

[ INSTRUCTION MANUAL ]

FINE **Sodick** WIRE CUT-EDM

# 85 PIPE AWT

MARK20 SERIES



FINE **Sodick**  
SODICK Co., Ltd.

Vol. 1.1

# Table of Contents

|  |    |
|--|----|
| 1. Specification .....                                 | 1  |
| 2. Component Description .....                         | 2  |
| 3. Operation Description .....                         | 3  |
| 4. Operating Instructions .....                        | 4  |
| 1) Operation control pendant .....                     | 4  |
| 2) Manual operation/NC code operation .....            | 6  |
| 3) AWT position setting .....                          | 7  |
| 4) Example of AWT program .....                        | 8  |
| 5) AWT operation .....                                 | 9  |
| 5. AWT Setting .....                                   | 11 |
| 1) Setting of parameters "SETTING" and "MACHINE" ..... | 11 |
| 2) Setting of AWT OFFSET X(U)/Y(V) .....               | 14 |
| 3) Setting of BB1/BB2 .....                            | 16 |
| 4) Adjustment of AWT fluid column .....                | 18 |
| 5) Setting of wire .....                               | 19 |
| 6. AWT Troubleshooting .....                           | 20 |
| 7. Other Points to Note and Maintenance .....          | 24 |
| 8. Replacement of Consumables .....                    | 25 |
| 1) Pipe .....  | 25 |
| 2) AWT die .....                                       | 25 |
| 3) Cutter .....  | 26 |
| 4) Slide belt .....                                    | 27 |
| 9. Manual Wire Threading .....                         | 28 |