



RATNAPARKHI
ELECTRONICS IND. PVT. LTD.
SINCE 1989

CNC EDM



We Support



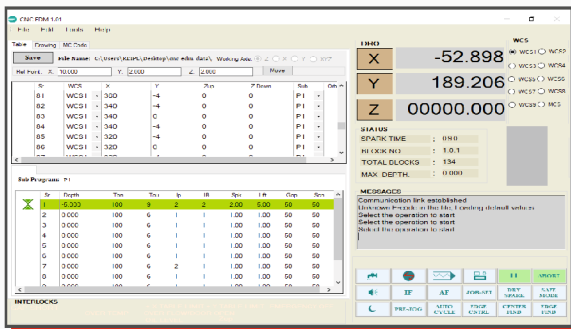
MAKE IN INDIA

CNC EDM

Features

- 1) Adaptive multi stage anti arc
A spark discharge is continuously monitored and instant pulse to pulse corrective actions are taken
- 2) A high-speed jump of 3.3 mtr/min maintains clean gap.
- 3) A safe mode for deep cavities where flushing conditions are difficult
- 4) Auto centre and edge find – internal and external.
- 5) Programmable multicavity operation.
- 6) Multi co-ordinate systems. (9 work co-ordinate systems)
- 7) Programmable X / Y / Z erosion axis. (vertical or side sparking).
- 8) XYZ simultaneous machining
- 9) Orbiting cycles, vector, polygon, circular & taper machining
- 10) Display of electrode path during machining
- 11) "Dry spark" for electrode alignment.
- 12) X,Y & Z axis with precision class LM guideways
- 13) X,Y & Z axis with precision ground ballscrew
- 14) Direct coupled AC servo for X, Y, Z axis
- 15) Machine reference with pitch error compensation
- 16) Auto cycle operation based on: lift distance & machining depth
- 17) Low wear for reducing electrode wear. effective in rib machining
- 18) "Edge control" for corner wear control. suitable for low current
- 19) Sleep mode for auto shutdown
- 20) Pendant unit with MPG

Self Guided operation panel



CNC EDM : Pulse Generator

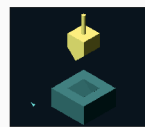
- Unlimited no. of programs and 99 sub programs (10 Steps), 99 orbiting programs
- EDM technology at a glance on screen
- 3 axes digital positioning display
- Day and night / sleep function
- Higher material removal rate due to equi-energy pulse discharge
- Reduced electrode wear with high MRR
- Selectable high-speed jump function
- Inbuilt safe machining circuit
- Adaptive anti-arc and flushing control
- Industrial computer for human-machine interface
- 17 Inch LCD screen



Pendant unit with MPG & multiple controls.

Safety & Protection :

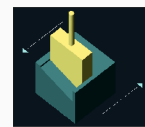
- ▲ Servo fault.
- ▲ X,Y,Z axis over travel limit, over temperature, low oil level, over flow, pump overload, door open



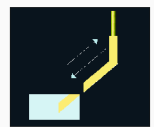
Vertical Z Axis



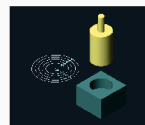
Multicavity



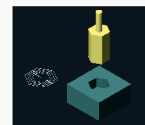
Side Sparking



XYZ Simultaneous



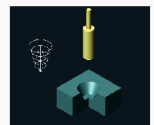
Circular Cycle



Polygon Cycle



Vector Cycle



Taper Cycle

Technical Specifications

Machine tool	CNC EDM 5530	CNC EDM 7045
Work Tank	850 x 530 x 300 mm	1100 x 700 x 400 mm
Work Table	550 x 300 mm	700 x 450 mm
X Travel	320 mm	450 mm
Y Travel	250 mm	350 mm
Z Travel	250 mm	250 mm
Max. job weight	400 kg	800 kg
Max. Electrode Weight	60 kg	60 kg
Max.job height	300 mm	300 mm
Machine Weight	1200 kg	1550 kg
Machine foot print	2600 X 2000 X 2300	3000 X 2200 X 2400

EDM Pulse Generator

Sr.No.	Particular	Remark
1	Max Working Current	30+5-amp STD / 45+5 amp
2	Pulse ON-OFF Setting	Ton (1 to 999), τ (1 to 12)
3	Max MRR	* Copper to Steel 235 Mm3 /Min * Graphite To Steel 240 Mm3 /Min * Steel To Steel 150 Mm3 /Min
4	Minimum Electrode Wear	<0.1%
5	Surface Finish	μ Ra 0.8 – 1.3
6	Connected Load	5.5 kva
7	Power Supply	3 PHASE, 415 VAC, 50 Hz

Dielectric Unit

Sr.No.	Particular	CNC EDM 5530	CNC EDM 7045
1	Dielectric tank Capacity	300 litre	400 litre
2	Filter Element	10 μ paper	10 μ paper
3	No of Filter	2 Nos	2 Nos
4	Pump Motor	0.5 hp 3 phase 1 No	0.5 hp 3 phase 2 Nos

Important Note : In keeping with our constant endeavour to meet market needs, we reserve the right to alter or change the specifications mentioned, without prior notice

www.ratnaparkhiedm.com



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