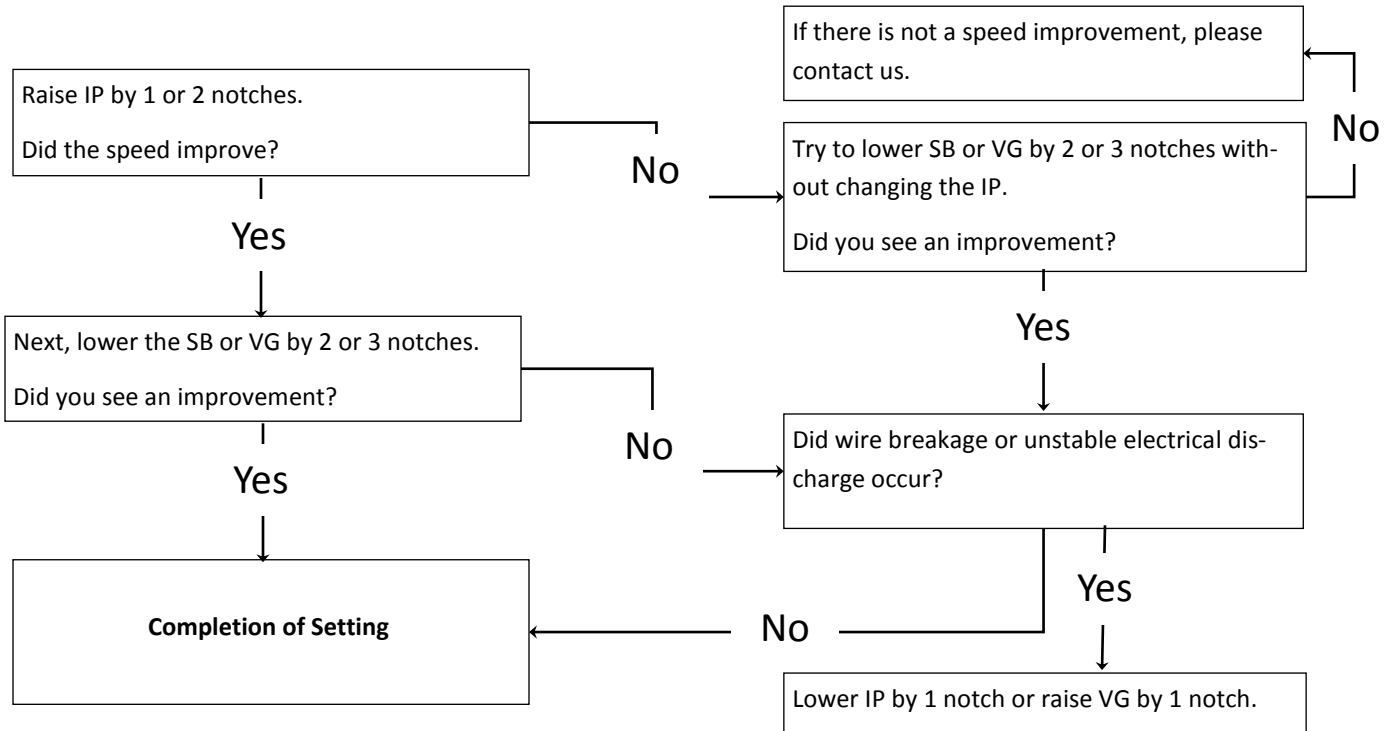




## Tuning VELOCITY EDM WIRE For Maximum Results

To verify the wire is being used to the optimum condition, as it leaves the machine to the used wire bin, it should have changed color to a burnt brown color and the surface should be pitted, similar to an 80 grit sand paper feel. *If these results have not been achieved the machine requires further adjustment as optimum performance has not been realized.*

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