BS 0.20mm

Roughing

St Cu AL Gr.

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.20mm | St | Both Away | Roughing |

Offset for roughing is max gap.

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm | 1 | | 3 | | 5 | | 10 | | 15 | | 20 | | 25 | | | 30 | | 40 | | 50 | |
| E No. | E1016 | | E1026 | | E1036 | | E1046 | | E1056 | | E1066 | | E1076 | | | E1086 | | E1096 | | E1106 | |
| H Value | V-corner | | V-corner | | V-corner | | V-corner | | V-corner | | V-corner | | V-corner | | | V-corner | | V-corner | | V-corner | |
| Offset roughing | 0.110 | | 0.120 | | 0.120 | | 0.128 | | 0.130 | | 0.132 | | 0.135 | | | 0.135 | | 0.140 | | 0.140 | |
| Pressure Up.(Mpa) | - | | - | | - | | - | | - | | - | | - | | | - | | - | | - | |
| Low(Mpa | - | | - | | - | | - | | - | | - | | - | | | - | | - | | - | |
| Removal rate  (mm/min) | 10.5  ~9.5 | | 8.8  ~7.8 | | 7.2  ~6.8 | | 5.1  ~4.6 | | 4.5  ~4.1 | | 3.6  ~3.2 | | 2.8  ~2.6 | | | 2.5  ~2.0 | | 1.7  ~1.5 | | 1.3  ~1.1 | |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 8~11 | | 8~11 | | 5~7 | | 4~6 | | 4~6 | | 4~6 | | 4~6 | | | 4~6 | | 5~7 | | 4~6 | |
| Spark lump  state |  | |  | |  | |  | |  | |  | |  | | |  | |  | |  | |
| 12 | | 12 | | 12 | | 12 | | 12 | | 12 | | 12 | | | 12 | | 12 | | 12 | |
| Surface(micron) | 20 | | 20 | | 20 | | 20 | | 20 | | 20 | | 20 | | | 20 | | 20 | | 20 | |

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| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.20mm | St | Both Away | Roughing |

Offset for roughing is max gap.

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm | 60 | | 80 | | 100 | | 125 | | 150 | |  |  |  |  |  |
| E No. | E1116 | | E1126 | | E1136 | | E1146 | | E1156 | |  |  |  |  |  |
| H Value | V-corner | | V-corner | | V-corner | | V-corner | | V-corner | |  |  |  |  |  |
| Offset roughing | 0.140 | | 0.144 | | 0.145 | | 0.145 | | 0.150 | |  |  |  |  |  |
| Pressure Up.(Mpa) | - | | - | | - | | - | | - | |  |  |  |  |  |
| Low(Mpa | - | | - | | - | | - | | - | |  |  |  |  |  |
| Removal rate  (mm/min) | 0.9  ~0.85 | | 0.64  ~0.58 | | 0.50  ~0.38 | | 0.35  ~0.25 | | 0.25  ~0.18 | |  |  |  |  |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 4~6 | | 3~5 | | 3~5 | | 3~5 | | 4~6 | |
| Spark lump  state |  | |  | |  | |  | |  | |  |  |  |  |  |
| 12 | | 12 | | 12 | | 12 | | 12 | |
| Surface(micron) | 20 | | 20 | | 20 | | 20 | | 20 | |  |  |  |  |  |

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| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.20mm | Cu | Both Away | Roughing |

Offset for roughing is max gap.

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | | 10 | | 15 | | | 20 | | | 25 | | | 30 | | | 40 | | | 50 | | | 60 | | |  |
| E No. |  | E1644 | | E1654 | | | E1664 | | | E1674 | | | E1684 | | | E1694 | | | E1704 | | | E1714 | | |  |
| H Value |  | V-corner | | V-corner | | | V-corner | | | V-corner | | | V-corner | | | V-corner | | | V-corner | | | V-corner | | |  |
| Offset roughing |  | 0.148 | | 0.153 | | | 0.153 | | | 0.158 | | | 0.161 | | | 0.164 | | | 0.169 | | | 0.173 | | |  |
| Pressure Up.(Mpa) |  | - | | - | | | - | | | - | | | - | | | - | | | - | | | - | | |  |
| Low(Mpa) | | - | | - | | | - | | | - | | | - | | | - | | | - | | | - | | |  |
| Removal rate  (mm/min) |  | 8.5  ~7.0 | | 5.8  ~4.8 | | | 5.7  ~4.7 | | | 4.7  ~3.9 | | | 4.0  ~3.3 | | | 2.8  ~2.3 | | | 2.1  ~1.7 | | | 1.7  ~1.4 | | |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 6~8 | | 6~7 | | | 5~7 | | | 6~7 | | | 6~7 | | | 5~7 | | | 5~7 | | | 5~7 | | |
| Spark lump  state |  |  | |  | | |  | | |  | | |  | | |  | | |  | | |  | | |  |
| 12 | | 12 | | | 12 | | | 12 | | | 12 | | | 12 | | | 12 | | | 12 | | |
| Surface(micron) |  | 20 | | 20 | | | 20 | | | 20 | | | 20 | | | 20 | | | 20 | | | 20 | | |  |

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BS 0.25mm

Roughing

St Cu AL Gr.

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | St | Both Away | Roughing |

Offset for roughing is max gap.



|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm | 1 | | | 3 | | | 5 | | | 10 | | | 15 | | | 20 | | 25 | | 30 | | | 40 | | | 50 | | |
| E No. | E1016 | | | E1026 | | | E1036 | | | E1046 | | | E1056 | | | E1066 | | E1076 | | E1086 | | | E1096 | | | E1106 | | |
| H Value | V-corner | | | V-corner | | | V-corner | | | V-corner | | | V-corner | | | V-corner | | V-corner | | V-corner | | | V-corner | | | V-corner | | |
| Offset roughing | 0.148 | | | 0.157 | | | 0.160 | | | 0.160 | | | 0.162 | | | 0.163 | | 0.166 | | 0.169 | | | 0.172 | | | 0.176 | | |
| Pressure Up.(Mpa) | - | | | - | | | 0.10 | | | 0.10 | | | 0.2 | | | 0.2 | | 0.2 | | 0.2 | | | 0.2 | | | 0.2 | | |
| Low(Mpa | - | | | - | | | 0.10 | | | 0.10 | | | 0.2 | | | 0.2 | | 0.2 | | 0.2 | | | 0.2 | | | 0.2 | | |
| Removal rate  (mm/min) | 9.4  ~9.1 | | | 7.8  ~7.5 | | | 7.2  ~6.0 | | | 6.0  ~5.0 | | | 5.2  ~4.5 | | | 4.5  ~3.8 | | 3.8  ~3.0 | | 3.3  ~2.8 | | | 2.5  ~2.0 | | | 2.5  ~2.0 | | |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 6~8 | | | 5~8 | | | 6~8 | | | 5~8 | | | 4~6 | | | 4~5 | | 4~5 | | 2~4 | | | 4~6 | | | 4~6 | | |
| Spark lump  state |  | | |  | | |  | | |  | | |  | | |  | |  | |  | | |  | | |  | | |
| 12 | | | 12 | | | 12 | | | 12 | | | 12 | | | 12 | | 12 | | 12 | | | 12 | | | 12 | | |
| Surface(micron) | 20 | | | 20 | | | 20 | | | 20 | | | 20 | | | 20 | | 20 | | 20 | | | 20 | | | 20 | | |

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| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | St | Both Away | Roughing |

Offset for roughing is max gap.

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm | 60 | | | 80 | | | 100 | | | 125 | | | 150 | | |  |  |  |  |  |
| E No. | E1116 | | | E1126 | | | E1136 | | | E1146 | | | E1156 | | |  |  |  |  |  |
| H Value | V-corner | | | V-corner | | | V-corner | | | V-corner | | | V-corner | | |  |  |  |  |  |
| Offset roughing | 0.180 | | | 0.183 | | | 0.185 | | | 0.187 | | | 0.189 | | |  |  |  |  |  |
| Pressure Up.(Mpa) | 0.2 | | | 0.2 | | | 0.2 | | | 0.2 | | | 0.2 | | |  |  |  |  |  |
| Low(Mpa | 0.2 | | | 0.2 | | | 0.2 | | | 0.2 | | | 0.2 | | |  |  |  |  |  |
| Removal rate  (mm/min) | 1.5  ~1.0 | | | 0.95  ~0.7 | | | 0.7  ~0.5 | | | 0.46  ~0.38 | | | 0.34  ~0.28 | | |  |  |  |  |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 3~5 | | | 4~6 | | | 3~5 | | | 4~6 | | | 3~5 | | |
| Spark lump  state |  | | |  | | |  | | |  | | |  | | |  |  |  |  |  |
| 12 | | | 12 | | | 12 | | | 12 | | | 12 | | |
| Surface(micron) | 20 | | | 20 | | | 20 | | | 20 | | | 20 | | |  |  |  |  |  |

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | Cu | Both Away | Roughing |

Offset for roughing is max gap.

|  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm | 5 | 10 | 15 | 20 | 25 | 30 | 40 | 50 | 60 |
| E No. | E1634 | E1644 | E1654 | E1664 | E1674 | E1684 | E1694 | E1704 | E1714 |
| H Value | V- | V- | V- | V- | V- | V- | V- | V- | V- |
| Offset roughing | 0.165 | 0.173 | 0.178 | 0.178 | 0.183 | 0.186 | 0.191 | 0.194 | 0.199 |
| Pressure Up.(Mpa) | 0.1 | 0.1 | 0.1 | 0.2 | 0.2 | 0.2 | 0.2 | 0.2 | 0.2 |
| Low(Mpa | 0.1 | 0.1 | 0.1 | 0.2 | 0.2 | 0.2 | 0.2 | 0.2 | 0.2 |
| Removal rate | 11.5 | 9.7 | 6.9 | 5.9 | 4.6 | 4.0 | 2.9 | 2.2 | 1.8 |
| (mm/min) | ~9.5 | ~7.9 | ~5.7 | ~4.9 | ~3.8 | ~3.2 | ~2.3 | ~1.8 | ~1.4 |

Servo lump

state 6~8 6~8 6~8 5~7 6~7 6~7 5~7 6~7 5~7



Spark lump

|  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| state | 12 | 12 | 12 | 12 | 12 | 12 | 12 | 12 | 12 |
| Surface(micron) | 18 | 18 | 20 | 20 | 20 | 20 | 20 | 20 | 20 |

BS 0.20mm

Finish

St

Both Away

Reference 3 cuts finish condition



Note: Corner precision is inferior to 4 and 5 cuts.

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
|  | |  |  | |  |  |
|  | B | oth Aw | ay |  |  | |
|  | |  |  | |  |  |

Used V-corner for roughing t~ 50t

(No use G44 or G44H0)

|  |  |  |  |
| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 1 | | | | | | | | | | | | | | 1 | | | | | | | | |
| MODEL No. |  | | | | | | | | | | | | | |  | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |  | 1st | | | 2nd | | | 3rd | |  |
| E No. | E1016 | | | E1017 | | | E1018 | | | E1019 | | E1020 | |  | E1016 | | | E1017 | | | E1019 | |  |
| H Value | V-corner | | |  | | |  | | |  | |  | |  |  | | |  | | |  | |  |
| Offset Roughing | 0.110 | | | - | | | - | | | - | | - | |  |  | | |  | | |  | |  |
|  | 0.135 | | | 0.105 | | | - | | | - | | - | |  |  | | |  | | |  | |  |
| Finish 7 | 0.147 | | | 0.117 | | | 0.105 | | | - | | - | |  |  | | |  | | |  | |  |
| Finish 3 | 0.152 | | | 0.122 | | | 0.110 | | | 0.105 | | - | |  | 0.140 | | | 0.110 | | | 0.105 | |  |
| Finish 2 | 0.154 | | | 0.124 | | | 0.112 | | | 0.107 | | 0.107 | |  |  | | |  | | |  | |  |
|  | 0.167 | | | 0.137  0.117 | | | -  0.105 | | | -  - | | -  - | |  |  | | |  | | |  | |  |
|  | 0.172 | | | 0.142  0.122 | | | -  0.110 | | | -  0.105 | | -  - | |  |  | | |  | | |  | |  |
|  | 0.174 | | | 0.144  0.124 | | | -  0.112 | | | -  0.107 | | -  0.107 | |  |  | | |  | | |  | |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | |  | - | | | - | | | - | |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | |  | - | | | - | | | - | |  |
| Removal rate  (mm/min) | 9.5  10.5 | | | 13.0  15 | | | 13.0  15 | | | 15.0 | | 12.0 | |  | 9.5  10.5 | | | 13.0  15 | | | 15.0 | |  |
| Servo lump  state | 8 11 | | | 6 9 | | | 6 9 | | | 4 6 | | 3 5 | |  | 8 11 | | | 6 9 | | | 4 6 | |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  |  | | |  | | | Non  - | |  |
| 12 | | | 12 | | | 12 | | |  | 12 | | | 12 | | |  |
| Surface(micron) | 16 | | | 8 | | | 7.5 | | | 3 3.5 | | 2 2.5 | |  | 16 | | | 8 | | | 3 3.5 | |  |
| 01: E No. | E1016 | | | E1017 | | | E1018 | | | E1019 | | E1020 | |  | E1016 | | | E1017 | | | E1019 | |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |  | 0.200 | | | 0.200 | | | 0.200 | |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | | 1 | | | 1 | |  |
| 04:THICKNESS | 1.0 | | | 1.0 | | | 1.0 | | | 1.0 | | 1.0 | |  | 1.0 | | | 1.0 | | | 1.0 | |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | |  | 0 | | | 1 | | | 3 | |  |
| 06:ONA | 18 | | | 2 | | | 2 | | | 2 | | 2 | |  | 18 | | | 2 | | | 2 | |  |
| 07:ONB | 18 | | | 2 | | | 2 | | | 2 | | 2 | |  | 18 | | | 2 | | | 2 | |  |
| 08:ONC | 9 | | | 1 | | | 1 | | | 1 | | 1 | |  | 9 | | | 1 | | | 1 | |  |
| 09:OND | 8 | | | 1 | | | 1 | | | 1 | | 1 | |  | 8 | | | 1 | | | 1 | |  |
| 10:OFF | 100 | | | 200 | | | 200 | | | 10 | | 5 | |  | 100 | | | 200 | | | 10 | |  |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | |  | 10 | | | 10 | | | 5 | |  |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | | 150 | | | 150 | |  |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | | 150 | | | 150 | |  |
| 14:DCHG-S | 10 | | | 10 | | | 10 | | | 12 | | 10 | |  | 10 | | | 10 | | | 12 | |  |
| 15:DCHG-R | 10 | | | 10 | | | 10 | | | 12 | | 10 | |  | 10 | | | 10 | | | 12 | |  |
| 16:SV | 8 | | | 8 | | | 8 | | | 10 | | 8 | |  | 8 | | | 8 | | | 10 | |  |
| 17:RV | 8 | | | 8 | | | 8 | | | 10 | | 8 | |  | 8 | | | 8 | | | 10 | |  |
| 18:IPM | 15 | | | 10 | | | 10 | | | 18 | | 8 | |  | 15 | | | 10 | | | 18 | |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 8 | |  | 7 | | | 7 | | | 1 | |  |
| 20:SV.MODE | 62H | | | 71H | | | 71H | | | 31H | | 31H | |  | 62H | | | 71H | | | 31H | |  |
| 21:SV. | 4AH | | | 04H | | | 04H | | | 0EH | | 0EH | |  | 4AH | | | 04H | | | 0EH | |  |
| 22:SV.ADJ | 150 | | | 85 | | | 85 | | | 0 | | 0 | |  | 150 | | | 85 | | | 0 | |  |
| 23:SPEED | 10.00 | | | 18.00 | | | 18.00 | | | 15.00 | | 12.00 | |  | 10.00 | | | 18.00 | | | 15.00 | |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 13H | | 13H | |  | 33H | | | 33H | | | 13H | |  |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | | 01H | | 01H | |  | 04H | | | 01H | | | 01H | |  |
| 26:PRG0-1 | 0000H | | | D3DH | | | D3DH | | | F3DH | | 0C3CH | |  | 0000H | | | D3DH | | | F3DH | |  |
| 27:PRG0-2 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | | 00H | | | 00H | |  |
| 28:PRG0-3 | 00H | | | 9AH | | | 9AH | | | AAH | | AAH | |  | 00H | | | 9AH | | | AAH | |  |
| 29:PRG0-4 | 00H | | | AAH | | | AAH | | | AAH | | AAH | |  | 00H | | | AAH | | | AAH | |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | | 00H | | | 00H | |  |
| 31:PRG2-1 | 10 | | | 0 | | | 0 | | | 0 | | 0 | |  | 10 | | | 0 | | | 0 | |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  | 35 | | | 0 | | | 0 | |  |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | | 00H | | | 00H | |  |
| 34:PRG3-2 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | | 00H | | | 00H | |  |
| 35:PRG3-3 | 0 | | | 0 | | | 0 | | | 0 | | 0 | |  | 0 | | | 0 | | | 0 | |  |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | |  | 07H | | | 01H | | | 01H | |  |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |  | 0BH | | | 0BH | | | 0BH | |  |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | | 1 | | | 1 | |  |
| 39:ADC1-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | | 00H | | | 00H | |  |
| 40:ADC1-2 | 23H | | | 00H | | | 00H | | | 00H | | 00H | |  | 23H | | | 00H | | | 00H | |  |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | | 00H | | | 00H | |  |
| 42:ADC2-2 | 23H | | | 00H | | | 00H | | | 00H | | 00H | |  | 23H | | | 00H | | | 00H | |  |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | |  | 6 | | | 8 | | | 8 | |  |
| 44:OVERRIDE U | 80 | | | 100 | | | 100 | | | 100 | | 100 | |  | 80 | | | 100 | | | 100 | |  |
| 45:OVERRIDE L | 80 | | | 80 | | | 80 | | | 80 | | 80 | |  | 80 | | | 80 | | | 80 | |  |
| 46:WIRE FEED | 12 | | | 12 | | | 12 | | | 12 | | 12 | |  | 12 | | | 12 | | | 12 | |  |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | |  | 6 | | | 7 7 | | | | |  |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | |  | 15 | | | 15 | | | 15 | |  |
| 49:EST.SPEED | 10.0 | | | 13.5 | | | 13.5 | | | 15.0 | | 12.0 | |  | 10.0 | | | 13.5 | | | 15.0 | |  |

