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CNC Wire Cut Introduction. Wire EDM cutting, also known as electrical discharge machining, is a process that uses an electrically energized thin wire to slice through metal. Wire EDM cutting uses rapid, controlled, repetitive spark

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discharges from the wire to the workpiece, thereby eroding the metal away. The workpiece must be electrically conductive.

Wire EDM Programming Example - Helman CNC

CNC Program. N005 G54 (SELECT
COORDINATE SYSTEM A00) N010 G92

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X.250 Y-.300 (SET PROGRAM ZERO)
N015 G90 (SELECT ABSOLUTE MODE)
N020 C411 (SELECT CUTTING
CONDITION) N025 G42 H061 (SELECT
RIGHT OFFSET AND VALUE) N030 T94
(SUBMERGE MODE) N031 T91 (AUTO
WIRE THREAD) N035 T84 (HIGH
PRESSURE FLUSH ING) N040 G01 Y0
(MOVE UP IN Y) N045 X.5 (MOVE TO THE

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RIGHT) N050 Y.500 (MOVE UP IN Y) N055 X0 (MOVE TO THE LEFT) N060 Y0 (MOVE TO PROGRAM ZERO) N065 X.150 (MOVE TO MOO POINT) N070 G40 Y-.02 (MOVE TO ...

Sodick Wire Cutting EDM CNC Programming Example

- Both the program start flag and the

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program number must be independent of all other commands (on separate lines) •The data within a block should follow the sequence shown in the above sample block Example CNC Program

```
N5 G90 G20 N10 M06 T3 N15 M03 S1250
N20 G00 X1 Y1 N25 Z0.1 N30 G01
Z-0.125 F5 N35 X3 Y2 F10 N40 G00 Z1
N45 X0 Y0 N50 M05 N55 M30
```

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CNC Programming - University of Technology

Sometimes cutting some simple workpieces, such as a circle or a square, etc. Needn't programming, directly manually input 3 B commands, methods of operation are as follows: In the main menu press B key, and press Enter, then

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input 3B command in standard format.
For example: B3000B4000B4000GYL2, if coordinates value is zero, can be omitted.

HL Wire Cutting Control Programming System

1. Showing the creation of CAD geometry. 2. Applying XY selection with auto entry motion for overall

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geometries. 3. Defining new cutting order by using sort option.

Fikusworks Wire EDM Basic programming

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Wirecut Fanuc Robocut Fanuc (16W, 1997)

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5) To fixed the program, PROGRAM → Find number of program 62 → OPEN FILE (M2) → fix the program line "ERROR" → FILE (M1) → SAVE (M3) → repeat steps 1 until 4. 6) (Note: use ← ↑ → ↓, ENTER, observe the simulation of the program).

5.3 Machining.

1) Make sure the work piece parallel with work table and screw tightly.

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EDM wirecut report - LinkedIn SlideShare

CNC Programming and Operations
Manual P/N 70000508G - Contents
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5000M CNC Programming & Operations Manual

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Technical Specifications; Table Size L x W: 200 x 340 mm: Table Travel X, Y axis: 120 x 160 mm: Maximum Work Piece Thickness: 100 mm: Machining

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Accuracy: 0.010 mm

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