-2	Program Wire Diameter Compensation Amount Setting and Transfer (G43 (H1 =))	6-29
6-7-3	Corner Processing Modes (G88 and G89)	6-30
(1)	Intersection point calculation mode (G89)	6-30
(2)	Corner R mode (G88)	6-45
6-7-4	Upper and Lower Identical R (G87), Upper and Lower Designation R (Q), and Center of Taper Plane (Z5) Designation (QI, QJ)	6-50
6-7-5	Undercutting Prevention by Wire Diameter Compensation (Interference check function)	6-57
1)	When the programmed route and wire center route obtained by an intersection point calculation move in opposite directions.....	6-57
2)	Inserted blocks interfere with each other	6-58
(1)	Other alarms in dealing with interference blocks (errors).....	6-59
1)	Where all the compensation vectors defining the inserted blocks are eliminated.	6-59
(2)	Conditions that validate the cutting prevention process (Interference check)	6-60
(3)	Limitations of interference checking by three-block advanced reading.....	6-63
(4)	Example of interference check function	6-63
(5)	"CMP ERROR CHECK" (interference stop) switch	6-64
6-8	Machining Support Function	6-65
6-8-1	Edge Plane Positioning (G29)	6-65
6-8-2	Hole Center Positioning (G30).....	6-67
6-8-3	Automatic Vertical Alignment (G78).....	6-69
6-8-4	Current Value Reading (G14)	6-71

6-8-5	Reading and Writing of Time Data (G43.1, G44.1)	6-72
6-8-6	Soft Limit (G63, G64)	6-73
6-9	Program Supporting Functions	6-74
6-9-1	Subprogram Control (G22 and G23)	6-74
(1)	Function and purpose	6-74
(2)	Subprogram	6-74
(3)	Execution of subprogram	6-75
(4)	Program skip function (G23)	6-78
6-9-2	Figure Rotation (G22 and G23)	6-79
6-9-3	Microjoint Function (G46)	6-80
6-9-4	G Command Mirror Image (G62, G51.1)	6-82
6-9-5	G Command X-Y Axis Exchange (G97)	6-85
6-9-6	Adjustment of Wire Diameter Compensation (OFFSET) Content	6-87
6-9-7	Operation on Variables	6-88
(1)	Outline	6-88
(2)	Structure of variable operation mode	6-89
(3)	Variable function	6-90
7)	Local variables (H901 to H932)	6-92
8)	Variable macro	6-93
9)	User variables	6-94
(4)	Variable operation function of conventional compatibility mode	6-95
(5)	Variable type 2	6-97
6-9-8	External Output Commands	6-103
(1)	Outline	6-103
(2)	POPEN command (Open command)	6-103
(3)	PCLOS command (Close command)	6-103
(4)	BPRNT command (Data output commands)	6-104
(5)	DPRNT command (Data output command)	6-104
6-9-9	User Macro Function (G101 to G111, G200 to G202, G203, G65, G66, G66.1)	6-105
(1)	Function and purpose	6-105
(2)	Operation instruction (G101 to G110)	6-105
(3)	3-point center calculation (G111)	6-108
(4)	Judgement branch instruction (G200 to G203)	6-109
(5)	Bit test (G203)	6-111
(6)	Macro simple call (G65)	6-112
(7)	Macro modal access A (G66)	6-115
(8)	Macro modal access B (G66.1)	6-117
6-9-10	Control Commands	6-117
6-9-11	Corner Chamfering	6-121
6-9-12	Corner R	6-123
6-9-13	Linear Angle Command	6-124
6-9-14	Geometric Command	6-125
6-9-15	Approach Error Compensation	6-126
6-10	Multiple Coordinate System Function (G53 to G59, G54.1 P00 to P99 and G43)	6-130
6-10-1	Machine Coordinate System and Workpiece Coordinate	6-130
6-10-2	Setting Multiple Coordinate System by NC Program	6-130
6-10-3	Local Coordinate System Setting (G52)	6-138
6-11	Preparatory Functions (G Code)	6-140
6-12	Feedrate Function (F Code)	6-143
6-12-1	Rapid Traverse Rate (G00)	6-143
6-12-2	Machining Feedrate	6-143
6-12-3	Command Increments and Command Speed Range	6-143

