WIRE ELECTRICAL DISCHARGE MACHINE

EC32/EC64

(MGW-GL)

INSTRUCTION MANUAL

(MECHANICAL EDITION)

MAKINO MILLING MACHINE CO., LTD.

CONTENTS

1. SF	PECIF	FICATION	1-1
1.1	Nan	ne of Each Part	1-1
1.2	Spe	cifications	1–2
= #	(1)	Specifications by model	1-2
		Specifications common to EC32 and EC64	
1.3		s Assignment	
1.4	Mac	hine Coordinate System, Origin and Reference Point	1–8
2. C/	AUTK	ONS FOR SAFETY	2-1
3. FL	# 10 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0 0	IONS AND HANDLING OF MAIN PARTS	
3.1		rer Switches	
3.2		xis	
	S 1555	Zaxis position and taper machining	
3.3	Wire	e System	
3.	3.1	Wire path	
3.	3.2	Wire delivery	
	(1)	Name of major components	
	(2)	Wire loading method	
3	.3.3	Wire guide unit (upper)	
3	3.4	Upper head	
	(1)	Splashguard	
3	.3.5	Lower head	
	(1)	Name of main parts	
	(2)	Replacing diamond guide and press guide	
	(3)	Replacing the energizing plate	
	(4)	Replacing of V guide	
	(5)	Adjustment of nozzle guard height	
	(6)	Replacing dielectric nozzle	3–19
	(7)	Installation of head cover	3–20
	(8)	Parts not to be loosened	3–20
3	.3.6	Wire guide unit (lower)	3-21
3	.3.7	Wire winding	
3	.3.8	Automatic wire threading	
3	.3.9	Wire vertical alignment	
		Wire vertical alignment	
	(2)	Precautions on wire vertical adjustment	3-25

3	3.3.10	Line-up between positioning guide and K shaft	3-26
3.4	Tap	per Cutting Unit	3-29
3	3.4.1	Appearance	3-29
		Taper machining and mechanical limitation	3-29
		lectric Fluid System	3-31
		Dielectric fluid circuit diagram and dielectric fluid supply unit	3-31
	.5.2	Function of each part	3-33
3	.5.3	Tank filling for dielectric fluid supply unit	3-35
	(1)	Checking before tank filling	3-35
	(2)	Tank filling	3-35
3	.5.4	Replenishment and change of dielectric fluid	3-36
	(1)	Replenishment of dielectric fluid	3-36
	(2)	Change of dielectric fluid	3-36
3	.5.5	Change of filter and filter element	3-36
	(1)	Change of dielectric filter	3-36
	(2)	Change of jet filter element	3-37
3	.5.6	Change of ion exchange resin	3-38
3	.5.7	Cleaning of raw water inlet assembly	3-39
3	.5.8	Air breathing of flushing pump	3-40
3	.5.9	Others	3-40
3.6	Air	System	3-41
3	.6.1	Pneumatic circuit diagram	3-41
3	.6.2	Function of each part	3-42
3.7	Wo	rk Tank	3-44
3.8	Wo	rkpiece Clamping	3-45
3	.8.1	Machining area	3-45
3	.8.2	Workpiece fixture	3-46
3	.8.3	Fasteners	3-48
		The state of the s	
. 0	PERA	TION AT START-UP	4-1
4.1	Sta	t-up Procedure	4-1
4.2	Che	cking Before Start of Machining	4-2
	(1)	Machine	4-2
	(2)	Dielectric fluid supply unit	4-2
. 0	PERA	ATION AT END OF WORK	5–1
		Unloading workpiece	
		Replenishment and change of dielectric fluid	
		Cleaning each part of machine	

		(4) Turning the power off	5–1
6	. IN	SPECTION	6-1
	6.1	Periodic Inspection	6-1
	6.2	Maintenance	6-1