

**NE EDM**  
**NE30/NE50/NE50L/NE75/NE100**  
**INSTRUCTION MANUAL**



**亞特精密機械股份有限公司**  
**ARD PRECISION MACHINERY CO.,LTD.**

# **MACHINE INSTRUCTION CONTENTS**

<b>CHAPTER 1. SYSTEM SPECIFICATIONS.....</b>	<b>3</b>
1-1 MACHINE	
1-2 POWER SUPPLY	
1-3 DIELECTRIC TANK	
1-4 STANDARD ACCESSORIES	
1-5 OPTIONAL ACCESSORIES	
<b>CHAPTER 2. UNPACKING.....</b>	<b>5</b>
<b>CHAPTER 3. TRANSPORTATION.....</b>	<b>10</b>
<b>CHAPTER 4. OPERATION SITE.....</b>	<b>13</b>
4-1 OPERATION SITE	
4-2 MACHINE INSTALLATION DIAGRAM	
4-3 REQUIRED POWER	
4-4 HORIZONTAL ADJUSTMENT	
4-5 DEGREASING	
<b>CHAPTER 5. INSTALLATION.....</b>	<b>13</b>
5-1 DIELECTRIC TANK	
5-2 POWER SUPPLY UNIT CONNECTIONS	
<b>CHAPTER 6. CHECKING DIELECTRIC CIRCUIT.....</b>	<b>16</b>
<b>CHAPTER 7. DIELECTRIC CIRCULATION INSTRUCTIONS.....</b>	<b>17</b>

**CHAPTER 8. MACHINE OPERATION..... 19**

- 8-1 WORK TANK
- 8-2 MACHINE START
- 8-3 CLOSE THE WORK TANK DOOR
- 8-4 FLUSHING
- 8-5 SETTING THE CONTROL PANEL

**CHAPTER 9. MAINTENANCE, CLEANING  
& LUBRICATION..... 17**

- 9-1 FLUID LEVEL CHECK
- 9-2 LUBRICATION
- 9-3 CLEANING

**CHAPTER 10. M30F, M50, M75F MACHINICAL  
PARTS LIST..... 29**

# **P30, P45, P60 POWER SUPPLY UNIT**

## **CONTENTS**

<b>CHAPTER 1. ARD POWER SUPPLY</b>	
<b>INTRODUCTION.....</b>	<b>4</b>
<b>CHAPTER 2. EDM SRINCIPLES AND</b>	
<b>TECHNOLOGY.....</b>	<b>5</b>
<b>CHAPTER 3. ELECTRODE MATERIAL.....</b>	<b>7</b>
3-1 ELECTRODE MATERIAL CHARACTERISITICS	
3-2 PRODUCTION METHODS OF ELECTRODES	
<b>CHAPTER 4. EDM APPLICATION.....</b>	<b>11</b>
4-1 DISCHARGE OPERATION PROCESS	
4-2 ORBIT-CUT EXAMPLE	
<b>CHAPTER 5. M30F, M50F CONTROL PANEL.....</b>	<b>14</b>
5-1 "BT" HIGH VOLTAGE CURRENT SETTING	
5-2 "AT" HIGH VOLTAGE CURRENT SETTING	
5-3 "PA" SPARK ON SETTING	
5-4 "PB" SPARK OFF SETTING	
5-5 SERVO SENSITIVITY SETTING	
5-6 DISCHARGE GAP SETTING	
5-7 TIME ON, TIME OFF SETTING	
5-8 BUZZER AND DISCHARGE TIMER	

5-9	EMERGENCY STOP & MAIN SWITCH SPARK VOLT OPTION SWITCH	C 10
5-10	CONBINED WORKINGLAMP AND FIRE DLTCCTOR	
5-11	FIRE ALARM SYSTEM	10

**CHAPTER 6. SYSTEM INTRODUCTION..... 25**

6-1	FUNCTIONS	10
6-2	COORDINATES SYSTEM	
6-3	SYSTEM OPERATION MODE	

**CHAPTER 7. SYSTEM OPERATION..... 30**

7-1	CONSOLE PANEL INSTRODUCTION
7-2	DISPLAY DESCRIPTION
7-3	KEYBOARD INTRODUCTION

**CHAPTER 8. SYSTEM APPLICATION..... 47**

8-1	INPUT POWER
8-2	FIND REFERENCE
8-3	FIND CENTER
8-4	Z-AXIS AUTO EDGE FIND
8-5	X, Y, Z AXES POSITION MEMORY FUNCTION

**CHAPTER 9. PROGRAMMING..... 56**

9-1	EDIT
9-2	PROGRAM EXECUTION
9-3	MODIFICATION DURING MACHINING
9-4	IMPORTANT THINGS TO BE NOTED

**CHAPTER 10. MACHINE PARAMETER..... 65**

- 10-1 P PARAMETER (for user reference only, please don't change then)
- 10-2 P PARAMETER DESCRIPTION (those description just for your reference. Please don't change the original setting)
- 10-3 HOW TO LOAD THE CONTENTS OF P31~ P99

# P45, P60, P90 APPLICATION NOTES

## CONTENTS

1. SURFACE FINISH IN EDM.....	2
2. (90V) ELECTROLYTIC COPPER (+)– STEEL.....	3
3. (100V) GRAPHITE (+)– STEEL.....	13
4. (260V) ELECTROLYTIC COPPER(–)– STEEL.....	18
5. (90V) COPPER TUNGSTEN(–)– TUNGSTEN CARBIDE.....	20
(Can be refered as copper to tungsten carbide application)	
6. (90V) ELECTOLYTIC COPPER (–)– COPPER.....	22
7. (260V,90V) STEEL (+)– STEEL.....	24
8. (260,90V) ELECTROLYTIC COPPER (+)– STEEL.....	26