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|  |  |  |  |
| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 3 | | | | | | | | | | | | | | | 3 | | | | | | | | | |
| MODEL No. |  | | | | | | | | | | | | | | |  | | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | | 5th | |  | 1st | | | 2nd | | | 3rd | | |  |
| E No. | E1026 | | | E1027 | | | E1028 | | | E1029 | | | E1030 | |  | E1026 | | | E1027 | | | E1029 | | |  |
| H Value | V-corner | | |  | | |  | | |  | | |  | |  |  | | |  | | |  | | |  |
| Offset Roughing | 0.120 | | | - | | | - | | | - | | | - | |  |  | | |  | | |  | | |  |
|  | 0.145 | | | 0.105 | | | - | | | - | | | - | |  |  | | |  | | |  | | |  |
| Finish 7 | 0.158 | | | 0.118 | | | 0.106 | | | - | | | - | |  |  | | |  | | |  | | |  |
| Finish 3 | 0.162 | | | 0.122 | | | 0.110 | | | 0.104 | | | - | |  | 0.151 | | | 0.111 | | | 0.106 | | |  |
| Finish 2 | 0.164 | | | 0.124 | | | 0.112 | | | 0.106 | | | 0.106 | |  |  | | |  | | |  | | |  |
|  | 0.178 | | | 0.138  0.118 | | | -  0.106 | | | -  - | | | -  - | |  |  | | |  | | |  | | |  |
|  | 0.182 | | | 0.142  0.122 | | | 0.110 | | | 0.104 | | | -  - | |  |  | | |  | | |  | | |  |
|  | 0.184 | | | 0.144  0.124 | | | 0.112 | | | 0.106 | | | 0.106 | |  |  | | |  | | |  | | |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | | - | |  | - | | | - | | | - | | |  |
| Low(Mpa | - | | | - | | | - | | | - | | | - | |  | - | | | - | | | - | | |  |
| Removal rate  (mm/min) | 7.8  8.8 | | | 12.5  13.5 | | | 9.0  12. | | | 15.0 | | | 12.0 | |  | 7.8  8.8 | | | 12.5  13.5 | | | 15.0 | | |  |
| Servo lump  state | 8 11 | | | 7 9 | | | 5 7 | | | 3 5 | | | 3 5 | |  | 8 11 | | | 7 9 | | | 3 5 | | |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | | Non  - | |  |  | | |  | | | Non  - | | |  |
| 12 | | | 12 | | | 12 | | | 12 | | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3 3.5 | | | 2 2.5 | |  | 20 | | | 13 | | | 3 3.5 | | |  |
| 01: E No. | E1026 | | | E1027 | | | E1028 | | | E1029 | | | E1030 | |  | E1026 | | | E1027 | | | E1029 | | |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | |  | 0.200 | | | 0.200 | | | 0.200 | | |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | | 1 | |  | 1 | | | 1 | | | 1 | | |  |
| 04:THICKNESS | 3.0 | | | 3.0 | | | 3.0 | | | 3.0 | | | 3.0 | |  | 3.0 | | | 3.0 | | | 3.0 | | |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | | 3 | |  | 0 | | | 1 | | | 3 | | |  |
| 06:ONA | 30 | | | 6 | | | 2 | | | 2 | | | 2 | |  | 30 | | | 6 | | | 2 | | |  |
| 07:ONB | 30 | | | 6 | | | 2 | | | 2 | | | 2 | |  | 30 | | | 6 | | | 2 | | |  |
| 08:ONC | 15 | | | 6 | | | 1 | | | 1 | | | 1 | |  | 15 | | | 6 | | | 1 | | |  |
| 09:OND | 15 | | | 6 | | | 1 | | | 1 | | | 1 | |  | 15 | | | 6 | | | 1 | | |  |
| 10:OFF | 60 | | | 100 | | | 150 | | | 10 | | | 5 | |  | 60 | | | 100 | | | 10 | | |  |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | | 5 | |  | 10 | | | 10 | | | 5 | | |  |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | | 150 | |  | 250 | | | 150 | | | 150 | | |  |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | | 150 | |  | 250 | | | 150 | | | 150 | | |  |
| 14:DCHG-S | 10 | | | 10 | | | 10 | | | 12 | | | 10 | |  | 10 | | | 10 | | | 12 | | |  |
| 15:DCHG-R | 10 | | | 10 | | | 10 | | | 12 | | | 10 | |  | 10 | | | 10 | | | 12 | | |  |
| 16:SV | 8 | | | 8 | | | 8 | | | 10 | | | 8 | |  | 8 | | | 8 | | | 10 | | |  |
| 17:RV | 8 | | | 8 | | | 8 | | | 10 | | | 8 | |  | 8 | | | 8 | | | 10 | | |  |
| 18:IPM | 16 | | | 12 | | | 10 | | | 18 | | | 8 | |  | 16 | | | 12 | | | 18 | | |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | | 8 | |  | 7 | | | 7 | | | 1 | | |  |
| 20:SV.MODE | 62H | | | 71H | | | 71H | | | 31H | | | 31H | |  | 62H | | | 71H | | | 31H | | |  |
| 21:SV. | 4AH | | | 04H | | | 04H | | | 0EH | | | 0EH | |  | 4AH | | | 04H | | | 0EH | | |  |
| 22:SV.ADJ | 170 | | | 100 | | | 80 | | | 0 | | | 0 | |  | 170 | | | 100 | | | 0 | | |  |
| 23:SPEED | 10.00 | | | 18.00 | | | 15.00 | | | 15.00 | | | 12.00 | |  | 10.00 | | | 18.00 | | | 15.00 | | |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 13H | | | 12H | |  | 33H | | | 33H | | | 13H | | |  |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | | 01H | | | 01H | |  | 04H | | | 01H | | | 01H | | |  |
| 26:PRG0-1 | 0000H | | | D3DH | | | D3DH | | | F3DH | | | 0C3CH | |  | 0000H | | | D3DH | | | F3DH | | |  |
| 27:PRG0-2 | 00H | | | 00H | | | 00H | | | 00H | | | 00H | |  | 00H | | | 00H | | | 00H | | |  |
| 28:PRG0-3 | 00H | | | 9AH | | | 9AH | | | AAH | | | AAH | |  | 00H | | | 9AH | | | AAH | | |  |
| 29:PRG0-4 | 00H | | | AAH | | | AAH | | | AAH | | | AAH | |  | 00H | | | AAH | | | AAH | | |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | | 00H | |  | 00H | | | 00H | | | 00H | | |  |
| 31:PRG2-1 | 10 | | | 0 | | | 0 | | | 0 | | | 0 | |  | 10 | | | 0 | | | 0 | | |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | | 0 | |  | 35 | | | 0 | | | 0 | | |  |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | | 00H | |  | 00H | | | 00H | | | 00H | | |  |
| 34:PRG3-2 | 00H | | | 00H | | | 00H | | | 00H | | | 00H | |  | 00H | | | 00H | | | 00H | | |  |
| 35:PRG3-3 | 0 | | | 0 | | | 0 | | | 0 | | | 0 | |  | 0 | | | 0 | | | 0 | | |  |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | | 01H | |  | 07H | | | 01H | | | 01H | | |  |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | |  | 0BH | | | 0BH | | | 0BH | | |  |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | | 1 | |  | 1 | | | 1 | | | 1 | | |  |
| 39:ADC1-1 | 67H | | | 00H | | | 00H | | | 00H | | | 00H | |  | 67H | | | 00H | | | 00H | | |  |
| 40:ADC1-2 | 23H | | | 00H | | | 00H | | | 00H | | | 00H | |  | 23H | | | 00H | | | 00H | | |  |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | | 00H | |  | 67H | | | 00H | | | 00H | | |  |
| 42:ADC2-2 | 23H | | | 00H | | | 00H | | | 00H | | | 00H | |  | 23H | | | 00H | | | 00H | | |  |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | | 8 | |  | 6 | | | 8 | | | 8 | | |  |
| 44:OVERRIDE U | 100 | | | 100 | | | 100 | | | 100 | | | 100 | |  | 100 | | | 100 | | | 100 | | |  |
| 45:OVERRIDE L | 100 | | | 80 | | | 80 | | | 80 | | | 80 | |  | 100 | | | 80 | | | 80 | | |  |
| 46:WIRE FEED | 12 | | | 12 | | | 12 | | | 12 | | | 12 | |  | 12 | | | 12 | | | 12 | | |  |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | | 7 | |  | 6 | | | 7 7 | | | | | |  |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | | 15 | |  | 15 | | | 15 | | | 15 | | |  |
| 49:EST.SPEED | 8.2 | | | 13.2 | | | 11.2 | | | 15.0 | | | 12.0 | |  | 8.2 | | | 13.2 | | | 15.0 | | |  |

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| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 5 | | | | | | | | | | | | | | 5 | | | | | | | | | |
| MODEL No. |  | | | | | | | | | | | | | |  | | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |  | 1st | | | 2nd | | | 3rd | | |  |
| E No. | E1036 | | | E1037 | | | E1038 | | | E1039 | | E1040 | |  | E1036 | | | E1037 | | | E1039 | | |  |
| H Value | V-corner | | |  | | |  | | |  | |  | |  |  | | |  | | |  | | |  |
| Offset Roughing | 0.120 | | | - | | | - | | | - | | - | |  |  | | |  | | |  | | |  |
|  | 0.147 | | | 0.105 | | | - | | | - | | - | |  |  | | |  | | |  | | |  |
| Finish 7 | 0.156 | | | 0.114 | | | 0.102 | | | - | | - | |  |  | | |  | | |  | | |  |
| Finish 3 | 0.161 | | | 0.119 | | | 0.107 | | | 0.105 | | - | |  | 0.154 | | | 0.111 | | | 0.106 | | |  |
| Finish 2 | 0.163 | | | 0.121 | | | 0.109 | | | 0.107 | | 0.107 | |  |  | | |  | | |  | | |  |
|  | 0.176 | | | 0.134  0.114 | | | -  0.102 | | | -  - | | -  - | |  |  | | |  | | |  | | |  |
|  | 0.181 | | | 0.139  0.119 | | | -  0.107 | | | -  0.105 | | -  - | |  |  | | |  | | |  | | |  |
|  | 0.183 | | | 0.141  0.121 | | | -  0.109 | | | -  0.107 | | -  0.107 | |  |  | | |  | | |  | | |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | |  | - | | | - | | | - | | |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | |  | - | | | - | | | - | | |  |
| Removal rate  (mm/min) | 6.8  ~7.2 | | | 11.0  ~15.0 | | | 9.0  ~12.0 | | | 15.0 | | 10.0 | |  | 6.8  ~7.2 | | | 11.0  ~15.0 | | | 15.0 | | |  |
| Servo lump  state | 5 7 | | | 7 9 | | | 2 4 | | | 2 4 | | 3 5 | |  | 5 7 | | | 7 9 | | | 2 4 | | |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  |  | | |  | | | Non  - | | |  |
| 12 | | | 12 | | | 12 | | | 12 | | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3 3.5 | | 2 2.5 | |  | 20 | | | 13 | | | 3 3.5 | | |  |
| 01: E No. | E1036 | | | E1037 | | | E1038 | | | E1039 | | E1040 | |  | E1036 | | | E1037 | | | E1039 | | |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |  | 0.200 | | | 0.200 | | | 0.200 | | |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | | 1 | | | 1 | | |  |
| 04:THICKNESS | 5.0 | | | 5.0 | | | 5.0 | | | 5.0 | | 5.0 | |  | 5.0 | | | 5.0 | | | 5.0 | | |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | |  | 0 | | | 1 | | | 3 | | |  |
| 06:ONA | 30 | | | 6 | | | 2 | | | 2 | | 2 | |  | 30 | | | 6 | | | 2 | | |  |
| 07:ONB | 30 | | | 6 | | | 2 | | | 2 | | 2 | |  | 30 | | | 6 | | | 2 | | |  |
| 08:ONC | 15 | | | 6 | | | 1 | | | 1 | | 1 | |  | 15 | | | 6 | | | 1 | | |  |
| 09:OND | 15 | | | 6 | | | 1 | | | 1 | | 1 | |  | 15 | | | 6 | | | 1 | | |  |
| 10:OFF | 60 | | | 80 | | | 130 | | | 10 | | 5 | |  | 60 | | | 80 | | | 10 | | |  |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | |  | 10 | | | 10 | | | 5 | | |  |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | | 150 | | | 150 | | |  |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | | 150 | | | 150 | | |  |
| 14:DCHG-S | 10 | | | 10 | | | 10 | | | 12 | | 10 | |  | 10 | | | 10 | | | 12 | | |  |
| 15:DCHG-R | 10 | | | 10 | | | 10 | | | 12 | | 10 | |  | 10 | | | 10 | | | 12 | | |  |
| 16:SV | 8 | | | 8 | | | 8 | | | 10 | | 8 | |  | 8 | | | 8 | | | 10 | | |  |
| 17:RV | 8 | | | 8 | | | 8 | | | 10 | | 8 | |  | 8 | | | 8 | | | 10 | | |  |
| 18:IPM | 16 | | | 15 | | | 10 | | | 18 | | 8 | |  | 16 | | | 15 | | | 18 | | |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 8 | |  | 7 | | | 7 | | | 1 | | |  |
| 20:SV.MODE | 62H | | | 71H | | | 71H | | | 31H | | 31H | |  | 62H | | | 71H | | | 31H | | |  |
| 21:SV. | 4AH | | | 04H | | | 04H | | | 0EH | | 0EH | |  | 4AH | | | 04H | | | 0EH | | |  |
| 22:SV.ADJ | 120 | | | 95 | | | 57 | | | 0 | | 0 | |  | 120 | | | 95 | | | 0 | | |  |
| 23:SPEED | 10.00 | | | 18.00 | | | 15.00 | | | 15.00 | | 10.00 | |  | 10.00 | | | 18.00 | | | 15.00 | | |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 13H | | 12H | |  | 33H | | | 33H | | | 13H | | |  |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | | 01H | | 01H | |  | 04H | | | 01H | | | 01H | | |  |
| 26:PRG0-1 | 0000H | | | D3DH | | | D3DH | | | F3DH | | 0C3DH | |  | 0000H | | | D3DH | | | F3DH | | |  |
| 27:PRG0-2 | 00H | | | 11H | | | 11H | | | 00H | | 00H | |  | 00H | | | 11H | | | 00H | | |  |
| 28:PRG0-3 | 00H | | | 9AH | | | 9AH | | | AAH | | AAH | |  | 00H | | | 9AH | | | AAH | | |  |
| 29:PRG0-4 | 00H | | | AAH | | | AAH | | | AAH | | AAH | |  | 00H | | | AAH | | | AAH | | |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | | 00H | | | 00H | | |  |
| 31:PRG2-1 | 15 | | | 0 | | | 0 | | | 0 | | 0 | |  | 15 | | | 0 | | | 0 | | |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  | 35 | | | 0 | | | 0 | | |  |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | | 00H | | | 00H | | |  |
| 34:PRG3-2 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | | 00H | | | 00H | | |  |
| 35:PRG3-3 | 0 | | | 0 | | | 0 | | | 0 | | 0 | |  | 0 | | | 0 | | | 0 | | |  |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | |  | 07H | | | 01H | | | 01H | | |  |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |  | 0BH | | | 0BH | | | 0BH | | |  |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | | 1 | | | 1 | | |  |
| 39:ADC1-1 | 37H | | | 00H | | | 00H | | | 00H | | 00H | |  | 37H | | | 00H | | | 00H | | |  |
| 40:ADC1-2 | 23H | | | 00H | | | 00H | | | 00H | | 00H | |  | 23H | | | 00H | | | 00H | | |  |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | | 00H | | | 00H | | |  |
| 42:ADC2-2 | 23H | | | 00H | | | 00H | | | 00H | | 00H | |  | 23H | | | 00H | | | 00H | | |  |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | |  | 6 | | | 8 | | | 8 | | |  |
| 44:OVERRIDE U | 100 | | | 100 | | | 100 | | | 100 | | 100 | |  | 100 | | | 100 | | | 100 | | |  |
| 45:OVERRIDE L | 100 | | | 80 | | | 80 | | | 80 | | 80 | |  | 100 | | | 80 | | | 80 | | |  |
| 46:WIRE FEED | 16 | | | 15 | | | 15 | | | 15 | | 15 | |  | 16 | | | 15 | | | 15 | | |  |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | |  | 6 | | | 7 | | | 7 | | |  |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | |  | 15 | | | 15 | | | 15 | | |  |
| 49:EST.SPEED | 7.0 | | | 13.0 | | | 10.0 | | | 15.0 | | 10.0 | |  | 7.0 | | | 13.0 | | | 15.0 | | |  |

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| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 10 | | | | | | | | | | | | | | 10 | | | | | | | | |
| MODEL No. |  | | | | | | | | | | | | | |  | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |  | 1st | | 2nd | | | 3rd | | |  |
| E No. | E1046 | | | E1047 | | | E1048 | | | E1049 | | E1050 | |  | E1046 | | E1047 | | | E1049 | | |  |
| H Value | V-corner | | |  | | |  | | |  | |  | |  |  | |  | | |  | | |  |
| Offset Roughing | 0.128 | | | - | | | - | | | - | | - | |  |  | |  | | |  | | |  |
|  | 0.152 | | | 0.105 | | | - | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 7 | 0.161 | | | 0.114 | | | 0.102 | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 3 | 0.166 | | | 0.118 | | | 0.106 | | | 0.104 | | - | |  | 0.159 | | 0.110 | | | 0.105 | | |  |
| Finish 2 | 0.168 | | | 0.120 | | | 0.108 | | | 0.106 | | 0.106 | |  |  | |  | | |  | | |  |
|  | 0.181 | | | 0.134  0.114 | | | -  0.102 | | | -  - | | -  - | |  |  | |  | | |  | | |  |
|  | 0.186 | | | 0.138  0.118 | | | -  0.106 | | | -  0.104 | | -  - | |  |  | |  | | |  | | |  |
|  | 0.188 | | | 0.140  0.120 | | | -  0.108 | | | -  0.106 | | -  0.106 | |  |  | |  | | |  | | |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Removal rate  (mm/min) | 4.6  5.1 | | | 9.0  11.0 | | | 9.0  11.0 | | | 15.0 | | 10.0 | |  | 4.6  5.1 | | 9.0  11.0 | | | 15.0 | | |  |
| Servo lump  state | 4 6 | | | 6 8 | | | 1 3 | | | 2 4 | | 2 4 | |  | 4 6 | | 6 8 | | | 2 4 | | |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  |  | |  | | | Non  - | | |  |
| 12 | | | 12 | | | 12 | | | 12 | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3 3.5 | | 2 2.5 | |  | 20 | | 13 | | | 3 3.5 | | |  |
| 01: E No. | E1046 | | | E1047 | | | E1048 | | | E1049 | | E1050 | |  | E1046 | | E1047 | | | E1049 | | |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |  | 0.200 | | 0.200 | | | 0.200 | | |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 04:THICKNESS | 10.0 | | | 10.0 | | | 10.0 | | | 10.0 | | 10.0 | |  | 10.0 | | 10.0 | | | 10.0 | | |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | |  | 0 | | 1 | | | 3 | | |  |
| 06:ONA | 30 | | | 6 | | | 2 | | | 2 | | 2 | |  | 30 | | 6 | | | 2 | | |  |
| 07:ONB | 30 | | | 6 | | | 2 | | | 2 | | 2 | |  | 30 | | 6 | | | 2 | | |  |
| 08:ONC | 10 | | | 6 | | | 1 | | | 1 | | 1 | |  | 10 | | 6 | | | 1 | | |  |
| 09:OND | 12 | | | 6 | | | 1 | | | 1 | | 1 | |  | 12 | | 6 | | | 1 | | |  |
| 10:OFF | 70 | | | 70 | | | 80 | | | 10 | | 5 | |  | 70 | | 70 | | | 10 | | |  |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | |  | 10 | | 10 | | | 5 | | |  |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 14:DCHG-S | 10 | | | 10 | | | 10 | | | 15 | | 12 | |  | 10 | | 10 | | | 15 | | |  |
| 15:DCHG-R | 10 | | | 10 | | | 10 | | | 15 | | 12 | |  | 10 | | 10 | | | 15 | | |  |
| 16:SV | 8 | | | 8 | | | 8 | | | 12 | | 10 | |  | 8 | | 8 | | | 12 | | |  |
| 17:RV | 8 | | | 8 | | | 8 | | | 12 | | 10 | |  | 8 | | 8 | | | 12 | | |  |
| 18:IPM | 20 | | | 15 | | | 10 | | | 18 | | 8 | |  | 20 | | 15 | | | 18 | | |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 8 | |  | 7 | | 7 | | | 1 | | |  |
| 20:SV.MODE | 62H | | | 71H | | | 71H | | | 31H | | 31H | |  | 62H | | 71H | | | 31H | | |  |
| 21:SV. | 4AH | | | 04H | | | 02H | | | 0EH | | 0EH | |  | 4AH | | 04H | | | 0EH | | |  |
| 22:SV.ADJ | 120 | | | 90 | | | 47 | | | 0 | | 0 | |  | 120 | | 90 | | | 0 | | |  |
| 23:SPEED | 50.00 | | | 15.00 | | | 15.00 | | | 15.00 | | 10.00 | |  | 50.00 | | 15.00 | | | 15.00 | | |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 13H | | 12H | |  | 33H | | 33H | | | 13H | | |  |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | | 01H | | 01H | |  | 04H | | 01H | | | 01H | | |  |
| 26:PRG0-1 | 0000H | | | 0F3DH | | | 0F3DH | | | 0F3DH | | 0C3DH | |  | 0000H | | 0F3DH | | | 0F3DH | | |  |
| 27:PRG0-2 | 00H | | | 11H | | | 11H | | | 00H | | 00H | |  | 00H | | 11H | | | 00H | | |  |
| 28:PRG0-3 | 00H | | | 9AH | | | 9AH | | | AAH | | AAH | |  | 00H | | 9AH | | | AAH | | |  |
| 29:PRG0-4 | 00H | | | AAH | | | AAH | | | AAH | | AAH | |  | 00H | | AAH | | | AAH | | |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 31:PRG2-1 | 15 | | | 0 | | | 0 | | | 0 | | 0 | |  | 15 | | 0 | | | 0 | | |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  | 35 | | 0 | | | 0 | | |  |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 34:PRG3-2 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 35:PRG3-3 | 0 | | | 0 | | | 0 | | | 0 | | 0 | |  | 0 | | 0 | | | 0 | | |  |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | |  | 07H | | 01H | | | 01H | | |  |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |  | 0BH | | 0BH | | | 0BH | | |  |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 39:ADC1-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 40:ADC1-2 | 23H | | | 00H | | | 00H | | | 00H | | 00H | |  | 23H | | 00H | | | 00H | | |  |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 42:ADC2-2 | 23H | | | 00H | | | 00H | | | 00H | | 00H | |  | 23H | | 00H | | | 00H | | |  |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | |  | 6 | | 8 | | | 8 | | |  |
| 44:OVERRIDE U | 100 | | | 100 | | | 100 | | | 100 | | 100 | |  | 100 | | 100 | | | 100 | | |  |
| 45:OVERRIDE L | 100 | | | 80 | | | 80 | | | 80 | | 80 | |  | 100 | | 80 | | | 80 | | |  |
| 46:WIRE FEED | 16 | | | 15 | | | 15 | | | 15 | | 15 | |  | 16 | | 15 | | | 15 | | |  |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | |  | 6 | | 7 | | | 7 | | |  |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | |  | 15 | | 15 | | | 15 | | |  |
| 49:EST.SPEED | 5.1 | | | 10.0 | | | 10.0 | | | 15.0 | | 10.0 | |  | 5.1 | | 10.0 | | | 15.0 | | |  |