6-12-4 F Command Related Items.....	6-143
6-13 Miscellaneous Function (M Code).....	6-144
6-13-1 Miscellaneous Function List	6-144
6-13-2 Miscellaneous Function Explanation	6-145
(1) Program stop (M00).....	6-145
(2) Optional stop (M01)	6-145
(3) Program end (M02 or M30)	6-146
(4) External signal output (M60 to M69)	6-146
(5) Dielectric fluid preparation ON/OFF (M74, M75).....	6-146
(6) Dielectric fluid circulation ON/OFF (M76, M77).....	6-146
(7) Rapid filling up (M78).....	6-146
(8) Dielectric fluid ON/OFF (M80, M81)	6-146
(9) Automatic wire feeder control (M20, M21, M22 and M23)	6-146
(10) Wire feed ON/OFF (M82, M83)	6-147
(11) Machining ON/OFF (M84, M85)	6-147
(12) Dielectric fluid LOW/HIGH (M88, M89)	6-147
(13) Adaptive control ON/OFF (M90, M91).....	6-147
(14) All stop (M93)	6-147
(15) Fluid level setting LOW/HIGH (M58, M59)	6-147
(16) Automatic scrap treatment (M52)	6-148
(17) Automatic work change (M53).....	6-148
(18) PM mode selection (M101, M102, M103, M105)	6-148
(19) Machining speed adjustment (M106)	6-150
(20) CM-R (M110)	6-151
(21) CM-S (M111).....	6-152
(22) EM-path control (M112)	6-154
(23) EM-condition control (M113).....	6-155
6-14 Machining Conditions Selection E	6-156
6-14-1 Command Format.....	6-156
6-14-2 Package Change	6-156
6-15 Coordinates Rotation Function; K (G05)	6-157
6-16 Figure Magnification Setting Function; S (G51).....	6-159
6-17 Taper Angle Command Function; A	6-161
6-18 Axis Rotation Setting Function.....	6-163
6-19 Execution Sequence for Simultaneous Commands of Graphic Scale and Coordinate Rotate	6-164
6-20 Upper and Lower Optional Shape Programming.....	6-165
6-20-1 Move Path for Intersection Point Calculation Mode (G89)	6-165
6-20-2 Move Path for Corner R Mode (G88)	6-166
6-20-3 Precautions for the Upper Lower Random Shape Program.....	6-167

CHAPTER 7 COMMUNICATION WITH EXTERNAL DEVICES

7-1 Communication between Control Unit and External Device Using RS-232-C.....	7-1
7-1-1 Communication Outline	7-1
7-1-2 Communication by Code Control Method (DC1 and DC3 Methods)	7-1

(1) Control unit side data reception (Control code method)	7-2
(2) Control unit side data transmission (Control code method)	7-2
7-1-3 Communication by Code Control Method (DC1 and DC3 Method + DC2 and DC4)	7-3
(1) Data transmission and signal flow by the control unit	7-4
7-1-4 Communication by Line Control (RS-CS Control) Method	7-5
7-1-5 Communication by Protocol Control (DC1, DC3 Control)	7-5
7-1-6 Transmission Method	7-6
7-1-7 Codes	7-6
7-1-8 NC Tape Format	7-7
7-1-9 Signals	7-8
7-1-10 Connector and Pin Arrangement	7-9
7-1-11 Interface	7-10

CHAPTER 8 E.S.P.E.R CAD/W

8-1 Introduction	8-1
8-2 Programming Procedures	8-2
Precautions and Restrictions	8-3
8-3 Basic Operations	8-4
8-3-1 Screen Configuration	8-4
8-3-2 Buttons Used and Their Functions	8-5
8-3-3 Using the Slide Pad	8-6
8-3-4 Coordinate System	8-6
8-3-5 Angle	8-7
8-3-6 Calculator Function	8-7
8-3-7 Enlarging and Reducing the Screen Display	8-8
8-3-8 Erasing Figure Elements	8-8
8-3-9 Selecting Specific Element Points (Selecting an intersection or edge point)	8-8
8-3-10 Redrawing	8-9
8-4 Drawing Procedures	8-10
8-4-1 Drawing by Reading in External CAD Data (IGES, DXF, CAD/W file)	8-10
(1) Example of reading in external CAD data (IGES, DXF, CAD/W file)	8-10
8-4-2 Drawing by Reading in Pattern	8-11
(1) Example of reading in pattern	8-11
8-4-3 Drawing Using the CAD Function	8-13
(1) Example of drawing using the CAD function	8-13
8-5 E.S.P.E.R CAD/W NC Program Creation	8-15
8-5-1 Flow of Creating NC Program with E.S.P.E.R CAD/W	8-15
8-5-2 Example of Creating NC Program for Die-shape Single Part	8-16
8-5-3 Example of Creating NC Program for Die-shape Multiple-setup (Example using shape layout)	8-18
8-5-4 Example of Creating NC Program for Die-shape Multiple-setup (Example of program including use of automatic wire feeder)	8-20
8-5-5 Example of Creating NC Program for Die-shape (coreless)	8-23
8-5-6 Example of Creating NC Program for Punch-shape Single Part	8-25
8-5-7 Example of Creating NC Program for Punch-shape Multiple-setup	8-27
8-6 Reading in with E.S.P.E.R	8-30

