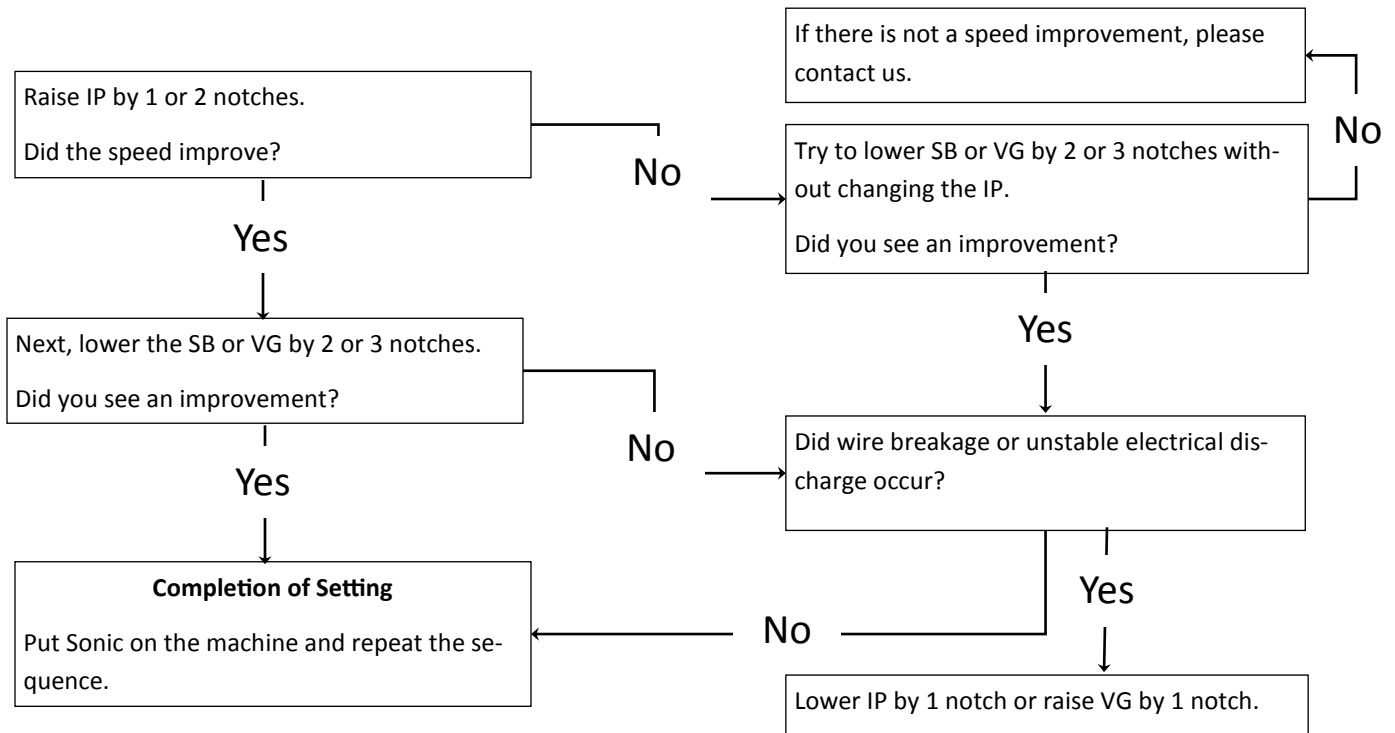


Tuning A Wire EDM Machine For Maximum Results

To ensure that you see the greatest benefit from our Sonic wire it is important that your machines be operating at peak efficiency with your current wire. Most EDM machines have the capability to increase or decrease cutting speed automatically based on the cutting conditions in the gap. We want to make sure that you can take advantage of this ability to increase speed with your machines and to do this we must make sure you have reached the limits of the current wire you are using.

To accomplish this we must progress with a sequence of changes.



EDM Machine Manufacturer	Discharge Energy Settings	Off Time Setting
Agie	P, T	TD
Charmilles	A, IAL	B, A
Fanuc	ON	OFF, SV
Hitachi	PA	PA, FB
Japax	IP, On Time	OFF
Makino	Peak Current, ON	OFF
Mitsubishi	IP	SB, OFF
Seibu	I	OFF
Sodick	IP, ON	MA, OFF