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|  |  |  |  |
| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 15 | | | | | | | | | | | | | | 15 | | | | | | | | |
| MODEL No. |  | | | | | | | | | | | | | |  | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |  | 1st | | 2nd | | | 3rd | | |  |
| E No. | E1056 | | | E1057 | | | E1058 | | | E1059 | | E1060 | |  | E1056 | | E1057 | | | E1059 | | |  |
| H Value | V-corner | | |  | | |  | | |  | |  | |  |  | |  | | |  | | |  |
| Offset Roughing | 0.130 | | | - | | | - | | | - | | - | |  |  | |  | | |  | | |  |
|  | 0.154 | | | 0.105 | | | - | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 7 | 0.163 | | | 0.114 | | | 0.102 | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 3 | 0.168 | | | 0.118 | | | 0.106 | | | 0.104 | | - | |  | 0.161 | | 0.110 | | | 0.105 | | |  |
| Finish 2 | 0.170 | | | 0.120 | | | 0.108 | | | 0.106 | | 0.106 | |  |  | |  | | |  | | |  |
|  | 0.183 | | | 0.134  0.114 | | | -  0.102 | | | -  - | | -  - | |  |  | |  | | |  | | |  |
|  | 0.188 | | | 0.138  0.118 | | | -  0.106 | | | -  0.104 | | -  - | |  |  | |  | | |  | | |  |
|  | 0.190 | | | 0.140  0.120 | | | -  0.108 | | | -  0.106 | | -  0.106 | |  |  | |  | | |  | | |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Removal rate  (mm/min) | 4.1  4.5 | | | 5.5  9.2 | | | 9.0  11.0 | | | 15.0 | | 8.0 | |  | 4.1  4.5 | | 5.5  9.2 | | | 15.0 | | |  |
| Servo lump  state | 4 6 | | | 5 7 | | | 1 3 | | | 2 4 | | 1 3 | |  | 4 6 | | 5 7 | | | 2 4 | | |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  |  | |  | | | Non  - | | |  |
| 12 | | | 12 | | | 12 | | | 12 | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3 3.5 | | 2 2.5 | |  | 20 | | 13 | | | 3 3.5 | | |  |
| 01: E No. | E1056 | | | E1057 | | | E1058 | | | E1059 | | E1060 | |  | E1056 | | E1057 | | | E1059 | | |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |  | 0.200 | | 0.200 | | | 0.200 | | |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 04:THICKNESS | 15.0 | | | 15.0 | | | 15.0 | | | 15.0 | | 15.0 | |  | 15.0 | | 15.0 | | | 15.0 | | |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | |  | 0 | | 1 | | | 3 | | |  |
| 06:ONA | 30 | | | 6 | | | 2 | | | 2 | | 2 | |  | 30 | | 6 | | | 2 | | |  |
| 07:ONB | 30 | | | 6 | | | 2 | | | 2 | | 2 | |  | 30 | | 6 | | | 2 | | |  |
| 08:ONC | 10 | | | 6 | | | 1 | | | 1 | | 1 | |  | 10 | | 6 | | | 1 | | |  |
| 09:OND | 12 | | | 6 | | | 1 | | | 1 | | 1 | |  | 12 | | 6 | | | 1 | | |  |
| 10:OFF | 60 | | | 70 | | | 80 | | | 10 | | 5 | |  | 60 | | 70 | | | 10 | | |  |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | |  | 10 | | 10 | | | 5 | | |  |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 14:DCHG-S | 12 | | | 10 | | | 10 | | | 15 | | 12 | |  | 12 | | 10 | | | 15 | | |  |
| 15:DCHG-R | 12 | | | 10 | | | 10 | | | 15 | | 12 | |  | 12 | | 10 | | | 15 | | |  |
| 16:SV | 10 | | | 8 | | | 8 | | | 12 | | 10 | |  | 10 | | 8 | | | 12 | | |  |
| 17:RV | 10 | | | 8 | | | 8 | | | 12 | | 10 | |  | 10 | | 8 | | | 12 | | |  |
| 18:IPM | 21 | | | 15 | | | 12 | | | 18 | | 8 | |  | 21 | | 15 | | | 18 | | |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 8 | |  | 7 | | 7 | | | 1 | | |  |
| 20:SV.MODE | 62H | | | 71H | | | 71H | | | 31H | | 31H | |  | 62H | | 71H | | | 31H | | |  |
| 21:SV. | 4AH | | | 04H | | | 02H | | | 0EH | | 0EH | |  | 4AH | | 04H | | | 0EH | | |  |
| 22:SV.ADJ | 120 | | | 87 | | | 40 | | | 0 | | 0 | |  | 120 | | 87 | | | 0 | | |  |
| 23:SPEED | 50.00 | | | 15.00 | | | 15.00 | | | 15.00 | | 8.00 | |  | 50.00 | | 15.00 | | | 15.00 | | |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 12H | | 11H | |  | 33H | | 33H | | | 12H | | |  |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | | 01H | | 01H | |  | 04H | | 01H | | | 01H | | |  |
| 26:PRG0-1 | 0000H | | | 0F3DH | | | 0F3DH | | | 0F3DH | | 0C3DH | |  | 0000H | | 0F3DH | | | 0F3DH | | |  |
| 27:PRG0-2 | 00H | | | 22H | | | 22H | | | 00H | | 00H | |  | 00H | | 22H | | | 00H | | |  |
| 28:PRG0-3 | 00H | | | 9AH | | | 9AH | | | AAH | | AAH | |  | 00H | | 9AH | | | AAH | | |  |
| 29:PRG0-4 | 00H | | | AAH | | | AAH | | | AAH | | AAH | |  | 00H | | AAH | | | AAH | | |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 31:PRG2-1 | 20 | | | 0 | | | 0 | | | 0 | | 0 | |  | 20 | | 0 | | | 0 | | |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  | 35 | | 0 | | | 0 | | |  |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 34:PRG3-2 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 35:PRG3-3 | 0 | | | 0 | | | 0 | | | 0 | | 0 | |  | 0 | | 0 | | | 0 | | |  |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | |  | 07H | | 01H | | | 01H | | |  |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |  | 0BH | | 0BH | | | 0BH | | |  |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 39:ADC1-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 40:ADC1-2 | 23H | | | 00H | | | 00H | | | 00H | | 00H | |  | 23H | | 00H | | | 00H | | |  |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 42:ADC2-2 | 23H | | | 00H | | | 00H | | | 00H | | 00H | |  | 23H | | 00H | | | 00H | | |  |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | |  | 6 | | 8 | | | 8 | | |  |
| 44:OVERRIDE U | 140 | | | 100 | | | 100 | | | 100 | | 100 | |  | 140 | | 100 | | | 100 | | |  |
| 45:OVERRIDE L | 140 | | | 80 | | | 80 | | | 80 | | 80 | |  | 140 | | 80 | | | 80 | | |  |
| 46:WIRE FEED | 16 | | | 15 | | | 15 | | | 15 | | 15 | |  | 16 | | 15 | | | 15 | | |  |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | |  | 6 | | 7 | | | 7 | | |  |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | |  | 15 | | 15 | | | 15 | | |  |
| 49:EST.SPEED | 4.5 | | | 7.5 | | | 10.0 | | | 15.0 | | 8.0 | |  | 4.5 | | 7.5 | | | 15.0 | | |  |

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|  |  |  |  |
| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 20 | | | | | | | | | | | | | | 20 | | | | | | | | |
| MODEL No. |  | | | | | | | | | | | | | |  | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |  | 1st | | 2nd | | | 3rd | | |  |
| E No. | E1066 | | | E1067 | | | E1068 | | | E1069 | | E1070 | |  | E1066 | | E1067 | | | E1069 | | |  |
| H Value | V-corner | | |  | | |  | | |  | |  | |  |  | |  | | |  | | |  |
| Offset Roughing | 0.132 | | | - | | | - | | | - | | - | |  |  | |  | | |  | | |  |
|  | 0.156 | | | 0.105 | | | - | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 7 | 0.165 | | | 0.114 | | | 0.102 | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 3 | 0.169 | | | 0.118 | | | 0.106 | | | 0.104 | | - | |  | 0.163 | | 0.111 | | | 0.106 | | |  |
| Finish 2 | 0.171 | | | 0.120 | | | 0.108 | | | 0.106 | | 0.106 | |  |  | |  | | |  | | |  |
|  | 0.189 | | | 0.134  0.114 | | | -  0.102 | | | -  - | | -  - | |  |  | |  | | |  | | |  |
|  | 0.191 | | | 0.138  0.118 | | | -  0.106 | | | -  0.104 | | -  - | |  |  | |  | | |  | | |  |
|  | 0.199 | | | 0.140  0.120 | | | -  0.108 | | | -  0.106 | | -  0.106 | |  |  | |  | | |  | | |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Removal rate  (mm/min) | 3.2  3.6 | | | 4.5  8.5 | | | 7.0  9.0 | | | 15.0 | | 8.0 | |  | 3.2  3.6 | | 4.5  8.5 | | | 15.0 | | |  |
| Servo lump  state | 4 6 | | | 5 7 | | | 1 3 | | | 2 4 | | 4 6 | |  | 4 6 | | 5 7 | | | 2 4 | | |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  |  | |  | | | Non  - | | |  |
| 12 | | | 12 | | | 12 | | | 12 | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3 3.5 | | 2 2.5 | |  | 20 | | 13 | | | 3 3.5 | | |  |
| 01: E No. | E1066 | | | E1067 | | | E1068 | | | E1069 | | E1070 | |  | E1066 | | E1067 | | | E1069 | | |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |  | 0.200 | | 0.200 | | | 0.200 | | |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 04:THICKNESS | 20.0 | | | 20.0 | | | 20.0 | | | 20.0 | | 20.0 | |  | 20.0 | | 20.0 | | | 20.0 | | |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | |  | 0 | | 1 | | | 3 | | |  |
| 06:ONA | 30 | | | 6 | | | 2 | | | 2 | | 2 | |  | 30 | | 6 | | | 2 | | |  |
| 07:ONB | 30 | | | 6 | | | 2 | | | 2 | | 2 | |  | 30 | | 6 | | | 2 | | |  |
| 08:ONC | 10 | | | 6 | | | 1 | | | 1 | | 1 | |  | 10 | | 6 | | | 1 | | |  |
| 09:OND | 12 | | | 6 | | | 1 | | | 1 | | 1 | |  | 12 | | 6 | | | 1 | | |  |
| 10:OFF | 60 | | | 70 | | | 80 | | | 10 | | 5 | |  | 60 | | 70 | | | 10 | | |  |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | |  | 10 | | 10 | | | 5 | | |  |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 14:DCHG-S | 12 | | | 10 | | | 10 | | | 18 | | 15 | |  | 12 | | 10 | | | 18 | | |  |
| 15:DCHG-R | 12 | | | 10 | | | 10 | | | 18 | | 15 | |  | 12 | | 10 | | | 18 | | |  |
| 16:SV | 10 | | | 8 | | | 8 | | | 16 | | 12 | |  | 10 | | 8 | | | 16 | | |  |
| 17:RV | 10 | | | 8 | | | 8 | | | 16 | | 12 | |  | 10 | | 8 | | | 16 | | |  |
| 18:IPM | 21 | | | 15 | | | 12 | | | 18 | | 8 | |  | 21 | | 15 | | | 18 | | |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 8 | |  | 7 | | 7 | | | 1 | | |  |
| 20:SV.MODE | 62H | | | 71H | | | 71H | | | 31H | | 31H | |  | 62H | | 71H | | | 31H | | |  |
| 21:SV. | 4AH | | | 04H | | | 02H | | | 0EH | | 0EH | |  | 4AH | | 04H | | | 0EH | | |  |
| 22:SV.ADJ | 120 | | | 87 | | | 38 | | | 0 | | 0 | |  | 120 | | 87 | | | 0 | | |  |
| 23:SPEED | 50.00 | | | 15.00 | | | 15.00 | | | 15.00 | | 8.00 | |  | 50.00 | | 15.00 | | | 15.00 | | |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 13H | | 11H | |  | 33H | | 33H | | | 13H | | |  |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | | 01H | | 01H | |  | 04H | | 01H | | | 01H | | |  |
| 26:PRG0-1 | 0000H | | | 0F3DH | | | 0F3DH | | | 0F3DH | | 0C3D | |  | 0000H | | 0F3DH | | | 0F3DH | | |  |
| 27:PRG0-2 | 00H | | | 22H | | | 22H | | | 11H | | 00H | |  | 00H | | 22H | | | 11H | | |  |
| 28:PRG0-3 | 00H | | | 9AH | | | 9AH | | | AAH | | AAH | |  | 00H | | 9AH | | | AAH | | |  |
| 29:PRG0-4 | 00H | | | AAH | | | AAH | | | AAH | | AAH | |  | 00H | | AAH | | | AAH | | |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 31:PRG2-1 | 30 | | | 0 | | | 0 | | | 0 | | 0 | |  | 30 | | 0 | | | 0 | | |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  | 35 | | 0 | | | 0 | | |  |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 34:PRG3-2 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 35:PRG3-3 | 0 | | | 0 | | | 0 | | | 0 | | 0 | |  | 0 | | 0 | | | 0 | | |  |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | |  | 07H | | 01H | | | 01H | | |  |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |  | 0BH | | 0BH | | | 0BH | | |  |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 39:ADC1-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 40:ADC1-2 | 23H | | | 00H | | | 00H | | | 00H | | 00H | |  | 23H | | 00H | | | 00H | | |  |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 42:ADC2-2 | 23H | | | 00H | | | 00H | | | 00H | | 00H | |  | 23H | | 00H | | | 00H | | |  |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | |  | 6 | | 8 | | | 8 | | |  |
| 44:OVERRIDE U | 140 | | | 100 | | | 100 | | | 100 | | 100 | |  | 140 | | 100 | | | 100 | | |  |
| 45:OVERRIDE L | 140 | | | 80 | | | 80 | | | 80 | | 80 | |  | 140 | | 80 | | | 80 | | |  |
| 46:WIRE FEED | 16 | | | 15 | | | 15 | | | 15 | | 15 | |  | 16 | | 15 | | | 15 | | |  |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | |  | 6 | | 7 | | | 7 | | |  |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | |  | 15 | | 15 | | | 15 | | |  |
| 49:EST.SPEED | 3.6 | | | 6.7 | | | 8.0 | | | 15.0 | | 8.0 | |  | 3.6 | | 6.7 | | | 15.0 | | |  |