8-6-1	Reading in with E.S.P.E.R	8-30
8-6-2	Procedures for Reading with E.S.P.E.R	8-30
8-6-3	Example of Reading with E.S.P.E.R	8-31
8-6-4	Example of Reading in Each Machining Pattern	8-32
(1)	Die-shape single part	8-32
(2)	Die-shape multiple-setup	8-32
(3)	Die-shape multiple-setup (program incorporating automatic wire feeder)	8-33
(4)	Die-shape coreless machining	8-33
(5)	Punch-shape single part	8-34
(6)	Punch-shape multiple-setup	8-34
8-7	Details of Operations	8-35
8-7-1	Edit Drawing	8-35
(1)	Line	8-35
1)	Horizontal line	8-35
2)	Vertical line	8-36
3)	Two-point segment	8-36
4)	Angle line	8-37
(2)	Point, Circle, Arc	8-38
1)	Point	8-38
2)	Circle	8-38
3)	Arc	8-40
4)	Semi-circle	8-42
(3)	Corner cut, edit element	8-42
1)	Line length edit	8-42
2)	Division	8-43
3)	Line division	8-43
4)	Corner cut	8-43
5)	Corner R insertion	8-44
6)	Corner chamfer	8-44
7)	Offset	8-45
(4)	Moving and copying	8-46
1)	Parallel movement	8-46
2)	Enlarging and reducing	8-46
3)	Parallel copy	8-47
4)	Rotation copy	8-47
5)	Reverse copy	8-48
(5)	Pattern	8-49
1)	Circle	8-49
2)	Square	8-49
3)	Hole	8-50
4)	Gears	8-50
(6)	File	8-51
1)	New	8-51
2)	Reading an IGES file	8-51
3)	Reading a DXF file	8-51
4)	Reading a CAD/W file	8-52
5)	Saving	8-52
8-7-2	Making the NC Program	8-53
(1)	Designating taper	8-53
1)	Partial taper	8-53
2)	Peripheral taper	8-53
3)	Designated R	8-53
4)	Top/bottom random	8-54
5)	Erase taper	8-54
(2)	Designating machining	8-55

1) Machining methods	8-55
2) Machining elements	8-55
3) Designating machining	8-56
4) Canceling.....	8-56
(3) Laying out shapes	8-56
1) Random	8-56
2) Line	8-57
3) Periphery	8-57
4) Radial	8-58
5) Grid	8-58
6) Grid mode	8-59
(4) Setting machining	8-61
1) Setting the functions	8-61
2) Setting the L No.	8-62
3) Process definition	8-63
4) NC make	8-63
(5) Setting the environment	8-63
1) Initialization	8-63
2) MOUSE A TYPE	8-64
3) MOUSE B TYPE	8-64
4) DCLK ON	8-64
5) DCLK OFF	8-64
8-8 Miscellaneous.....	8-65
8-8-1 Special Notes for Reading in IGES Files	8-65
(1) Restrictions (IGES Read)	8-65
(2) Precautions (IGES Read)	8-65
(3) Appendix (IGES Read)	8-66
8-8-2 Special Notes for Reading in DXF Files	8-67
(1) Restrictions (DXF Read)	8-67
(2) Cautions (DXF read)	8-67
(3) Appendix (DXF)	8-68

CHAPTER 9 MAINTENANCE AND ALARM LIST

I. Precautions for Maintenance and Inspection	I
II. Measures for Faults and Abnormalities	II
III. Prohibition of Modifications	II
9-1 Maintenance and Inspection Items	9-1
9-2 Maintenance and Inspection Method	9-2
9-2-1 Daily Inspection and Before-Operation Inspection	9-2
(1) Confirmation of wire route	9-2
(2) Inspection of lower ceramic plate (Insulation board)	9-2
(3) Inspection of nozzles	9-3
(4) Confirmation of dielectric fluid	9-3
(5) Confirmation of dielectric fluid specific resistivity	9-4
(6) Cleaning of working tank	9-5
(7) Confirmation of machining position	9-5
(8) Inspection of wire collection section	9-6
(9) Oiling.....	9-7
(10) Inspection of filter regulator	9-9
(11) Inspection of oil filter	9-11

