

FA-S Series

**WIRE-CUT
EDM SYSTEMS**

**MACHINING
CHARACTERISTICS
DATA BOOK**

BQN-W-70462B

(Version 3.0)

Contents

1. Configuration of Machining Conditions Table.....	A-1
1-1 Configuration of Machining Conditions Table.....	A-1
2. How to Read the Machining Characteristics Data Table.....	A-2
2-1 How to Read the Machining Conditions Table (Machining Condition Digest).....	A-2
2-2 How to Read the Machining Characteristics Data Table (Machining conditions table).....	A-3
2-3 Names of Machining Conditions Setting Notches.....	A-4
2-4 Notch Settings.....	A-5
2-5 Setting the Nozzle and Dielectric Fluid Flow Rate.....	A-7
2-6 Setting corner control.....	A-8
3. Optimizing Machining Conditions.....	A-10
3-1 1st Cut Machining Section.....	A-10
3-2 Finish Machining Section.....	A-11
3-3 Correcting the upper/lower dimension difference.....	A-12

4. Machining Characteristics Data

4-1 $\phi 0.20$ wire

Wire dia. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions	
				Material thickness (mm)	Page
$\phi 0.20$	Steel	Standard	1	5 to 100	1-1 to 1-11
		Speed priority	2	5 to 100	2-1 to 2-11
		Minimum step	3	5 to 100	3-1 to 3-11
	Tungsten carbide	Standard	4	5 to 100	4-1 to 4-11
	Copper	Standard	5	5 to 100	5-1 to 5-11
	Aluminum	Standard	6	5 to 100	6-1 to 6-11

4-2 $\phi 0.25$ wire

Wire dia. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions	
				Material thickness (mm)	Page
$\phi 0.25$	Steel	Standard	7	5 to 250	7-1 to 7-15
		Speed priority	8	5 to 150	8-1 to 8-13
		Minimum step	9	5 to 100	9-1 to 9-11
	Tungsten carbide	Standard	10	5 to 100	10-1 to 10-11
	Copper	Standard	11	5 to 150	11-1 to 11-13
	Aluminum	Standard	12	5 to 150	12-1 to 12-13

4-3 $\phi 0.30$ wire

Wire dia. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions	
				Material thickness (mm)	Page
$\phi 0.30$	Steel	Standard	13	10 to 300	13-1 to 13-15
		Minimum step	14	5 to 100	14-1 to 14-11
	Copper	Standard	15	5 to 150	15-1 to 15-13
	Aluminum	Standard	16	5 to 300	16-1 to 16-16

4-4 $\phi 0.10$ wire

Wire dia. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions	
				Material thickness (mm)	Page
$\phi 0.10$	Steel	Standard	17	3 to 50	17-1 to 17-7
	Tungsten carbide	Standard	18	3 to 50	18-1 to 18-7
	Copper	Standard	19	3 to 50	19-1 to 19-7

4-5 ø0.15 wire

Wire dia. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions	
				Material thickness (mm)	Page
ø0.15	Steel	Standard	20	3 to 70	20-1 to 20-9
	Tungsten carbide	Standard	21	3 to 60	21-1 to 21-8
	Copper	Standard	22	3 to 60	22-1 to 22-8

4-6 Land machining

Wire dia. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions	
				Material thickness (mm)	Page
ø0.20	Steel	Land machining	23		23-1 to 23-1
	Tungsten carbide	Land machining	24		24-1 to 24-1
ø0.25	Steel	Land machining	25		25-1 to 25-1
	Tungsten carbide	Land machining	26		26-1 to 26-1

4-7 SL machining

Wire dia. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions	
				Material thickness (mm)	Page
ø0.20	Steel	SL	27	5 to 100	27-1 to 27-1
ø0.25	Steel	SL	28	5 to 100	28-1 to 28-1
ø0.30	Steel	SL	29	5 to 100	29-1 to 29-1

4-8 High-speed rough machining

Wire dia. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions	
				Material thickness (mm)	Page
ø0.20	Steel	High-speed rough	30	5 to 100	30-1 to 30-11
ø0.25	Steel	High-speed rough	31	5 to 100	31-1 to 31-11
ø0.30	Steel	High-speed rough	32	40 to 100	32-1 to 32-7