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|  |  |  |  |
| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 25 | | | | | | | | | | | | | | 25 | | | | | | | | |
| MODEL No. |  | | | | | | | | | | | | | |  | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |  | 1st | | 2nd | | | 3rd | | |  |
| E No. | E1076 | | | E1077 | | | E1078 | | | E1079 | | E1080 | |  | E1076 | | E1077 | | | E1079 | | |  |
| H Value | V-corner | | |  | | |  | | |  | |  | |  |  | |  | | |  | | |  |
| Offset Roughing | 0.135 | | | - | | | - | | | - | | - | |  |  | |  | | |  | | |  |
|  | 0.159 | | | 0.105 | | | - | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 7 | 0.168 | | | 0.114 | | | 0.102 | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 3 | 0.173 | | | 0.119 | | | 0.107 | | | 0.105 | | - | |  | 0.166 | | 0.111 | | | 0.106 | | |  |
| Finish 2 | 0.175 | | | 0.121 | | | 0.109 | | | 0.107 | | 0.107 | |  |  | |  | | |  | | |  |
|  | 0.188 | | | 0.134  0.114 | | | -  0.102 | | | -  - | | -  - | |  |  | |  | | |  | | |  |
|  | 0.193 | | | 0.139  0.119 | | | -  0.107 | | | -  0.105 | | -  - | |  |  | |  | | |  | | |  |
|  | 0.195 | | | 0.141  0.121 | | | -  0.109 | | | -  0.107 | | -  0.107 | |  |  | |  | | |  | | |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Removal rate  (mm/min) | 2.6  2.8 | | | 4.5  7.0 | | | 5.5  7.5 | | | 15.0 | | 8.0 | |  | 2.6  2.8 | | 4.5  7.0 | | | 15.0 | | |  |
| Servo lump  state | 4 6 | | | 5 7 | | | 1 3 | | | 3 5 | | 3 5 | |  | 4 6 | | 5 7 | | | 3 5 | | |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  |  | |  | | | Non  - | | |  |
| 12 | | | 12 | | | 12 | | | 12 | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3.3 3.8 | | 2.3 2.8 | |  | 20 | | 13 | | | 3.3 3.8 | | |  |
| 01: E No. | E1076 | | | E1077 | | | E1078 | | | E1079 | | E1080 | |  | E1076 | | E1077 | | | E1079 | | |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |  | 0.200 | | 0.200 | | | 0.200 | | |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 04:THICKNESS | 25.0 | | | 25.0 | | | 25.0 | | | 25.0 | | 25.0 | |  | 25.0 | | 25.0 | | | 25.0 | | |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | |  | 0 | | 1 | | | 3 | | |  |
| 06:ONA | 30 | | | 6 | | | 2 | | | 2 | | 2 | |  | 30 | | 6 | | | 2 | | |  |
| 07:ONB | 50 | | | 6 | | | 2 | | | 2 | | 2 | |  | 50 | | 6 | | | 2 | | |  |
| 08:ONC | 10 | | | 6 | | | 1 | | | 1 | | 1 | |  | 10 | | 6 | | | 1 | | |  |
| 09:OND | 12 | | | 6 | | | 1 | | | 1 | | 1 | |  | 12 | | 6 | | | 1 | | |  |
| 10:OFF | 95 | | | 70 | | | 80 | | | 10 | | 5 | |  | 95 | | 70 | | | 10 | | |  |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | |  | 10 | | 10 | | | 5 | | |  |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 14:DCHG-S | 12 | | | 10 | | | 10 | | | 18 | | 15 | |  | 12 | | 10 | | | 18 | | |  |
| 15:DCHG-R | 12 | | | 10 | | | 10 | | | 18 | | 15 | |  | 12 | | 10 | | | 18 | | |  |
| 16:SV | 10 | | | 8 | | | 8 | | | 16 | | 12 | |  | 10 | | 8 | | | 16 | | |  |
| 17:RV | 10 | | | 8 | | | 8 | | | 16 | | 12 | |  | 10 | | 8 | | | 16 | | |  |
| 18:IPM | 22 | | | 15 | | | 13 | | | 18 | | 8 | |  | 22 | | 15 | | | 18 | | |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 8 | |  | 7 | | 7 | | | 1 | | |  |
| 20:SV.MODE | 62H | | | 71H | | | 71H | | | 31H | | 31H | |  | 62H | | 71H | | | 31H | | |  |
| 21:SV. | 4AH | | | 04H | | | 02H | | | 0EH | | 0EH | |  | 4AH | | 04H | | | 0EH | | |  |
| 22:SV.ADJ | 105 | | | 82 | | | 38 | | | 0 | | 0 | |  | 105 | | 82 | | | 0 | | |  |
| 23:SPEED | 50.00 | | | 12.00 | | | 12.00 | | | 15.00 | | 8.00 | |  | 50.00 | | 12.00 | | | 15.00 | | |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 12H | | 11H | |  | 33H | | 33H | | | 12H | | |  |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | | 01H | | 01H | |  | 04H | | 01H | | | 01H | | |  |
| 26:PRG0-1 | 0000H | | | 0F3DH | | | 0F3DH | | | 0F3DH | | 0C3DH | |  | 0000H | | 0F3DH | | | 0F3DH | | |  |
| 27:PRG0-2 | 00H | | | 22H | | | 22H | | | 11H | | 11H | |  | 00H | | 22H | | | 11H | | |  |
| 28:PRG0-3 | 00H | | | 9AH | | | 9AH | | | AAH | | AAH | |  | 00H | | 9AH | | | AAH | | |  |
| 29:PRG0-4 | 00H | | | AAH | | | AAH | | | AAH | | AAH | |  | 00H | | AAH | | | AAH | | |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 31:PRG2-1 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  | 35 | | 0 | | | 0 | | |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  | 35 | | 0 | | | 0 | | |  |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 34:PRG3-2 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 35:PRG3-3 | 0 | | | 0 | | | 0 | | | 0 | | 0 | |  | 0 | | 0 | | | 0 | | |  |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | |  | 07H | | 01H | | | 01H | | |  |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |  | 0BH | | 0BH | | | 0BH | | |  |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 39:ADC1-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 40:ADC1-2 | 23H | | | 00H | | | 00H | | | 00H | | 00H | |  | 23H | | 00H | | | 00H | | |  |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 42:ADC2-2 | 23H | | | 00H | | | 00H | | | 00H | | 00H | |  | 23H | | 00H | | | 00H | | |  |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | |  | 6 | | 8 | | | 8 | | |  |
| 44:OVERRIDE U | 140 | | | 100 | | | 100 | | | 100 | | 100 | |  | 140 | | 100 | | | 100 | | |  |
| 45:OVERRIDE L | 140 | | | 80 | | | 80 | | | 80 | | 80 | |  | 140 | | 80 | | | 80 | | |  |
| 46:WIRE FEED | 16 | | | 15 | | | 15 | | | 15 | | 15 | |  | 16 | | 15 | | | 15 | | |  |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | |  | 6 | | 7 | | | 7 | | |  |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | |  | 15 | | 15 | | | 15 | | |  |
| 49:EST.SPEED | 2.9 | | | 6.3 | | | 6.8 | | | 15.0 | | 8.0 | |  | 2.9 | | 6.3 | | | 15.0 | | |  |

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|  |  |  |  |
| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 30 | | | | | | | | | | | | | | 30 | | | | | | | | |
| MODEL No. |  | | | | | | | | | | | | | |  | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |  | 1st | | 2nd | | | 3rd | | |  |
| E No. | E1086 | | | E1087 | | | E1088 | | | E1089 | | E1090 | |  | E1086 | | E1087 | | | E1089 | | |  |
| H Value | V-corner | | |  | | |  | | |  | |  | |  |  | |  | | |  | | |  |
| Offset Roughing | 0.135 | | | - | | | - | | | - | | - | |  |  | |  | | |  | | |  |
|  | 0.159 | | | 0.105 | | | - | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 7 | 0.168 | | | 0.114 | | | 0.102 | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 3 | 0.173 | | | 0.119 | | | 0.107 | | | 0.105 | | - | |  | 0.166 | | 0.111 | | | 0.106 | | |  |
| Finish 2 | 0.175 | | | 0.121 | | | 0.109 | | | 0.107 | | 0.107 | |  |  | |  | | |  | | |  |
|  | 0.188 | | | 0.134  0.114 | | | -  0.102 | | | -  - | | -  - | |  |  | |  | | |  | | |  |
|  | 0.193 | | | 0.139  0.119 | | | -  0.107 | | | -  0.105 | | -  - | |  |  | |  | | |  | | |  |
|  | 0.195 | | | 0.141  0.121 | | | -  0.109 | | | -  0.107 | | -  0.107 | |  |  | |  | | |  | | |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Removal rate  (mm/min) | 2.0 | | | 4.5  6.5 | | | 5.5  7.5 | | | 15.0 | | 8.0 | |  | 2.0  2.3 | | 4.5  6.5 | | | 15.0 | | |  |
| Servo lump  state | 4 6 | | | 5 7 | | | 1 3 | | | 2 4 | | 2 4 | |  | 4 6 | | 5 7 | | | 2 4 | | |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  |  | |  | | | Non  - | | |  |
| 12 | | | 12 | | | 12 | | | 12 | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3.3 3.8 | | 2.3 2.8 | |  | 20 | | 13 | | | 3.3 3.8 | | |  |
| 01: E No. | E1086 | | | E1087 | | | E1088 | | | E1089 | | E1090 | |  | E1086 | | E1087 | | | E1089 | | |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |  | 0.200 | | 0.200 | | | 0.200 | | |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 04:THICKNESS | 30.0 | | | 30.0 | | | 30.0 | | | 30.0 | | 30.0 | |  | 30.0 | | 30.0 | | | 30.0 | | |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | |  | 0 | | 1 | | | 3 | | |  |
| 06:ONA | 30 | | | 6 | | | 2 | | | 2 | | 2 | |  | 30 | | 6 | | | 2 | | |  |
| 07:ONB | 50 | | | 6 | | | 2 | | | 2 | | 2 | |  | 50 | | 6 | | | 2 | | |  |
| 08:ONC | 10 | | | 6 | | | 1 | | | 1 | | 1 | |  | 10 | | 6 | | | 1 | | |  |
| 09:OND | 12 | | | 6 | | | 1 | | | 1 | | 1 | |  | 12 | | 6 | | | 1 | | |  |
| 10:OFF | 95 | | | 70 | | | 80 | | | 10 | | 5 | |  | 95 | | 70 | | | 10 | | |  |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | |  | 10 | | 10 | | | 5 | | |  |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 14:DCHG-S | 12 | | | 10 | | | 10 | | | 18 | | 15 | |  | 12 | | 10 | | | 18 | | |  |
| 15:DCHG-R | 12 | | | 10 | | | 10 | | | 18 | | 15 | |  | 12 | | 10 | | | 18 | | |  |
| 16:SV | 10 | | | 8 | | | 8 | | | 16 | | 12 | |  | 10 | | 8 | | | 16 | | |  |
| 17:RV | 10 | | | 8 | | | 8 | | | 16 | | 12 | |  | 10 | | 8 | | | 16 | | |  |
| 18:IPM | 22 | | | 16 | | | 14 | | | 18 | | 8 | |  | 22 | | 16 | | | 18 | | |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 8 | |  | 7 | | 7 | | | 1 | | |  |
| 20:SV.MODE | 62H | | | 71H | | | 71H | | | 31H | | 31H | |  | 62H | | 71H | | | 31H | | |  |
| 21:SV. | 4AH | | | 04H | | | 02H | | | 0EH | | 0EH | |  | 4AH | | 04H | | | 0EH | | |  |
| 22:SV.ADJ | 105 | | | 82 | | | 38 | | | 0 | | 0 | |  | 105 | | 82 | | | 0 | | |  |
| 23:SPEED | 50.00 | | | 12.00 | | | 12.00 | | | 15.00 | | 8.00 | |  | 50.00 | | 12.00 | | | 15.00 | | |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 12H | | 11H | |  | 33H | | 33H | | | 12H | | |  |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | | 01H | | 01H | |  | 04H | | 01H | | | 01H | | |  |
| 26:PRG0-1 | 0000H | | | 0F3DH | | | 0F3DH | | | 0F3DH | | 0C3DH | |  | 0000H | | 0F3DH | | | 0F3DH | | |  |
| 27:PRG0-2 | 00H | | | 22H | | | 22H | | | 11H | | 11H | |  | 00H | | 22H | | | 11H | | |  |
| 28:PRG0-3 | 00H | | | 9AH | | | 9AH | | | AAH | | AAH | |  | 00H | | 9AH | | | AAH | | |  |
| 29:PRG0-4 | 00H | | | AAH | | | AAH | | | AAH | | AAH | |  | 00H | | AAH | | | AAH | | |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 31:PRG2-1 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  | 35 | | 0 | | | 0 | | |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  | 35 | | 0 | | | 0 | | |  |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 34:PRG3-2 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 35:PRG3-3 | 0 | | | 0 | | | 0 | | | 0 | | 0 | |  | 0 | | 0 | | | 0 | | |  |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | |  | 07H | | 01H | | | 01H | | |  |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |  | 0BH | | 0BH | | | 0BH | | |  |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 39:ADC1-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 40:ADC1-2 | 23H | | | 00H | | | 00H | | | 00H | | 00H | |  | 23H | | 00H | | | 00H | | |  |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 42:ADC2-2 | 23H | | | 00H | | | 00H | | | 00H | | 00H | |  | 23H | | 00H | | | 00H | | |  |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | |  | 6 | | 8 | | | 8 | | |  |
| 44:OVERRIDE U | 140 | | | 100 | | | 100 | | | 100 | | 100 | |  | 140 | | 100 | | | 100 | | |  |
| 45:OVERRIDE L | 140 | | | 80 | | | 80 | | | 80 | | 80 | |  | 140 | | 80 | | | 80 | | |  |
| 46:WIRE FEED | 16 | | | 15 | | | 15 | | | 15 | | 15 | |  | 16 | | 15 | | | 15 | | |  |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | |  | 6 | | 7 | | | 7 | | |  |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | |  | 15 | | 15 | | | 15 | | |  |
| 49:EST.SPEED | 2.4 | | | 5.5 | | | 6.5 | | | 15.0 | | 8.0 | |  | 2.4 | | 5.5 | | | 15.0 | | |  |

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| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 40 | | | | | | | | | | | | | | 40 | | | | | | | | |
| MODEL No. |  | | | | | | | | | | | | | |  | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |  | 1st | | 2nd | | | 3rd | | |  |
| E No. | E1096 | | | E1097 | | | E1098 | | | E1099 | | E1100 | |  | E1096 | | E1097 | | | E1099 | | |  |
| H Value | V-corner | | |  | | |  | | |  | |  | |  |  | |  | | |  | | |  |
| Offset Roughing | 0.140 | | | - | | | - | | | - | | - | |  |  | |  | | |  | | |  |
|  | 0.162 | | | 0.105 | | | - | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 7 | 0.173 | | | 0.116 | | | 0.104 | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 3 | 0.178 | | | 0.120 | | | 0.108 | | | 0.106 | | - | |  | 0.171 | | 0.113 | | | 0.106 | | |  |
| Finish 2 | 0.180 | | | 0.122 | | | 0.110 | | | 0.108 | | 0.108 | |  |  | |  | | |  | | |  |
|  | 0.193 | | | 0.136  0.116 | | | -  0.104 | | | -  - | | -  - | |  |  | |  | | |  | | |  |
|  | 0.198 | | | 0.140  0.120 | | | -  0.108 | | | -  0.106 | | -  - | |  |  | |  | | |  | | |  |
|  | 0.200 | | | 0.142  0.122 | | | -  0.110 | | | -  0.108 | | -  0.108 | |  |  | |  | | |  | | |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Removal rate  (mm/min) | 1.5  1.7 | | | 3.7  5.2 | | | 4.5  5.5 | | | 12.0 | | 8.0 | |  | 1.5  1.7 | | 3.7  5.2 | | | 12.0 | | |  |
| Servo lump  state | 4 6 | | | 5 7 | | | 1 3 | | | 3 6 | | 3 6 | |  | 4 6 | | 5 7 | | | 3 6 | | |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  |  | |  | | | Non  - | | |  |
| 12 | | | 12 | | | 12 | | | 12 | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3.3 3.8 | | 2.3 2.8 | |  | 20 | | 13 | | | 3.3 3.8 | | |  |
| 01: E No. | E1096 | | | E1097 | | | E1098 | | | E1099 | | E1100 | |  | E1096 | | E1097 | | | E1099 | | |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |  | 0.200 | | 0.200 | | | 0.200 | | |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 04:THICKNESS | 40.0 | | | 40.0 | | | 40.0 | | | 40.0 | | 40.0 | |  | 40.0 | | 40.0 | | | 40.0 | | |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | |  | 0 | | 1 | | | 3 | | |  |
| 06:ONA | 30 | | | 6 | | | 2 | | | 2 | | 2 | |  | 30 | | 6 | | | 2 | | |  |
| 07:ONB | 50 | | | 6 | | | 2 | | | 2 | | 2 | |  | 50 | | 6 | | | 2 | | |  |
| 08:ONC | 10 | | | 6 | | | 1 | | | 1 | | 1 | |  | 10 | | 6 | | | 1 | | |  |
| 09:OND | 12 | | | 6 | | | 1 | | | 1 | | 1 | |  | 12 | | 6 | | | 1 | | |  |
| 10:OFF | 95 | | | 70 | | | 80 | | | 10 | | 5 | |  | 95 | | 70 | | | 10 | | |  |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | |  | 10 | | 10 | | | 5 | | |  |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 14:DCHG-S | 12 | | | 10 | | | 10 | | | 23 | | 18 | |  | 12 | | 10 | | | 23 | | |  |
| 15:DCHG-R | 12 | | | 10 | | | 10 | | | 23 | | 18 | |  | 12 | | 10 | | | 23 | | |  |
| 16:SV | 10 | | | 8 | | | 8 | | | 18 | | 16 | |  | 10 | | 8 | | | 18 | | |  |
| 17:RV | 10 | | | 8 | | | 8 | | | 18 | | 16 | |  | 10 | | 8 | | | 18 | | |  |
| 18:IPM | 22 | | | 17 | | | 16 | | | 18 | | 8 | |  | 22 | | 17 | | | 18 | | |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 8 | |  | 7 | | 7 | | | 1 | | |  |
| 20:SV.MODE | 62H | | | 71H | | | 71H | | | 31H | | 31H | |  | 62H | | 71H | | | 31H | | |  |
| 21:SV. | 4AH | | | 02H | | | 02H | | | 0EH | | 0EH | |  | 4AH | | 02H | | | 0EH | | |  |
| 22:SV.ADJ | 105 | | | 70 | | | 42 | | | 0 | | 0 | |  | 105 | | 70 | | | 0 | | |  |
| 23:SPEED | 50.00 | | | 10.00 | | | 10.00 | | | 12.00 | | 8.00 | |  | 50.00 | | 10.00 | | | 12.00 | | |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 11H | | 11H | |  | 33H | | 33H | | | 11H | | |  |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | | 01H | | 01H | |  | 04H | | 01H | | | 01H | | |  |
| 26:PRG0-1 | 0000H | | | 0F3DH | | | 0F3DH | | | 0F3DH | | 0C3DH | |  | 0000H | | 0F3DH | | | 0F3DH | | |  |
| 27:PRG0-2 | 00H | | | 22H | | | 22H | | | 11H | | 11H | |  | 00H | | 22H | | | 11H | | |  |
| 28:PRG0-3 | 00H | | | 9AH | | | 9AH | | | AAH | | AAH | |  | 00H | | 9AH | | | AAH | | |  |
| 29:PRG0-4 | 00H | | | AAH | | | AAH | | | AAH | | AAH | |  | 00H | | AAH | | | AAH | | |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 31:PRG2-1 | 40 | | | 0 | | | 0 | | | 0 | | 0 | |  | 40 | | 0 | | | 0 | | |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  | 35 | | 0 | | | 0 | | |  |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 34:PRG3-2 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 35:PRG3-3 | 0 | | | 0 | | | 0 | | | 0 | | 0 | |  | 0 | | 0 | | | 0 | | |  |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | |  | 07H | | 01H | | | 01H | | |  |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |  | 0BH | | 0BH | | | 0BH | | |  |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 39:ADC1-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 40:ADC1-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | |  | 25H | | 00H | | | 00H | | |  |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 42:ADC2-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | |  | 25H | | 00H | | | 00H | | |  |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | |  | 6 | | 8 | | | 8 | | |  |
| 44:OVERRIDE U | 140 | | | 100 | | | 100 | | | 100 | | 100 | |  | 140 | | 100 | | | 100 | | |  |
| 45:OVERRIDE L | 140 | | | 80 | | | 80 | | | 80 | | 80 | |  | 140 | | 80 | | | 80 | | |  |
| 46:WIRE FEED | 16 | | | 15 | | | 15 | | | 15 | | 15 | |  | 16 | | 15 | | | 15 | | |  |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | |  | 6 | | 7 | | | 7 | | |  |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | |  | 15 | | 15 | | | 15 | | |  |
| 49:EST.SPEED | 1.6 | | | 4.5 | | | 5.2 | | | 12.0 | | 8.0 | |  | 1.6 | | 4.5 | | | 12.0 | | |  |