9-2-2	Weekly Inspection	9-12
(1)	Maintenance and inspection of lower roller section	9-12
9-2-3	Monthly Inspection.....	9-12
(1)	Inspection of wire-alignment device (Option)	9-12
(2)	Inspection of lower nozzle clearance	9-12
(3)	Cleaning of fluid level sensor	9-13
(4)	Cleaning of working tank seal.....	9-14
(5)	Oiling of Z and UV axes.....	9-15
9-2-4	6-month Inspection	9-16
(1)	Inspection of floppy disk device.....	9-16
(2)	Cleaning the float switch in the work tank	9-16
9-2-5	Miscellaneous.....	9-17
(1)	Display screen	9-17
(2)	Uninterruptive Power Supply (UPS)	9-17
(3)	Replacing the backup battery	9-17
(4)	Hard disk (HDD)	9-17
(5)	Replacing the servo amplifier backup battery	9-17
9-3	Maintenance and Inspection of Dielectric Fluid Reservoir.....	9-18
9-3-1	Dielectric Fluid Reservoir Maintenance and Inspection Items	9-18
(1)	Replenishment of dielectric fluid.....	9-20
(2)	Inspection of dielectric fluid filter	9-20
(3)	Inspection of the supply pump.....	9-20
(4)	Cleaning of specific resistivity sensor.....	9-21
(5)	Replacement of water purifier (ion exchange resin)	9-21
(6)	Cleaning of dielectric fluid reservoir	9-23
(7)	Operation and maintenance of piping unit solenoid valve.....	9-24
(8)	Operation and maintenance of piping unit cylinder valve (CE mark specifications)	9-30
(9)	Maintenance and operation of injection nozzle solenoid valve	9-34
(10)	Cleaning the float switch.....	9-40
(11)	Supply of lubricating oil to pump	9-41
9-4	Maintenance and Inspection of the Dielectric Fluid Temperature Control Unit	9-42
9-4-1	Cleaning the air filter.....	9-42
9-4-2	Cleaning the unit cooler.....	9-43
9-4-3	Cleaning the condenser.....	9-43
9-4-4	Error codes and remedies	9-46
9-5	Automatic Threader (AT Unit) Maintenance and Inspection Methods.....	9-48
9-5-1	Maintenance and Inspection Items.....	9-48
(1)	Maintenance and inspection table	9-48
(2)	Other precautions	9-50
(3)	AT Maintenance Guidance Screen.....	9-51
9-5-2	Maintenance and Inspection Methods.....	9-52
(1)	Wire Feed System	9-52
(1)-1	Wire breakage detection sensor	9-52
(1)-2	Main tension roller	9-53
(1)-3	Retry sensor and pick arm	9-54
(1)-4	Auxiliary die	9-55
(2)	AT Unit	9-56
(2)-1	Wire pressing roller	9-56
(2)-2	Guide pipe	9-57
(2)-3	Wire chip guide.....	9-60
(2)-4	Cutter contact	9-61
(2)-5	Wire chip take-up roller	9-63
(3)	Power Feeder	9-64

(3)-1	Upper power feed terminal	9-64
(3)-2	Lower power feeder	9-65
(4)	Upper Wire Guide	9-66
(4)-1	Guide U	9-66
(4)-2	Upper diamond die	9-67
(4)-3	Jet nozzle	9-68
(5)	Lower Wire Guide	9-70
(5)-1	Lower guide roller	9-70
(5)-2	Maintenance of guide D	9-71
(5)-3	Aspirator sensor	9-72
(5)-4	Lower diamond die	9-74
(6)	Wire Collection Unit	9-75
(6)-1	Wire collection unit	9-75
(7)	Wire Chip Collection Unit	9-77
(7)-1	Wire chip collection box	9-77
(7)-2	Wire chip collection hose	9-78
9-5-3	Troubleshooting	9-79
9-6	Updating the System	9-81
9-6-1	Updating the System	9-81
9-6-2	Restoration When System Does Not Start up Correctly	9-84
9-7	List of Alarms	9-86
9-7-1	Operation Alarms	9-86
9-7-2	Alarms Concerning Sequencer	9-90
9-7-3	Operation Alarms	9-96
9-7-4	Stop Alarms	9-98
9-7-5	Servo Alarms	9-108
9-7-6	MCP Alarms	9-119
9-7-7	Other Servo Alarms	9-121
9-7-8	Program Alarms	9-122
9-7-9	System Alarms	9-130
9-7-10	System Warning	9-131
9-8	List of Consumables	9-132
9-9	Reference Information on Wire Electrodes	9-133

CHAPTER 10 Option

1	20kg Wire Winding Unit	10-1-1
2	Electrolyte Corrosion Prevention Specifications	10-2-1
	(Protection After Machining Circuit: PAM)	
3	DNC (Direct Numerical Control)	10-3-1
4	Wire Processing Unit	10-4-1
5	Angle Master (45-degree large angle taper specifications)	10-5-1