

INSTRUCTION MANUAL

ELECTRICAL DISCHARGE MACHINE

MGF POWER SUPPLY

PROGRAMMING

MAKINO MILLING MACHINE CO., LTD.

TABLE OF CONTENTS

| | Page |
|--|------|
| 1. DETERMINING ELECTRODE REDUCTION | 1-1 |
| 2. SELECTING INITIAL MACHINING CONDITIONS | 2-1 |
| 3. INSTALLATION OF A LARGE ELECTRODE | 3-1 |
| 4. SL MACHINING BY GRAPHITE ELECTRODE | 4-1 |
| 5. HELICAL GEAR MACHINING | 5-1 |
| 6. MACHINING BY AN ELECTROFORMING ELECTRODE AND A LARGE AREA COPPER ELECTRODE | 6-1 |
| 7. SUPPLEMENTARY DESCRIPTION ON VARIOUS MACHINING APPLICATIONS | 7-1 |
| (1) Glazed machining | 7-2 |
| (2) Satin machining | 7-3 |
| (3) Pin gate machining | 7-4 |
| (4) Thread cutting by swinging | 7-7 |
| 8. CONTOURING | 8-1 |
| 9. PREMACHINED HOLE MACHINING BY PIPE ELECTRODE | 9-1 |
| 10. FINE HOLE MACHINING BY DRESSED ELECTRODE | 10-1 |
| 11. HOW TO USE A CENTERING BALL | 11-1 |
| 12. INDEX MACHINING | 12-1 |
| 13. USE OF ATC | 13-1 |
| 14. IRREGULAR SHAPES MACHINING (BOTTOM STOPPED - COMPLEX MENU) | 14-1 |
| 15. APPLICATIONS OF THE POSITIONING MODEL | 15-1 |
| 16. PROGRAMMING EXAMPLES IN NC LANGUAGE | 16-1 |
| 17. WHEN YOU ARE IN A DIFFICULTY | 17-1 |