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| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 50 | | | | | | | | | | | | | | 50 | | | | | | | | |
| MODEL No. |  | | | | | | | | | | | | | |  | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |  | 1st | | 2nd | | | 3rd | | |  |
| E No. | E1106 | | | E1107 | | | E1108 | | | E1109 | | E1110 | |  | E1106 | | E1107 | | | E1109 | | |  |
| H Value | V-corner | | |  | | |  | | |  | |  | |  |  | |  | | |  | | |  |
| Offset Roughing | 0.140 | | | - | | | - | | | - | | - | |  |  | |  | | |  | | |  |
|  | 0.162 | | | 0.105 | | | - | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 7 | 0.173 | | | 0.116 | | | 0.104 | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 3 | 0.178 | | | 0.122 | | | 0.110 | | | 0.108 | | - | |  | 0.171 | | 0.114 | | | 0.107 | | |  |
| Finish 2 | 0.180 | | | 0.124 | | | 0.112 | | | 0.110 | | 0.108 | |  |  | |  | | |  | | |  |
|  | 0.193 | | | 0.136  0.116 | | | -  0.104 | | | -  - | | -  - | |  |  | |  | | |  | | |  |
|  | 0.198 | | | 0.142  0.122 | | | -  0.110 | | | -  0.108 | | -  - | |  |  | |  | | |  | | |  |
|  | 0.200 | | | 0.144  0.124 | | | -  0.112 | | | -  0.110 | | -  0.108 | |  |  | |  | | |  | | |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Removal rate  (mm/min) | 1.1  1.3 | | | 3.0  5.3 | | | 4.0  5.5 | | | 8.0 | | 8.0 | |  | 1.1  1.3 | | 3.0  5.3 | | | 8.0 | | |  |
| Servo lump  state | 4 6 | | | 5 7 | | | 1 3 | | | 4 6 | | 2 4 | |  | 4 6 | | 5 7 | | | 4 6 | | |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  |  | |  | | | Non  - | | |  |
| 12 | | | 12 | | | 12 | | | 12 | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3.3 3.8 | | 2.3 2.8 | |  | 20 | | 13 | | | 3.3 3.8 | | |  |
| 01: E No. | E1106 | | | E1107 | | | E1108 | | | E1109 | | E1110 | |  | E1106 | | E1107 | | | E1109 | | |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |  | 0.200 | | 0.200 | | | 0.200 | | |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 04:THICKNESS | 50.0 | | | 50.0 | | | 50.0 | | | 50.0 | | 50.0 | |  | 50.0 | | 50.0 | | | 50.0 | | |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | |  | 0 | | 1 | | | 3 | | |  |
| 06:ONA | 30 | | | 6 | | | 2 | | | 2 | | 3 | |  | 30 | | 6 | | | 2 | | |  |
| 07:ONB | 50 | | | 6 | | | 2 | | | 2 | | 3 | |  | 50 | | 6 | | | 2 | | |  |
| 08:ONC | 10 | | | 6 | | | 1 | | | 1 | | 1 | |  | 10 | | 6 | | | 1 | | |  |
| 09:OND | 12 | | | 6 | | | 1 | | | 1 | | 1 | |  | 12 | | 6 | | | 1 | | |  |
| 10:OFF | 100 | | | 70 | | | 80 | | | 10 | | 5 | |  | 100 | | 70 | | | 10 | | |  |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | |  | 10 | | 10 | | | 5 | | |  |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 14:DCHG-S | 12 | | | 10 | | | 10 | | | 23 | | 23 | |  | 12 | | 10 | | | 23 | | |  |
| 15:DCHG-R | 12 | | | 10 | | | 10 | | | 23 | | 23 | |  | 12 | | 10 | | | 23 | | |  |
| 16:SV | 10 | | | 8 | | | 8 | | | 18 | | 18 | |  | 10 | | 8 | | | 18 | | |  |
| 17:RV | 10 | | | 8 | | | 8 | | | 18 | | 18 | |  | 10 | | 8 | | | 18 | | |  |
| 18:IPM | 22 | | | 17 | | | 16 | | | 18 | | 8 | |  | 22 | | 17 | | | 18 | | |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 8 | |  | 7 | | 7 | | | 1 | | |  |
| 20:SV.MODE | 62H | | | 71H | | | 71H | | | 31H | | 31H | |  | 62H | | 71H | | | 31H | | |  |
| 21:SV. | 4AH | | | 02H | | | 02H | | | 0EH | | 0EH | |  | 4AH | | 02H | | | 0EH | | |  |
| 22:SV.ADJ | 95 | | | 70 | | | 40 | | | 0 | | 0 | |  | 95 | | 70 | | | 0 | | |  |
| 23:SPEED | 50.00 | | | 10.00 | | | 10.00 | | | 8.00 | | 8.00 | |  | 50.00 | | 10.00 | | | 8.00 | | |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 11H | | 11H | |  | 33H | | 33H | | | 11H | | |  |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | | 01H | | 01H | |  | 04H | | 01H | | | 01H | | |  |
| 26:PRG0-1 | 0000H | | | 0F3DH | | | 0F3DH | | | 0F3DH | | 0C3DH | |  | 0000H | | 0F3DH | | | 0F3DH | | |  |
| 27:PRG0-2 | 00H | | | 22H | | | 22H | | | 11H | | 11H | |  | 00H | | 22H | | | 11H | | |  |
| 28:PRG0-3 | 00H | | | 9AH | | | 9AH | | | AAH | | AAH | |  | 00H | | 9AH | | | AAH | | |  |
| 29:PRG0-4 | 00H | | | AAH | | | AAH | | | AAH | | AAH | |  | 00H | | AAH | | | AAH | | |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 31:PRG2-1 | 40 | | | 0 | | | 0 | | | 0 | | 0 | |  | 40 | | 0 | | | 0 | | |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  | 35 | | 0 | | | 0 | | |  |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 34:PRG3-2 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 35:PRG3-3 | 0 | | | 0 | | | 0 | | | 0 | | 0 | |  | 0 | | 0 | | | 0 | | |  |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | |  | 07H | | 01H | | | 01H | | |  |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |  | 0BH | | 0BH | | | 0BH | | |  |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 39:ADC1-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 40:ADC1-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | |  | 25H | | 00H | | | 00H | | |  |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 42:ADC2-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | |  | 25H | | 00H | | | 00H | | |  |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | |  | 6 | | 8 | | | 8 | | |  |
| 44:OVERRIDE U | 140 | | | 100 | | | 100 | | | 100 | | 100 | |  | 140 | | 100 | | | 100 | | |  |
| 45:OVERRIDE L | 140 | | | 100 | | | 100 | | | 100 | | 100 | |  | 140 | | 100 | | | 100 | | |  |
| 46:WIRE FEED | 16 | | | 15 | | | 15 | | | 15 | | 15 | |  | 16 | | 15 | | | 15 | | |  |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | |  | 6 | | 7 | | | 7 | | |  |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | |  | 15 | | 15 | | | 15 | | |  |
| 49:EST.SPEED | 1.3 | | | 4.0 | | | 4.6 | | | 8.0 | | 8.0 | |  | 1.3 | | 4.0 | | | 8.0 | | |  |

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| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 60 | | | | | | | | | | | | | | 60 | | | | | | | | |
| MODEL No. |  | | | | | | | | | | | | | |  | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |  | 1st | | 2nd | | | 3rd | | |  |
| E No. | E1116 | | | E1117 | | | E1118 | | | E1119 | | E1120 | |  | E1116 | | E1117 | | | E1119 | | |  |
| H Value | V-corner | | |  | | |  | | |  | |  | |  |  | |  | | |  | | |  |
| Offset Roughing | 0.140 | | | - | | | - | | | - | | - | |  |  | |  | | |  | | |  |
|  | 0.164 | | | 0.105 | | | - | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 7 | 0.175 | | | 0.116 | | | 0.104 | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 3 | 0.180 | | | 0.122 | | | 0.110 | | | 0.108 | | - | |  | 0.173 | | 0.113 | | | 0.107 | | |  |
| Finish 2 | 0.182 | | | 0.124 | | | 0.112 | | | 0.110 | | 0.108 | |  |  | |  | | |  | | |  |
|  | 0.195 | | | 0.136  0.116 | | | -  0.104 | | | -  - | | -  - | |  |  | |  | | |  | | |  |
|  | 0.200 | | | 0.142  0.122 | | | -  0.110 | | | -  0.108 | | -  - | |  |  | |  | | |  | | |  |
|  | 0.205 | | | 0.144  0.124 | | | -  0.112 | | | -  0.110 | | -  0.108 | |  |  | |  | | |  | | |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Removal rate  (mm/min) | 0.85  0.9 | | | 2.3  3.5 | | | 3.0  3.6 | | | 8.0 | | 8.0 | |  | 0.85  0.9 | | 2.3  3.5 | | | 8.0 | | |  |
| Servo lump  state | 4 6 | | | 4 6 | | | 1 3 | | | 3 6 | | 2 4 | |  | 4 6 | | 4 6 | | | 3 6 | | |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  |  | |  | | | Non  - | | |  |
| 12 | | | 12 | | | 12 | | | 12 | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3.3 3.8 | | 2.3 2.8 | |  | 20 | | 13 | | | 3.3 3.8 | | |  |
| 01: E No. | E1116 | | | E1117 | | | E1118 | | | E1119 | | E1120 | |  | E1116 | | E1117 | | | E1119 | | |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |  | 0.200 | | 0.200 | | | 0.200 | | |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 04:THICKNESS | 60.0 | | | 60.0 | | | 60.0 | | | 60.0 | | 60.0 | |  | 60.0 | | 60.0 | | | 60.0 | | |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | |  | 0 | | 1 | | | 3 | | |  |
| 06:ONA | 30 | | | 6 | | | 2 | | | 3 | | 3 | |  | 30 | | 6 | | | 3 | | |  |
| 07:ONB | 50 | | | 6 | | | 2 | | | 3 | | 3 | |  | 50 | | 6 | | | 3 | | |  |
| 08:ONC | 10 | | | 6 | | | 1 | | | 1 | | 1 | |  | 10 | | 6 | | | 1 | | |  |
| 09:OND | 12 | | | 6 | | | 1 | | | 1 | | 1 | |  | 12 | | 6 | | | 1 | | |  |
| 10:OFF | 110 | | | 70 | | | 80 | | | 10 | | 5 | |  | 110 | | 70 | | | 10 | | |  |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | |  | 10 | | 10 | | | 5 | | |  |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 14:DCHG-S | 12 | | | 10 | | | 10 | | | 23 | | 23 | |  | 12 | | 10 | | | 23 | | |  |
| 15:DCHG-R | 12 | | | 10 | | | 10 | | | 23 | | 23 | |  | 12 | | 10 | | | 23 | | |  |
| 16:SV | 10 | | | 8 | | | 8 | | | 18 | | 18 | |  | 10 | | 8 | | | 18 | | |  |
| 17:RV | 10 | | | 8 | | | 8 | | | 18 | | 18 | |  | 10 | | 8 | | | 18 | | |  |
| 18:IPM | 22 | | | 18 | | | 16 | | | 18 | | 8 | |  | 22 | | 18 | | | 18 | | |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 8 | |  | 7 | | 7 | | | 1 | | |  |
| 20:SV.MODE | 62H | | | 71H | | | 71H | | | 31H | | 31H | |  | 62H | | 71H | | | 31H | | |  |
| 21:SV. | 4AH | | | 02H | | | 02H | | | 0EH | | 0EH | |  | 4AH | | 02H | | | 0EH | | |  |
| 22:SV.ADJ | 90 | | | 67 | | | 37 | | | 0 | | 0 | |  | 90 | | 67 | | | 0 | | |  |
| 23:SPEED | 50.00 | | | 8.00 | | | 8.00 | | | 8.00 | | 8.00 | |  | 50.00 | | 8.00 | | | 8.00 | | |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 11H | | 11H | |  | 33H | | 33H | | | 11H | | |  |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | | 01H | | 01H | |  | 04H | | 01H | | | 01H | | |  |
| 26:PRG0-1 | 0000H | | | 0F3DH | | | 0F3DH | | | 0F3DH | | F3DH | |  | 0000H | | 0F3DH | | | 0F3DH | | |  |
| 27:PRG0-2 | 00H | | | 22H | | | 22H | | | 11H | | 11H | |  | 00H | | 22H | | | 11H | | |  |
| 28:PRG0-3 | 00H | | | 9AH | | | 9AH | | | AAH | | AAH | |  | 00H | | 9AH | | | AAH | | |  |
| 29:PRG0-4 | 00H | | | AAH | | | AAH | | | AAH | | AAH | |  | 00H | | AAH | | | AAH | | |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 31:PRG2-1 | 40 | | | 0 | | | 0 | | | 0 | | 0 | |  | 40 | | 0 | | | 0 | | |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  | 35 | | 0 | | | 0 | | |  |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 34:PRG3-2 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 35:PRG3-3 | 0 | | | 0 | | | 0 | | | 0 | | 0 | |  | 0 | | 0 | | | 0 | | |  |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | |  | 07H | | 01H | | | 01H | | |  |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |  | 0BH | | 0BH | | | 0BH | | |  |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 39:ADC1-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 40:ADC1-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | |  | 25H | | 00H | | | 00H | | |  |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 42:ADC2-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | |  | 25H | | 00H | | | 00H | | |  |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | |  | 6 | | 8 | | | 8 | | |  |
| 44:OVERRIDE U | 140 | | | 100 | | | 100 | | | 100 | | 100 | |  | 140 | | 100 | | | 100 | | |  |
| 45:OVERRIDE L | 140 | | | 100 | | | 100 | | | 100 | | 100 | |  | 140 | | 100 | | | 100 | | |  |
| 46:WIRE FEED | 16 | | | 15 | | | 15 | | | 15 | | 15 | |  | 16 | | 15 | | | 15 | | |  |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | |  | 6 | | 7 | | | 7 | | |  |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | |  | 15 | | 15 | | | 15 | | |  |
| 49:EST.SPEED | 1.0 | | | 3.0 | | | 3.4 | | | 8.0 | | 8.0 | |  | 1.0 | | 3.0 | | | 8.0 | | |  |

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|  |  |  |  |
| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 80 Punch | | | | | | | | | | | | | | 80 Punch | | | | | | | | |
| MODEL No. |  | | | | | | | | | | | | | |  | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |  | 1st | | 2nd | | | 3rd | | |  |
| E No. | E1126 | | | E1127 | | | E1128 | | | E1129 | | E1130 | |  | E1126 | | E1127 | | | E1129 | | |  |
| H Value | V-corner | | |  | | |  | | |  | |  | |  |  | |  | | |  | | |  |
| Offset Roughing | 0.144 | | | - | | | - | | | - | | - | |  |  | |  | | |  | | |  |
|  | 0.165 | | | 0.111 | | | - | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 7 | 0.176 | | | 0.122 | | | 0.108 | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 3 | 0.184 | | | 0.130 | | | 0.116 | | | 0.108 | | - | |  | 0.174 | | 0.117 | | | 0.107 | | |  |
| Finish 2 | 0.186 | | | 0.132 | | | 0.118 | | | 0.110 | | 0.108 | |  |  | |  | | |  | | |  |
|  | 0.196 | | | 0.142  0.122 | | | -  0.108 | | | -  - | | -  - | |  |  | |  | | |  | | |  |
|  | 0.204 | | | 0.150  0.130 | | | -  0.116 | | | -  0.108 | | -  - | |  |  | |  | | |  | | |  |
|  | 0.206 | | | 0.152  0.132 | | | -  0.118 | | | -  0.110 | | -  0.108 | |  |  | |  | | |  | | |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Removal rate  (mm/min) | 0.58  0.64 | | | 2.3  4.5 | | | 3.0  4.0 | | | 8.0 | | 8.0 | |  | 0.58  0.64 | | 2.3  4.5 | | | 8.0 | | |  |
| Servo lump  state | 3 5 | | | 6 8 | | | 3 4 | | | 2 4 | | 2 4 | |  |  | |  | | |  | | |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  |  | |  | | | Non  - | | |  |
| 12 | | | 12 | | | 12 | | | 12 | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3.3 3.8 | | 2.3 2.8 | |  | 20 | | 13 | | | 3.3 3.8 | | |  |
| 01: E No. | E1126 | | | E1127 | | | E1128 | | | E1129 | | E1130 | |  | E1126 | | E1127 | | | E1129 | | |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |  | 0.200 | | 0.200 | | | 0.200 | | |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 04:THICKNESS | 80.0 | | | 80.0 | | | 80.0 | | | 80.0 | | 80.0 | |  | 80.0 | | 80.0 | | | 80.0 | | |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | |  | 0 | | 1 | | | 3 | | |  |
| 06:ONA | 30 | | | 8 | | | 3 | | | 3 | | 3 | |  | 30 | | 8 | | | 3 | | |  |
| 07:ONB | 40 | | | 8 | | | 3 | | | 3 | | 3 | |  | 40 | | 8 | | | 3 | | |  |
| 08:ONC | 15 | | | 8 | | | 3 | | | 1 | | 1 | |  | 15 | | 8 | | | 1 | | |  |
| 09:OND | 20 | | | 8 | | | 3 | | | 1 | | 1 | |  | 20 | | 8 | | | 1 | | |  |
| 10:OFF | 110 | | | 60 | | | 80 | | | 10 | | 5 | |  | 110 | | 60 | | | 10 | | |  |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | |  | 10 | | 10 | | | 5 | | |  |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 14:DCHG-S | 12 | | | 10 | | | 10 | | | 21 | | 21 | |  | 12 | | 10 | | | 21 | | |  |
| 15:DCHG-R | 12 | | | 10 | | | 10 | | | 21 | | 15 | |  | 12 | | 10 | | | 21 | | |  |
| 16:SV | 10 | | | 8 | | | 8 | | | 18 | | 12 | |  | 10 | | 8 | | | 18 | | |  |
| 17:RV | 10 | | | 8 | | | 8 | | | 18 | | 12 | |  | 10 | | 8 | | | 18 | | |  |
| 18:IPM | 20 | | | 20 | | | 15 | | | 12 | | 12 | |  | 20 | | 20 | | | 12 | | |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 6 | |  | 7 | | 7 | | | 1 | | |  |
| 20:SV.MODE | 60H | | | 71H | | | 71H | | | 31H | | 31H | |  | 60H | | 71H | | | 31H | | |  |
| 21:SV. | 04H | | | 02H | | | 02H | | | 0EH | | 0EH | |  | 04H | | 02H | | | 0EH | | |  |
| 22:SV.ADJ | 90 | | | 85 | | | 44 | | | 0 | | 0 | |  | 90 | | 85 | | | 0 | | |  |
| 23:SPEED | 1.00 | | | 10.00 | | | 8.00 | | | 8.00 | | 8.00 | |  | 1.00 | | 10.00 | | | 8.00 | | |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 11H | | 10H | |  | 33H | | 33H | | | 11H | | |  |
| 25:PRG-ON | 04H | | | 09H | | | 09H | | | 09H | | 09H | |  | 04H | | 09H | | | 09H | | |  |
| 26:PRG0-1 | 0000H | | | 0C3DH | | | 0C3DH | | | 0F3DH | | 0F3DH | |  | 0000H | | 0C3DH | | | 0F3DH | | |  |
| 27:PRG0-2 | 00H | | | 55H | | | 55H | | | 55H | | 33H | |  | 00H | | 55H | | | 55H | | |  |
| 28:PRG0-3 | 00H | | | 9AH | | | 9AH | | | AAH | | AAH | |  | 00H | | 9AH | | | AAH | | |  |
| 29:PRG0-4 | 00H | | | BBH | | | AAH | | | AAH | | AAH | |  | 00H | | BBH | | | AAH | | |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 31:PRG2-1 | 60 | | | 0 | | | 0 | | | 0 | | 0 | |  | 60 | | 0 | | | 0 | | |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  | 35 | | 0 | | | 0 | | |  |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 34:PRG3-2 | 00H | | | 40H | | | 40H | | | 40H | | 40H | |  | 00H | | 40H | | | 40H | | |  |
| 35:PRG3-3 | 0 | | | 2 | | | 2 | | | 0 | | 0 | |  | 0 | | 2 | | | 0 | | |  |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | |  | 07H | | 01H | | | 01H | | |  |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |  | 0BH | | 0BH | | | 0BH | | |  |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 39:ADC1-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 40:ADC1-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | |  | 25H | | 00H | | | 00H | | |  |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 42:ADC2-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | |  | 25H | | 00H | | | 00H | | |  |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | |  | 6 | | 8 | | | 8 | | |  |
| 44:OVERRIDE U | 140 | | | 100 | | | 100 | | | 100 | | 100 | |  | 140 | | 100 | | | 100 | | |  |
| 45:OVERRIDE L | 140 | | | 100 | | | 100 | | | 100 | | 100 | |  | 140 | | 100 | | | 100 | | |  |
| 46:WIRE FEED | 16 | | | 16 | | | 16 | | | 16 | | 16 | |  | 16 | | 16 | | | 16 | | |  |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | |  | 6 | | 7 | | | 7 | | |  |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | |  | 15 | | 15 | | | 15 | | |  |
| 49:EST.SPEED | 0.6 | | | 3.0 | | | 3.5 | | | 8.0 | | 8.0 | |  | 0.6 | | 3.0 | | | 8.0 | | |  |

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|  |  |  |  |
| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2(D) |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 80 Die | | | | | | | | | | | | | | 80 Die | | | | | | | | |
| MODEL No. |  | | | | | | | | | | | | | |  | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |  | 1st | | 2nd | | | 3rd | | |  |
| E No. | E1126 | | | E2122 | | | E2123 | | | E2124 | | E2125 | |  | E1126 | | E2122 | | | E2124 | | |  |
| H Value | V-corner | | |  | | |  | | |  | |  | |  |  | |  | | |  | | |  |
| Offset Roughing | 0.144 | | | - | | | - | | | - | | - | |  |  | |  | | |  | | |  |
|  | 0.168 | | | 0.108 | | | - | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 7(D) | 0.176 | | | 0.116 | | | 0.106 | | | - | | - | |  |  | |  | | |  | | |  |
| Finish 3(D) | 0.181 | | | 0.121 | | | 0.111 | | | 0.106 | | - | |  | 0.176 | | 0.116 | | | 0.108 | | |  |
| Finish 2(D) | 0.183 | | | 0.123 | | | 0.113 | | | 0.108 | | 0.108 | |  |  | |  | | |  | | |  |
|  | 0.196 | | | 0.136  0.116 | | | -  0.106 | | | -  - | | -  - | |  |  | |  | | |  | | |  |
|  | 0.201 | | | 0.141  0.121 | | | -  0.111 | | | -  0.106 | | -  - | |  |  | |  | | |  | | |  |
|  | 0.203 | | | 0.143  0.123 | | | -  0.113 | | | -  0.108 | | -  0.108 | |  |  | |  | | |  | | |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | |  | - | | - | | | - | | |  |
| Removal rate  (mm/min) | 0.58  0.64 | | | 2.3  4.5 | | | 3.0  4.0 | | | 8.0 | | 8.0 | |  | 0.58  0.64 | | 2.3  4.5 | | | 8.0 | | |  |
| Servo lump  state | 3 5 | | | 6 8 | | | 3 4 | | | 2 4 | | 2 4 | |  |  | |  | | |  | | |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  |  | |  | | | Non  - | | |  |
| 12 | | | 12 | | | 12 | | | 12 | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3.3 3.8 | | 2.3 2.8 | |  | 20 | | 13 | | | 3.3 3.8 | | |  |
| 01: E No. | E1126 | | | E2122 | | | E2123 | | | E2124 | | E2125 | |  | E1126 | | E2122 | | | E2124 | | |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |  | 0.200 | | 0.200 | | | 0.200 | | |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 04:THICKNESS | 80.0 | | | 80.0 | | | 80.0 | | | 80.0 | | 80.0 | |  | 80.0 | | 80.0 | | | 80.0 | | |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | |  | 0 | | 1 | | | 3 | | |  |
| 06:ONA | 30 | | | 8 | | | 3 | | | 3 | | 3 | |  | 30 | | 8 | | | 3 | | |  |
| 07:ONB | 40 | | | 8 | | | 3 | | | 3 | | 3 | |  | 40 | | 8 | | | 3 | | |  |
| 08:ONC | 15 | | | 8 | | | 3 | | | 1 | | 1 | |  | 15 | | 8 | | | 1 | | |  |
| 09:OND | 20 | | | 8 | | | 3 | | | 1 | | 1 | |  | 20 | | 8 | | | 1 | | |  |
| 10:OFF | 110 | | | 60 | | | 80 | | | 10 | | 5 | |  | 110 | | 60 | | | 10 | | |  |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | |  | 10 | | 10 | | | 5 | | |  |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  | 250 | | 150 | | | 150 | | |  |
| 14:DCHG-S | 12 | | | 10 | | | 10 | | | 21 | | 21 | |  | 12 | | 10 | | | 21 | | |  |
| 15:DCHG-R | 12 | | | 10 | | | 10 | | | 21 | | 15 | |  | 12 | | 10 | | | 21 | | |  |
| 16:SV | 10 | | | 8 | | | 8 | | | 18 | | 12 | |  | 10 | | 8 | | | 18 | | |  |
| 17:RV | 10 | | | 8 | | | 8 | | | 18 | | 12 | |  | 10 | | 8 | | | 18 | | |  |
| 18:IPM | 20 | | | 20 | | | 15 | | | 12 | | 12 | |  | 20 | | 20 | | | 12 | | |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 6 | |  | 7 | | 7 | | | 1 | | |  |
| 20:SV.MODE | 60H | | | 71H | | | 71H | | | 31H | | 31H | |  | 60H | | 71H | | | 31H | | |  |
| 21:SV. | 04H | | | 02H | | | 02H | | | 0EH | | 0EH | |  | 04H | | 02H | | | 0EH | | |  |
| 22:SV.ADJ | 90 | | | 85 | | | 44 | | | 0 | | 0 | |  | 90 | | 85 | | | 0 | | |  |
| 23:SPEED | 1.00 | | | 10.00 | | | 8.00 | | | 8.00 | | 8.00 | |  | 1.00 | | 10.00 | | | 8.00 | | |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 11H | | 10H | |  | 33H | | 33H | | | 11H | | |  |
| 25:PRG-ON | 04H | | | 09H | | | 09H | | | 09H | | 09H | |  | 04H | | 09H | | | 09H | | |  |
| 26:PRG0-1 | 0000H | | | 0C3DH | | | 0C3DH | | | 0F3DH | | 0F3DH | |  | 0000H | | 0C3DH | | | 0F3DH | | |  |
| 27:PRG0-2 | 00H | | | 55H | | | 55H | | | 55H | | 33H | |  | 00H | | 55H | | | 55H | | |  |
| 28:PRG0-3 | 00H | | | 9AH | | | 9AH | | | AAH | | AAH | |  | 00H | | 9AH | | | AAH | | |  |
| 29:PRG0-4 | 00H | | | BBH | | | AAH | | | AAH | | AAH | |  | 00H | | BBH | | | AAH | | |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 31:PRG2-1 | 60 | | | 0 | | | 0 | | | 0 | | 0 | |  | 60 | | 0 | | | 0 | | |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  | 35 | | 0 | | | 0 | | |  |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  | 00H | | 00H | | | 00H | | |  |
| 34:PRG3-2 | 00H | | | 40H | | | 40H | | | 40H | | 40H | |  | 00H | | 40H | | | 40H | | |  |
| 35:PRG3-3 | 0 | | | 2 | | | 2 | | | 0 | | 0 | |  | 0 | | 2 | | | 0 | | |  |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | |  | 07H | | 01H | | | 01H | | |  |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |  | 0BH | | 0BH | | | 0BH | | |  |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  | 1 | | 1 | | | 1 | | |  |
| 39:ADC1-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 40:ADC1-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | |  | 25H | | 00H | | | 00H | | |  |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  | 67H | | 00H | | | 00H | | |  |
| 42:ADC2-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | |  | 25H | | 00H | | | 00H | | |  |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | |  | 6 | | 8 | | | 8 | | |  |
| 44:OVERRIDE U | 140 | | | 100 | | | 100 | | | 100 | | 100 | |  | 140 | | 100 | | | 100 | | |  |
| 45:OVERRIDE L | 140 | | | 100 | | | 100 | | | 100 | | 100 | |  | 140 | | 100 | | | 100 | | |  |
| 46:WIRE FEED | 16 | | | 16 | | | 16 | | | 16 | | 16 | |  | 16 | | 16 | | | 16 | | |  |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | |  | 6 | | 7 | | | 7 | | |  |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | |  | 15 | | 15 | | | 15 | | |  |
| 49:EST.SPEED | 0.6 | | | 3.0 | | | 3.5 | | | 8.0 | | 8.0 | |  | 0.6 | | 3.0 | | | 8.0 | | |  |

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|  |  |  |  |
| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 100 Punch | | | | | | | | | | | | | 125 Punch | | | | | | | | | | | | |
| MODEL No. |  | | | | | | | | | | | | |  | | | | | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |
| E No. | E1136 | | | E1137 | | | E1138 | | | E1139 | | E1140 | | E1146 | | | E1147 | | | E1148 | | | E1149 | | E1150 | |
| H Value | V-corner | | |  | | |  | | |  | |  | | V-corner | | |  | | |  | | |  | |  | |
| Offset Roughing | 0.145 | | | - | | | - | | | - | | - | | 0.145 | | | - | | | - | | | - | | - | |
|  | 0.170 | | | 0.108 | | | - | | | - | | - | | 0.170 | | | 0.108 | | | - | | | - | | - | |
| Finish 7 | 0.179 | | | 0.117 | | | 0.107 | | | - | | - | | 0.179 | | | 0.117 | | | 0.107 | | | - | | - | |
| Finish 3 | 0.183 | | | 0.121 | | | 0.111 | | | 0.106 | | - | | 0.183 | | | 0.121 | | | 0.111 | | | 0.106 | | - | |
| Finish 2 | 0.185 | | | 0.123 | | | 0.113 | | | 0.108 | | 0.108 | | 0.185 | | | 0.123 | | | 0.113 | | | 0.108 | | 0.108 | |
|  | 0.199 | | | 0.137  0.117 | | | -  0.107 | | | -  - | | -  - | | 0.199 | | | 0.137  0.117 | | | -  0.107 | | | -  - | | -  - | |
|  | 0.203 | | | 0.141  0.121 | | | -  0.111 | | | -  0.106 | | -  - | | 0.203 | | | 0.141  0.121 | | | -  0.111 | | | -  0.106 | | -  - | |
|  | 0.205 | | | 0.143  0.123 | | | -  0.113 | | | -  0.108 | | -  0.108 | | 0.205 | | | 0.143  0.123 | | | -  0.113 | | | -  0.108 | | -  0.108 | |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | | - | | | - | | | - | | | - | | - | |
| Low(Mpa | - | | | - | | | - | | | - | | - | | - | | | - | | | - | | | - | | - | |
| Removal rate  (mm/min) | 0.38  0.5 | | | 2.0  3.0 | | | 1.8  2.8 | | | 8.0 | | 8.0 | | 0.25  0.35 | | | 1.8  3.0 | | | 1.6  2.8 | | | 8.0 | | 8.0 | |
| Servo lump  state | 3 5 | | | 6 8 | | | 3 4 | | | 2 4 | | 3 5 | | 3 5 | | | 6 8 | | | 3 4 | | | 2 4 | | 2 4 | |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  | | |  | | |  | | | Non  - | | Non  - | |
| 12 | | | 12 | | | 12 | | | 12 | | | 12 | | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3.3 3.8 | | 2.3 2.8 | | 20 | | | 13 | | | 7.5 | | | 3.3 3.8 | | 2.3 2.8 | |
| 01: E No. | E1136 | | | E1137 | | | E1138 | | | E1139 | | E1140 | | E1146 | | | E1147 | | | E1148 | | | E1149 | | E1150 | |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | | 1 | | | 1 | | | 1 | | | 1 | | 1 | |
| 04:THICKNESS | 100.0 | | | 100.0 | | | 100.0 | | | 100.0 | | 100.0 | | 125.0 | | | 125.0 | | | 125.0 | | | 125.0 | | 125.0 | |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | | 0 | | | 1 | | | 1 | | | 3 | | 3 | |
| 06:ONA | 30 | | | 8 | | | 3 | | | 3 | | 3 | | 30 | | | 8 | | | 3 | | | 3 | | 3 | |
| 07:ONB | 40 | | | 8 | | | 3 | | | 3 | | 3 | | 40 | | | 8 | | | 3 | | | 3 | | 3 | |
| 08:ONC | 15 | | | 8 | | | 3 | | | 1 | | 1 | | 15 | | | 8 | | | 3 | | | 1 | | 1 | |
| 09:OND | 20 | | | 8 | | | 3 | | | 1 | | 1 | | 20 | | | 8 | | | 3 | | | 1 | | 1 | |
| 10:OFF | 110 | | | 60 | | | 80 | | | 10 | | 5 | | 110 | | | 60 | | | 80 | | | 10 | | 5 | |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | | 10 | | | 10 | | | 10 | | | 5 | | 5 | |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | | 250 | | | 150 | | | 150 | | | 150 | | 150 | |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | | 250 | | | 150 | | | 150 | | | 150 | | 150 | |
| 14:DCHG-S | 12 | | | 10 | | | 10 | | | 21 | | 21 | | 12 | | | 10 | | | 10 | | | 21 | | 21 | |
| 15:DCHG-R | 12 | | | 10 | | | 10 | | | 21 | | 15 | | 12 | | | 10 | | | 10 | | | 21 | | 15 | |
| 16:SV | 10 | | | 8 | | | 8 | | | 18 | | 12 | | 10 | | | 8 | | | 8 | | | 18 | | 12 | |
| 17:RV | 10 | | | 8 | | | 8 | | | 18 | | 12 | | 10 | | | 8 | | | 8 | | | 18 | | 12 | |
| 18:IPM | 19 | | | 20 | | | 15 | | | 12 | | 12 | | 19 | | | 20 | | | 15 | | | 12 | | 12 | |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 6 | | 7 | | | 7 | | | 7 | | | 1 | | 6 | |
| 20:SV.MODE | 60H | | | 71H | | | 71H | | | 31H | | 31H | | 60H | | | 71H | | | 71H | | | 31H | | 31H | |
| 21:SV. | 04H | | | 02H | | | 02H | | | 0EH | | 0EH | | 04H | | | 02H | | | 02H | | | 0EH | | 0EH | |
| 22:SV.ADJ | 90 | | | 75 | | | 35 | | | 0 | | 0 | | 100 | | | 70 | | | 34 | | | 0 | | 0 | |
| 23:SPEED | 0.80 | | | 10.00 | | | 8.00 | | | 8.00 | | 8.00 | | 0.80 | | | 10.00 | | | 8.00 | | | 8.00 | | 8.00 | |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 11H | | 10H | | 33H | | | 33H | | | 33H | | | 11H | | 10H | |
| 25:PRG-ON | 04H | | | 09H | | | 09H | | | 09H | | 09H | | 04H | | | 09H | | | 09H | | | 09H | | 09H | |
| 26:PRG0-1 | 0000H | | | 0C3DH | | | 0C3DH | | | 0F3DH | | 0F3DH | | 0000H | | | 0C3DH | | | 0C3DH | | | 0F3DH | | 0F3DH | |
| 27:PRG0-2 | 00H | | | 55H | | | 55H | | | 55H | | 33H | | 00H | | | 55H | | | 55H | | | 55H | | 33H | |
| 28:PRG0-3 | 00H | | | 9AH | | | AAH | | | AAH | | AAH | | 00H | | | 9AH | | | AAH | | | AAH | | AAH | |
| 29:PRG0-4 | 00H | | | BBH | | | AAH | | | AAH | | AAH | | 00H | | | BBH | | | AAH | | | AAH | | AAH | |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | 00H | |
| 31:PRG2-1 | 60 | | | 0 | | | 0 | | | 0 | | 0 | | 60 | | | 0 | | | 0 | | | 0 | | 0 | |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | | 35 | | | 0 | | | 0 | | | 0 | | 0 | |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | 00H | |
| 34:PRG3-2 | 00H | | | 40H | | | 40H | | | 40H | | 40H | | 00H | | | 40H | | | 40H | | | 40H | | 40H | |
| 35:PRG3-3 | 0 | | | 2 | | | 2 | | | 0 | | 0 | | 0 | | | 2 | | | 2 | | | 0 | | 0 | |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | | 07H | | | 01H | | | 01H | | | 01H | | 01H | |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | | 1 | | | 1 | | | 1 | | | 1 | | 1 | |
| 39:ADC1-1 | 37H | | | 00H | | | 00H | | | 00H | | 00H | | 27H | | | 00H | | | 00H | | | 00H | | 00H | |
| 40:ADC1-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | | 25H | | | 00H | | | 00H | | | 00H | | 00H | |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | | 67H | | | 00H | | | 00H | | | 00H | | 00H | |
| 42:ADC2-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | | 25H | | | 00H | | | 00H | | | 00H | | 00H | |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | | 6 | | | 8 | | | 8 | | | 8 | | 8 | |
| 44:OVERRIDE U | 140 | | | 100 | | | 100 | | | 100 | | 100 | | 160 | | | 100 | | | 100 | | | 100 | | 100 | |
| 45:OVERRIDE L | 140 | | | 100 | | | 100 | | | 100 | | 100 | | 160 | | | 100 | | | 100 | | | 100 | | 100 | |
| 46:WIRE FEED | 16 | | | 16 | | | 16 | | | 16 | | 16 | | 16 | | | 16 | | | 16 | | | 16 | | 16 | |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | | 6 | | | 7 | | | 7 | | | 7 | | 7 | |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | | 15 | | | 15 | | | 15 | | | 15 | | 15 | |
| 49:EST.SPEED | 0.45 | | | 2.5 | | | 2.2 | | | 8.0 | | 8.0 | | 0.32 | | | 2.5 | | | 2.2 | | | 8.0 | | 8.0 | |

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|  |  |  |  |
| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2(D) |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 100 Die | | | | | | | | | | | | | 125 Die | | | | | | | | | | | | |
| MODEL No. |  | | | | | | | | | | | | |  | | | | | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |
| E No. | E1136 | | | E2132 | | | E2133 | | | E2134 | | E2135 | | E1146 | | | E2142 | | | E2143 | | | E2144 | | E2145 | |
| H Value |  | | |  | | |  | | |  | |  | |  | | |  | | |  | | |  | |  | |
| Offset Roughing | 0.145 | | | - | | | - | | | - | | - | | 0.145 | | | - | | | - | | | - | | - | |
|  | 0.166 | | | 0.106 | | | - | | | - | | - | | 0.166 | | | 0.106 | | | - | | | - | | - | |
| Finish 7(D) | 0.179 | | | 0.119 | | | 0.106 | | | - | | - | | 0.179 | | | 0.119 | | | 0.106 | | | - | | - | |
| Finish 3(D) | 0.184 | | | 0.124 | | | 0.111 | | | 0.106 | | - | | 0.184 | | | 0.124 | | | 0.111 | | | 0.106 | | - | |
| Finish 2(D) | 0.186 | | | 0.126 | | | 0.113 | | | 0.108 | | 0.108 | | 0.186 | | | 0.126 | | | 0.113 | | | 0.108 | | 0.108 | |
|  | 0.199 | | | 0.139  0.119 | | | -  0.106 | | | -  - | | -  - | | 0.199 | | | 0.139  0.119 | | | -  0.106 | | | -  - | | -  - | |
|  | 0.204 | | | 0.144  0.124 | | | -  0.111 | | | -  0.106 | | -  - | | 0.204 | | | 0.144  0.124 | | | -  0.111 | | | -  0.106 | | -  - | |
|  | 0.206 | | | 0.146  0.126 | | | -  0.113 | | | -  0.108 | | -  0.108 | | 0.206 | | | 0.146  0.126 | | | -  0.113 | | | -  0.108 | | -  0.108 | |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | | - | | | - | | | - | | | - | | - | |
| Low(Mpa | - | | | - | | | - | | | - | | - | | - | | | - | | | - | | | - | | - | |
| Removal rate  (mm/min) | 0.38  0.5 | | | 2.0  3.0 | | | 1.8  2.8 | | | 8.0 | | 8.0 | | 0.25  0.35 | | | 1.8  3.0 | | | 1.6  2.8 | | | 8.0 | | 8.0 | |
| Servo lump  state | 3 5 | | | 6 8 | | | 3 4 | | | 2 4 | | 3 5 | | 3 5 | | | 6 8 | | | 3 4 | | | 2 4 | | 2 4 | |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  | | |  | | |  | | | Non  - | | Non  - | |
| 12 | | | 12 | | | 12 | | | 12 | | | 12 | | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3.3 3.8 | | 2.3 2.8 | | 20 | | | 13 | | | 7.5 | | | 3.3 3.8 | | 2.3 2.8 | |
| 01: E No. | E1136 | | | E2132 | | | E2133 | | | E2134 | | E2135 | | E1146 | | | E2142 | | | E2143 | | | E2144 | | E2145 | |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | | 1 | | | 1 | | | 1 | | | 1 | | 1 | |
| 04:THICKNESS | 100.0 | | | 100.0 | | | 100.0 | | | 100.0 | | 100.0 | | 125.0 | | | 125.0 | | | 125.0 | | | 125.0 | | 125.0 | |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | | 0 | | | 1 | | | 1 | | | 3 | | 3 | |
| 06:ONA | 30 | | | 8 | | | 3 | | | 3 | | 3 | | 30 | | | 8 | | | 3 | | | 3 | | 3 | |
| 07:ONB | 40 | | | 8 | | | 3 | | | 3 | | 3 | | 40 | | | 8 | | | 3 | | | 3 | | 3 | |
| 08:ONC | 15 | | | 8 | | | 3 | | | 1 | | 1 | | 15 | | | 8 | | | 3 | | | 1 | | 1 | |
| 09:OND | 20 | | | 8 | | | 3 | | | 1 | | 1 | | 20 | | | 8 | | | 3 | | | 1 | | 1 | |
| 10:OFF | 110 | | | 60 | | | 80 | | | 10 | | 5 | | 110 | | | 60 | | | 80 | | | 10 | | 5 | |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | | 10 | | | 10 | | | 10 | | | 5 | | 5 | |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | | 250 | | | 150 | | | 150 | | | 150 | | 150 | |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | | 250 | | | 150 | | | 150 | | | 150 | | 150 | |
| 14:DCHG-S | 12 | | | 10 | | | 10 | | | 21 | | 21 | | 12 | | | 10 | | | 10 | | | 21 | | 21 | |
| 15:DCHG-R | 12 | | | 10 | | | 10 | | | 21 | | 15 | | 12 | | | 10 | | | 10 | | | 21 | | 15 | |
| 16:SV | 10 | | | 8 | | | 8 | | | 18 | | 12 | | 10 | | | 8 | | | 8 | | | 18 | | 12 | |
| 17:RV | 10 | | | 8 | | | 8 | | | 18 | | 12 | | 10 | | | 8 | | | 8 | | | 18 | | 12 | |
| 18:IPM | 19 | | | 20 | | | 15 | | | 12 | | 12 | | 19 | | | 20 | | | 15 | | | 12 | | 12 | |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 6 | | 7 | | | 7 | | | 7 | | | 1 | | 6 | |
| 20:SV.MODE | 60H | | | 71H | | | 71H | | | 31H | | 31H | | 60H | | | 71H | | | 71H | | | 31H | | 31H | |
| 21:SV. | 04H | | | 02H | | | 02H | | | 0EH | | 0EH | | 04H | | | 02H | | | 02H | | | 0EH | | 0EH | |
| 22:SV.ADJ | 90 | | | 80 | | | 44 | | | 0 | | 0 | | 100 | | | 76 | | | 40 | | | 0 | | 0 | |
| 23:SPEED | 0.80 | | | 10.00 | | | 8.00 | | | 8.00 | | 8.00 | | 0.80 | | | 10.00 | | | 8.00 | | | 8.00 | | 8.00 | |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 11H | | 10H | | 33H | | | 33H | | | 33H | | | 11H | | 10H | |
| 25:PRG-ON | 04H | | | 09H | | | 09H | | | 09H | | 09H | | 04H | | | 09H | | | 09H | | | 09H | | 09H | |
| 26:PRG0-1 | 0000H | | | 0C3DH | | | 0C3DH | | | 0F3DH | | 0F3DH | | 0000H | | | 0C3DH | | | 0C3DH | | | 0F3DH | | 0F3DH | |
| 27:PRG0-2 | 00H | | | 55H | | | 55H | | | 55H | | 33H | | 00H | | | 55H | | | 55H | | | 55H | | 33H | |
| 28:PRG0-3 | 00H | | | 9AH | | | AAH | | | AAH | | AAH | | 00H | | | 9AH | | | AAH | | | AAH | | AAH | |
| 29:PRG0-4 | 00H | | | BBH | | | AAH | | | AAH | | AAH | | 00H | | | BBH | | | AAH | | | AAH | | AAH | |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | 00H | |
| 31:PRG2-1 | 60 | | | 0 | | | 0 | | | 0 | | 0 | | 60 | | | 0 | | | 0 | | | 0 | | 0 | |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | | 35 | | | 0 | | | 0 | | | 0 | | 0 | |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | 00H | |
| 34:PRG3-2 | 00H | | | 40H | | | 40H | | | 40H | | 40H | | 00H | | | 40H | | | 40H | | | 40H | | 40H | |
| 35:PRG3-3 | 0 | | | 2 | | | 2 | | | 0 | | 0 | | 0 | | | 2 | | | 2 | | | 0 | | 0 | |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | | 07H | | | 01H | | | 01H | | | 01H | | 01H | |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | | 1 | | | 1 | | | 1 | | | 1 | | 1 | |
| 39:ADC1-1 | 37H | | | 00H | | | 00H | | | 00H | | 00H | | 27H | | | 00H | | | 00H | | | 00H | | 00H | |
| 40:ADC1-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | | 25H | | | 00H | | | 00H | | | 00H | | 00H | |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | | 67H | | | 00H | | | 00H | | | 00H | | 00H | |
| 42:ADC2-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | | 25H | | | 00H | | | 00H | | | 00H | | 00H | |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | | 6 | | | 8 | | | 8 | | | 8 | | 8 | |
| 44:OVERRIDE U | 140 | | | 100 | | | 100 | | | 100 | | 100 | | 160 | | | 100 | | | 100 | | | 100 | | 100 | |
| 45:OVERRIDE L | 140 | | | 100 | | | 100 | | | 100 | | 100 | | 160 | | | 100 | | | 100 | | | 100 | | 100 | |
| 46:WIRE FEED | 16 | | | 16 | | | 16 | | | 16 | | 16 | | 16 | | | 16 | | | 16 | | | 16 | | 16 | |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | | 6 | | | 7 | | | 7 | | | 7 | | 7 | |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | | 15 | | | 15 | | | 15 | | | 15 | | 15 | |
| 49:EST.SPEED | 0.45 | | | 2.5 | | | 2.2 | | | 8.0 | | 8.0 | | 0.32 | | | 2.0 | | | 2.0 | | | 8.0 | | 8.0 | |

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|  |  |  |  |
| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 150 Punch | | | | | | | | | | | | |  | | | | |
| MODEL No. |  | | | | | | | | | | | | |  | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |  | | |  |  |
| E No. | E1156 | | | E1157 | | | E1158 | | | E1159 | | E1160 | |  |  |  |  |  |
| H Value | V-corner | | |  | | |  | | |  | |  | |  |  |  |  |  |
| Offset Roughing | 0.150 | | | - | | | - | | | - | | - | |  |  |  |  |  |
|  | 0.168 | | | 0.108 | | | - | | | - | | - | |  |  |  |  |  |
| Finish 7 | 0.179 | | | 0.119 | | | 0.106 | | | - | | - | |  |  |  |  |  |
| Finish 3 | 0.184 | | | 0.124 | | | 0.111 | | | 0.108 | | - | |  |  |  |  |  |
| Finish 2 | 0.186 | | | 0.126 | | | 0.113 | | | 0.110 | | 0.108 | |  |  |  |  |  |
|  | 0.199 | | | 0.139  0.119 | | | -  0.106 | | | -  - | | -  - | |  |  |  |  |  |
|  | 0.204 | | | 0.144  0.124 | | | -  0.111 | | | -  0.108 | | -  - | |  |  |  |  |  |
|  | 0.206 | | | 0.146  0.126 | | | -  0.113 | | | -  0.110 | | -  0.108 | |  |  |  |  |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | |  |  |  |  |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | |  |  |  |  |  |
| Removal rate  (mm/min) | 0.18  0.25 | | | 1.5 | | | 1.3 | | | 8.0 | | 8.0 | |  |  |  |  |  |
| Servo lump  state | 4 6 | | | 5 7 | | | 3 4 | | | 2 4 | | 2 4 | |  |  |  |  |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  |  |  |  |  |
| 12 | | | 12 | | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3.3 3.8 | | 2.3 2.8 | |  |  |  |  |  |
| 01: E No. | E1156 | | | E1157 | | | E1158 | | | E1159 | | E1160 | |  |  |  |  |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |  |  |  |  |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  |  |  |  |  |
| 04:THICKNESS | 150.0 | | | 150.0 | | | 150.0 | | | 150.0 | | 150.0 | |  |  |  |  |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | |  |  |  |  |  |
| 06:ONA | 30 | | | 8 | | | 3 | | | 4 | | 3 | |  |  |  |  |  |
| 07:ONB | 40 | | | 8 | | | 3 | | | 4 | | 3 | |  |  |  |  |  |
| 08:ONC | 15 | | | 8 | | | 3 | | | 1 | | 1 | |  |  |  |  |  |
| 09:OND | 20 | | | 8 | | | 3 | | | 1 | | 1 | |  |  |  |  |  |
| 10:OFF | 110 | | | 60 | | | 80 | | | 10 | | 5 | |  |  |  |  |  |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | |  |  |  |  |  |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  |  |  |  |  |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  |  |  |  |  |
| 14:DCHG-S | 12 | | | 10 | | | 10 | | | 21 | | 21 | |  |  |  |  |  |
| 15:DCHG-R | 12 | | | 10 | | | 10 | | | 21 | | 15 | |  |  |  |  |  |
| 16:SV | 10 | | | 8 | | | 8 | | | 18 | | 12 | |  |  |  |  |  |
| 17:RV | 10 | | | 8 | | | 8 | | | 18 | | 12 | |  |  |  |  |  |
| 18:IPM | 19 | | | 20 | | | 15 | | | 12 | | 12 | |  |  |  |  |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 6 | |  |  |  |  |  |
| 20:SV.MODE | 60H | | | 71H | | | 71H | | | 31H | | 31H | |  |  |  |  |  |
| 21:SV. | 04H | | | 02H | | | 02H | | | 0EH | | 0EH | |  |  |  |  |  |
| 22:SV.ADJ | 100 | | | 66 | | | 32 | | | 0 | | 0 | |  |  |  |  |  |
| 23:SPEED | 0.50 | | | 8.00 | | | 8.00 | | | 8.00 | | 8.00 | |  |  |  |  |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 10H | | 10H | |  |  |  |  |  |
| 25:PRG-ON | 04H | | | 09H | | | 09H | | | 09H | | 09H | |  |  |  |  |  |
| 26:PRG0-1 | 0000H | | | 0C3DH | | | 0C3DH | | | 0F3DH | | 0F3DH | |  |  |  |  |  |
| 27:PRG0-2 | 00H | | | 55H | | | 55H | | | 55H | | 33H | |  |  |  |  |  |
| 28:PRG0-3 | 00H | | | 9AH | | | AAH | | | AAH | | AAH | |  |  |  |  |  |
| 29:PRG0-4 | 00H | | | BBH | | | AAH | | | AAH | | AAH | |  |  |  |  |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  |  |  |  |  |
| 31:PRG2-1 | 70 | | | 0 | | | 0 | | | 0 | | 0 | |  |  |  |  |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  |  |  |  |  |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  |  |  |  |  |
| 34:PRG3-2 | 00H | | | 40H | | | 40H | | | 40H | | 40H | |  |  |  |  |  |
| 35:PRG3-3 | 0 | | | 2 | | | 2 | | | 0 | | 0 | |  |  |  |  |  |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | |  |  |  |  |  |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |  |  |  |  |  |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  |  |  |  |  |
| 39:ADC1-1 | 17H | | | 00H | | | 00H | | | 00H | | 00H | |  |  |  |  |  |
| 40:ADC1-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | |  |  |  |  |  |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  |  |  |  |  |
| 42:ADC2-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | |  |  |  |  |  |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | |  |  |  |  |  |
| 44:OVERRIDE U | 160 | | | 100 | | | 100 | | | 100 | | 100 | |  |  |  |  |  |
| 45:OVERRIDE L | 160 | | | 100 | | | 100 | | | 100 | | 100 | |  |  |  |  |  |
| 46:WIRE FEED | 16 | | | 16 | | | 16 | | | 16 | | 16 | |  |  |  |  |  |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | |  |  |  |  |  |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | |  |  |  |  |  |
| 49:EST.SPEED | 0.23 | | | 2.0 | | | 1.6 | | | 8.0 | | 8.0 | |  |  |  |  |  |

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|  |  |  |  |
| --- | --- | --- | --- |
| Wire | W. Material | MC. Method | Finish |
| BS 0.20mm | St | Both Away | Roughing ~ +1 Finish 2(D) |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| W. Thickness(mm) | 150 Die | | | | | | | | | | | | |  | | | | |
| MODEL No. |  | | | | | | | | | | | | |  | | | | |
| PROCESS | 1st 2nd | | | | | | | | | 3rd | |  | |  |  |  |  |  |
| E No. | E1156 | | | E2152 | | | E2153 | | | E2154 | | E2155 | |  |  |  |  |  |
| H Value | V-corner | | |  | | |  | | |  | |  | |  |  |  |  |  |
| Offset Roughing | 0.150 | | | - | | | - | | | - | | - | |  |  |  |  |  |
|  | 0.168 | | | 0.108 | | | - | | | - | | - | |  |  |  |  |  |
| Finish 7(D) | 0.179 | | | 0.119 | | | 0.106 | | | - | | - | |  |  |  |  |  |
| Finish 3(D) | 0.184 | | | 0.124 | | | 0.111 | | | 0.108 | | - | |  |  |  |  |  |
| Finish 2(D) | 0.186 | | | 0.126 | | | 0.113 | | | 0.110 | | 0.108 | |  |  |  |  |  |
|  | 0.199 | | | 0.139  0.119 | | | -  0.106 | | | -  - | | -  - | |  |  |  |  |  |
|  | 0.204 | | | 0.144  0.124 | | | -  0.111 | | | -  0.108 | | -  - | |  |  |  |  |  |
|  | 0.206 | | | 0.146  0.126 | | | -  0.113 | | | -  0.110 | | -  0.108 | |  |  |  |  |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | |  |  |  |  |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | |  |  |  |  |  |
| Removal rate  (mm/min) | 0.18  0.25 | | | 1.5 | | |  | | | 8.0 | | 8.0 | |  |  |  |  |  |
| Servo lump  state | 4 6 | | | 5 7 | | | 3 4 | | | 2 4 | | 2 4 | |  |  |  |  |  |
|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | |  |  |  |  |  |
| 12 | | | 12 | | | 12 | | |
| Surface(micron) | 20 | | | 13 | | | 7.5 | | | 3.3 3.8 | | 2.3 2.8 | |  |  |  |  |  |
| 01: E No. | E1156 | | | E2152 | | | E2153 | | | E2154 | | E2155 | |  |  |  |  |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | |  |  |  |  |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  |  |  |  |  |
| 04:THICKNESS | 150.0 | | | 150.0 | | | 150.0 | | | 150.0 | | 150.0 | |  |  |  |  |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 3 | |  |  |  |  |  |
| 06:ONA | 30 | | | 8 | | | 3 | | | 4 | | 3 | |  |  |  |  |  |
| 07:ONB | 40 | | | 8 | | | 3 | | | 4 | | 3 | |  |  |  |  |  |
| 08:ONC | 15 | | | 8 | | | 3 | | | 1 | | 1 | |  |  |  |  |  |
| 09:OND | 20 | | | 8 | | | 3 | | | 1 | | 1 | |  |  |  |  |  |
| 10:OFF | 110 | | | 60 | | | 80 | | | 10 | | 5 | |  |  |  |  |  |
| 11:TS | 10 | | | 10 | | | 10 | | | 5 | | 5 | |  |  |  |  |  |
| 12:SCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  |  |  |  |  |
| 13:RCT | 250 | | | 150 | | | 150 | | | 150 | | 150 | |  |  |  |  |  |
| 14:DCHG-S | 12 | | | 10 | | | 10 | | | 21 | | 21 | |  |  |  |  |  |
| 15:DCHG-R | 12 | | | 10 | | | 10 | | | 21 | | 15 | |  |  |  |  |  |
| 16:SV | 10 | | | 8 | | | 8 | | | 18 | | 12 | |  |  |  |  |  |
| 17:RV | 10 | | | 8 | | | 8 | | | 18 | | 12 | |  |  |  |  |  |
| 18:IPM | 19 | | | 20 | | | 15 | | | 12 | | 12 | |  |  |  |  |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 6 | |  |  |  |  |  |
| 20:SV.MODE | 60H | | | 71H | | | 71H | | | 31H | | 31H | |  |  |  |  |  |
| 21:SV. | 04H | | | 02H | | | 02H | | | 0EH | | 0EH | |  |  |  |  |  |
| 22:SV.ADJ | 100 | | | 72 | | | 38 | | | 0 | | 0 | |  |  |  |  |  |
| 23:SPEED | 0.50 | | | 8.00 | | | 8.00 | | | 8.00 | | 8.00 | |  |  |  |  |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 10H | | 10H | |  |  |  |  |  |
| 25:PRG-ON | 04H | | | 09H | | | 09H | | | 09H | | 09H | |  |  |  |  |  |
| 26:PRG0-1 | 0000H | | | 0C3DH | | | 0C3DH | | | 0F3DH | | 0F3DH | |  |  |  |  |  |
| 27:PRG0-2 | 00H | | | 55H | | | 55H | | | 55H | | 33H | |  |  |  |  |  |
| 28:PRG0-3 | 00H | | | 9AH | | | AAH | | | AAH | | AAH | |  |  |  |  |  |
| 29:PRG0-4 | 00H | | | BBH | | | AAH | | | AAH | | AAH | |  |  |  |  |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  |  |  |  |  |
| 31:PRG2-1 | 70 | | | 0 | | | 0 | | | 0 | | 0 | |  |  |  |  |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | 0 | |  |  |  |  |  |
| 33:PRG3-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | |  |  |  |  |  |
| 34:PRG3-2 | 00H | | | 40H | | | 40H | | | 40H | | 40H | |  |  |  |  |  |
| 35:PRG3-3 | 0 | | | 2 | | | 2 | | | 0 | | 0 | |  |  |  |  |  |
| 36:ADC-ON | 07H | | | 01H | | | 01H | | | 01H | | 01H | |  |  |  |  |  |
| 37:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | |  |  |  |  |  |
| 38:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | |  |  |  |  |  |
| 39:ADC1-1 | 17H | | | 00H | | | 00H | | | 00H | | 00H | |  |  |  |  |  |
| 40:ADC1-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | |  |  |  |  |  |
| 41:ADC2-1 | 67H | | | 00H | | | 00H | | | 00H | | 00H | |  |  |  |  |  |
| 42:ADC2-2 | 25H | | | 00H | | | 00H | | | 00H | | 00H | |  |  |  |  |  |
| 43:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | |  |  |  |  |  |
| 44:OVERRIDE U | 160 | | | 100 | | | 100 | | | 100 | | 100 | |  |  |  |  |  |
| 45:OVERRIDE L | 160 | | | 100 | | | 100 | | | 100 | | 100 | |  |  |  |  |  |
| 46:WIRE FEED | 16 | | | 16 | | | 16 | | | 16 | | 16 | |  |  |  |  |  |
| 47:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | |  |  |  |  |  |
| 48:COND. | 15 | | | 15 | | | 15 | | | 15 | | 15 | |  |  |  |  |  |
| 49:EST.SPEED | 0.23 | | | 2.0 | | | 1.6 | | | 8.0 | | 8.0 | |  |  |  |  |  |

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BS 0.20mm

Finish

WC Both Away



Use laminer nozzle(dia. 5mm)

Used V-corner for roughing

(No use G44 or G44H0)

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.2mm | WC | Both Away | Roughing~ finish 0.8 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 5 | | | | | | | | | | | | | | |  | | | |
| MODEL No. | 603030512 | | | | | | | | | | | | |  | |  | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | | 6th | |  |  |  |  |
| E No. | E1436 | | | E1437 | | | E1438 | | | E1439 | | E1440 | | E9\*\*\* | |  |  |  |  |
| H Value | V-corner | | | - | | | - | | | - | | - | | - | |  |  |  |  |
| Offset roughing | 0.128 | | | - | | | - | | | - | | - | | - | |  |  |  |  |
| 2nd | 0.154 | | | 0.106 | | | - | | | - | | - | | - | |  |  |  |  |
| finish 5 | 0.161 | | | 0.113 | | | 0.107 | | | - | | - | | - | |  |  |  |  |
| finish 2 | 0.165 | | | 0.117 | | | 0.111 | | | 0.106 | | - | | - | |  |  |  |  |
| finish 1 | 0.167 | | | 0.119 | | | 0.113 | | | 0.108 | | 0.106 | | - | |  |  |  |  |
| finish 0.8 | 0.167 | | | 0.119 | | | 0.113 | | | 0.108 | | 0.106 | | 0.105 | |  |  |  |  |
|  | - | | | - | | | - | | | - | | - | | - | |
|  | -  - | | | -  - | | | -  - | | | -  - | | -  - | | -  - | |  |  |  |  |
|  | -  - | | | -  - | | | -  - | | | -  - | | -  - | | -  - | |  |  |  |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | | - | |  |  |  |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | | - | |  |  |  |  |
| Removal rate  (mm/min) | 4.8  ~4.5 | | | 9.0  ~6.0 | | | 10.0  ~7.0 | | | 10.0 | | 3.0 | | 3.0 | |  |  |  |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 2~5 | | | 6~8 | | | 3~5 | | | 6~8 | | 6~8 | | 4~6 | |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | | Non  - | |  |  |  |  |
| 12 | | | 12 | | | 12 | | |
| Surface(micron) | 10 | | | 7 | | | 5 | | | 1.8 | | 1 | | 0.8 | |  |  |  |  |
| 01: E No. | E1436 | | | E1437 | | | E1438 | | | E1439 | | E1440 | | E9\*\*\* | |  |  |  |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | 0.200 | | 0.200 | |  |  |  |  |
| 03:MATERIAL | 3 | | | 3 | | | 3 | | | 3 | | 3 | | 3 | |  |  |  |  |
| 04:THICKNESS | 5.0 | | | 5.0 | | | 5.0 | | | 5.0 | | 5.0 | | 5.0 | |  |  |  |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 4 | | 4 | |  |  |  |  |
| 06:ONA | 30 | | | 6 | | | 1 | | | 2 | | 2 | | 1 | |  |  |  |  |
| 07:ONB | 50 | | | 6 | | | 1 | | | 2 | | 2 | | 1 | |  |  |  |  |
| 08:ONC | 10 | | | 6 | | | 1 | | | 1 | | 1 | | 1 | |  |  |  |  |
| 09:OND | 12 | | | 6 | | | 1 | | | 1 | | 1 | | 1 | |  |  |  |  |
| 10:OFF | 150 | | | 80 | | | 200 | | | 10 | | 4 | | 4 | |  |  |  |  |
| 11:TS | 10 | | | 10 | | | 8 | | | 5 | | 5 | | 5 | |  |  |  |  |
| 12:SCT | 100 | | | 100 | | | 100 | | | 100 | | 200 | | 200 | |  |  |  |  |
| 13:RCT | 100 | | | 100 | | | 100 | | | 100 | | 200 | | 200 | |  |  |  |  |
| 14:DCHG-S | 10 | | | 10 | | | 10 | | | 12 | | 12 | | 6 | |  |  |  |  |
| 15:DCHG-R | 10 | | | 10 | | | 10 | | | 12 | | 12 | | 6 | |  |  |  |  |
| 16:SV | 8 | | | 8 | | | 9 | | | 12 | | 12 | | 6 | |  |  |  |  |
| 17:RV | 8 | | | 8 | | | 9 | | | 12 | | 12 | | 6 | |  |  |  |  |
| 18:IPM | 18 | | | 15 | | | 10 | | | 12 | | 12 | | 6 | |  |  |  |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 6 | | 7 | |  |  |  |  |
| 20:SV.MODE | 00H | | | 11H | | | 11H | | | 31H | | 31H | | 31H | |  |  |  |  |
| 21:SV. | 00H | | | 04H | | | 04H | | | 0EH | | 0EH | | 0EH | |  |  |  |  |
| 22:SV.ADJ | 150 | | | 250 | | | 150 | | | 0 | | 0 | | 0 | |  |  |  |  |
| 23:SPEED | 5.0 | | | 12.0 | | | 10.0 | | | 10.0 | | 3.0 | | 3.0 | |  |  |  |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 12H | | 12H | | 11H | |  |  |  |  |
| 25:PRG-ON | 04 | | | 01H | | | 01H | | | 01H | | 01 | | 01 | |  |  |  |  |
| 26:PRG0-1 | 0000H | | | 0C3FH | | | 0C3FH | | | 0C3DH | | 0C3DH | | 0C3DH | |  |  |  |  |
| 27:PRG0-2 | 00H | | | 33 | | | 33 | | | 33 | | 33 | | 33 | |  |  |  |  |
| 28:PRG0-3 | 00H | | | A8H | | | A8H | | | A8H | | A8H | | A8H | |  |  |  |  |
| 29:PRG0-4 | 00H | | | BAH | | | BAH | | | BAH | | BAH | | BAH | |  |  |  |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | | 00H | |  |  |  |  |
| 31:PRG2-1 | 40 | | | 0 | | | 0 | | | 0 | | 0 | | 0 | |  |  |  |  |
| 32:PRG2-2 | 40 | | | 0 | | | 0 | | | 0 | | 0 | | 0 | |  |  |  |  |
| 33:ADC-ON | 05H | | | 05H | | | 01H | | | 01H | | 01H | | 01H | |  |  |  |  |
| 34:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | | 0BH | |  |  |  |  |
| 35:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | | 1 | |  |  |  |  |
| 36:ADC1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | | 00H | |  |  |  |  |
| 37:ADC1-2 | 00H | | | 00H | | | 00H | | | 00H | | 00H | | 00H | |  |  |  |  |
| 38:ADC2-1 | 55H | | | 46H | | | 00H | | | 00H | | 00H | | 00H | |  |  |  |  |
| 39:ADC2-2 | 25H | | | 55H | | | 00H | | | 00H | | 00H | | 00H | |  |  |  |  |
| 40:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | | 8 | |  |  |  |  |
| 41:OVERRIDE U | 140 | | | 125 | | | 125 | | | 125 | | 125 | | 125 | |  |  |  |  |
| 42:OVERRIDE L | 140 | | | 125 | | | 125 | | | 125 | | 125 | | 125 | |  |  |  |  |
| 43:WIRE FEED | 16 | | | 14 | | | 14 | | | 14 | | 14 | | 14 | |  |  |  |  |
| 44:TENSION | 6 | | | 7 | | | 7 | | | 7 | | 7 | | 7 | |  |  |  |  |
| 45:COND. | 30 | | | 30 | | | 30 | | | 30 | | 30 | | 30 | |  |  |  |  |
| 46:EST.SPEED | 4.65 | | | 7.5 | | | 8.0 | | | 10.0 | | 3.0 | | 3.0 | |  |  |  |  |

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| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.2mm | WC | Both Away | Roughing~ finish 0.8 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 10 | | | | | | | | | | | | | | | | |  | | | |
| MODEL No. | 603040512 | | | | | | | | | | | | | |  | | |  | | | |
| PROCESS | 1st | | 2nd | | | 3rd | | | 4th | | | 5th | | | 6th | | |  |  |  |  |
| E No. | E1446 | | E1447 | | | E1448 | | | E1449 | | | E1450 | | | E9\*\*\* | | |  |  |  |  |
| H Value | V-corner | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Offset roughing | 0.132 | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| 2nd | 0.158 | | 0.106 | | | - | | | - | | | - | | | - | | |  |  |  |  |
| finish 5 | 0.165 | | 0.113 | | | 0.107 | | | - | | | - | | | - | | |  |  |  |  |
| finish 2 | 0.170 | | 0.118 | | | 0.111 | | | 0.106 | | | - | | | - | | |  |  |  |  |
| finish 1 | 0.172 | | 0.120 | | | 0.113 | | | 0.108 | | | 0.106 | | | - | | |  |  |  |  |
| finish 0.8 | 0.172 | | 0.120 | | | 0.113 | | | 0.108 | | | 0.106 | | | 0.105 | | |  |  |  |  |
|  | - | | - | | | - | | | - | | | - | | | - | | |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |  |  |  |  |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |  |  |  |  |
| Pressure Up.(Mpa) | - | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Low(Mpa | - | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Removal rate  (mm/min) | 3.5  ~3.4 | | 6.0  ~4.0 | | | 6.0  ~4.5 | | | 6.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 2~5 | | 6~8 | | | 1~3 | | | 7~9 | | | 7~9 | | | 5~8 | | |
| Spark lump  state |  | |  | | |  | | | Non  - | | | Non  - | | | Non  - | | |  |  |  |  |
| 12 | | 12 | | | 12 | | |
| Surface(micron) | 10 | | 7 | | | 5 | | | 1.8 | | | 1 | | | 0.8 | | |  |  |  |  |
| 01: E No. | E1446 | | E1447 | | | E1448 | | | E1449 | | | E1450 | | | E9\*\*\* | | |  |  |  |  |
| 02:WIRE DIA. | 0.200 | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | |  |  |  |  |
| 03:MATERIAL | 3 | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | |  |  |  |  |
| 04:THICKNESS | 10.0 | | 10.0 | | | 10.0 | | | 10.0 | | | 10.0 | | | 10.0 | | |  |  |  |  |
| 05:MODE | 0 | | 1 | | | 1 | | | 3 | | | 4 | | | 4 | | |  |  |  |  |
| 06:ONA | 30 | | 7 | | | 1 | | | 2 | | | 2 | | | 1 | | |  |  |  |  |
| 07:ONB | 50 | | 7 | | | 1 | | | 2 | | | 2 | | | 1 | | |  |  |  |  |
| 08:ONC | 10 | | 7 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 09:OND | 12 | | 7 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 10:OFF | 100 | | 80 | | | 200 | | | 10 | | | 4 | | | 4 | | |  |  |  |  |
| 11:TS | 10 | | 10 | | | 8 | | | 5 | | | 5 | | | 5 | | |  |  |  |  |
| 12:SCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 200 | | |  |  |  |  |
| 13:RCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 200 | | |  |  |  |  |
| 14:DCHG-S | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 15:DCHG-R | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 16:SV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 17:RV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 18:IPM | 20 | | 15 | | | 10 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 19:IPS | 7 | | 7 | | | 7 | | | 1 | | | 6 | | | 7 | | |  |  |  |  |
| 20:SV.MODE | 00H | | 11H | | | 11H | | | 31H | | | 31H | | | 31H | | |  |  |  |  |
| 21:SV. | 00H | | 04H | | | 04H | | | 0EH | | | 0EH | | | 0EH | | |  |  |  |  |
| 22:SV.ADJ | 120 | | 200 | | | 100 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 23:SPEED | 3.6 | | 10.0 | | | 6.0 | | | 6.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |
| 24:SM-REF | 33H | | 33H | | | 33H | | | 11 | | | 11 | | | 10H | | |  |  |  |  |
| 25:PRG-ON | 04 | | 01H | | | 01H | | | 01H | | | 01 | | | 01 | | |  |  |  |  |
| 26:PRG0-1 | 0000H | | 0C3FH | | | 0C3FH | | | 0C3DH | | | 0C3DH | | | 0C3DH | | |  |  |  |  |
| 27:PRG0-2 | 00H | | 33 | | | 33 | | | 33 | | | 33 | | | 33 | | |  |  |  |  |
| 28:PRG0-3 | 00H | | A8H | | | A8H | | | A8H | | | A8H | | | A8H | | |  |  |  |  |
| 29:PRG0-4 | 00H | | BAH | | | BAH | | | BAH | | | BAH | | | BAH | | |  |  |  |  |
| 30:PRG1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 31:PRG2-1 | 45 | | 0 | | | 0 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 32:PRG2-2 | 40 | | 0 | | | 0 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 33:ADC-ON | 05H | | 05H | | | 01H | | | 01H | | | 01H | | | 01H | | |  |  |  |  |
| 34:ADC0-1 | 0BH | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | |  |  |  |  |
| 35:ADC0-2 | 1 | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 36:ADC1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 37:ADC1-2 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 38:ADC2-1 | 55H | | 46H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 39:ADC2-2 | 25H | | 55H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 40:FLUSHING | 6 | | 8 | | | 8 | | | 8 | | | 8 | | | 8 | | |  |  |  |  |
| 41:OVERRIDE U | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 125 | | |  |  |  |  |
| 42:OVERRIDE L | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 125 | | |  |  |  |  |
| 43:WIRE FEED | 16 | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | |  |  |  |  |
| 44:TENSION | 6 | | 7 | | | 7 | | | 7 | | | 7 | | | 7 | | |  |  |  |  |
| 45:COND. | 30 | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | |  |  |  |  |
| 46:EST.SPEED | 3.45 | | 4.0 | | | 4.5 | | | 5.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |

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| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.2mm | WC | Both Away | Roughing~ finish 0.8 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 15 | | | | | | | | | | | | | | | | |  | | | |
| MODEL No. | 603050512 | | | | | | | | | | | | | |  | | |  | | | |
| PROCESS | 1st | | 2nd | | | 3rd | | | 4th | | | 5th | | | 6th | | |  |  |  |  |
| E No. | E1456 | | E1457 | | | E1458 | | | E1459 | | | E1460 | | | E9\*\*\* | | |  |  |  |  |
| H Value | V-corner | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Offset roughing | 0.135 | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| 2nd | 0.163 | | 0.108 | | | - | | | - | | | - | | | - | | |  |  |  |  |
| finish 5 | 0.169 | | 0.114 | | | 0.107 | | | - | | | - | | | - | | |  |  |  |  |
| finish 2 | 0.173 | | 0.118 | | | 0.111 | | | 0.106 | | | - | | | - | | |  |  |  |  |
| finish 1 | 0.175 | | 0.120 | | | 0.113 | | | 0.108 | | | 0.106 | | | - | | |  |  |  |  |
| finish 0.8 | 0.175 | | 0.120 | | | 0.113 | | | 0.108 | | | 0.106 | | | 0.105 | | |  |  |  |  |
|  | - | | - | | | - | | | - | | | - | | | - | | |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |  |  |  |  |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |  |  |  |  |
| Pressure Up.(Mpa) | - | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Low(Mpa | - | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Removal rate  (mm/min) | 2.9  ~2.7 | | 4.5  ~3.1 | | | 5.0  ~3.8 | | | 5.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 2~4 | | 6~8 | | | 1~3 | | | 3~5 | | | 3~5 | | | 2~5 | | |
| Spark lump  state |  | |  | | |  | | | Non  - | | | Non  - | | | Non  - | | |  |  |  |  |
| 12 | | 12 | | | 12 | | |
| Surface(micron) | 10 | | 7 | | | 5 | | | 1.8 | | | 1 | | | 0.8 | | |  |  |  |  |
| 01: E No. | E1456 | | E1457 | | | E1458 | | | E1459 | | | E1460 | | | E9\*\*\* | | |  |  |  |  |
| 02:WIRE DIA. | 0.200 | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | |  |  |  |  |
| 03:MATERIAL | 3 | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | |  |  |  |  |
| 04:THICKNESS | 15.0 | | 15.0 | | | 15.0 | | | 15.0 | | | 15.0 | | | 15.0 | | |  |  |  |  |
| 05:MODE | 0 | | 1 | | | 1 | | | 3 | | | 4 | | | 4 | | |  |  |  |  |
| 06:ONA | 30 | | 7 | | | 1 | | | 2 | | | 2 | | | 1 | | |  |  |  |  |
| 07:ONB | 50 | | 7 | | | 1 | | | 2 | | | 2 | | | 1 | | |  |  |  |  |
| 08:ONC | 10 | | 7 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 09:OND | 12 | | 7 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 10:OFF | 70 | | 60 | | | 180 | | | 10 | | | 4 | | | 4 | | |  |  |  |  |
| 11:TS | 10 | | 10 | | | 8 | | | 5 | | | 5 | | | 5 | | |  |  |  |  |
| 12:SCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 200 | | |  |  |  |  |
| 13:RCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 200 | | |  |  |  |  |
| 14:DCHG-S | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 15:DCHG-R | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 16:SV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 17:RV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 18:IPM | 20 | | 15 | | | 10 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 19:IPS | 7 | | 7 | | | 7 | | | 1 | | | 6 | | | 7 | | |  |  |  |  |
| 20:SV.MODE | 00H | | 11H | | | 11H | | | 31H | | | 31H | | | 31H | | |  |  |  |  |
| 21:SV. | 00H | | 04H | | | 04H | | | 0EH | | | 0EH | | | 0EH | | |  |  |  |  |
| 22:SV.ADJ | 80 | | 180 | | | 70 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 23:SPEED | 3.0 | | 9.0 | | | 5.0 | | | 5.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |
| 24:SM-REF | 33H | | 33H | | | 33H | | | 11 | | | 11 | | | 10H | | |  |  |  |  |
| 25:PRG-ON | 04 | | 01H | | | 01H | | | 01H | | | 01 | | | 01 | | |  |  |  |  |
| 26:PRG0-1 | 0000H | | 0C3FH | | | 0C3FH | | | 0C3DH | | | 0C3DH | | | 0C3DH | | |  |  |  |  |
| 27:PRG0-2 | 00H | | 33 | | | 33 | | | 33 | | | 33 | | | 33 | | |  |  |  |  |
| 28:PRG0-3 | 00H | | A8H | | | A8H | | | A8H | | | A8H | | | A8H | | |  |  |  |  |
| 29:PRG0-4 | 00H | | BAH | | | BAH | | | BAH | | | BAH | | | BAH | | |  |  |  |  |
| 30:PRG1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 31:PRG2-1 | 50 | | 0 | | | 0 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 32:PRG2-2 | 40 | | 0 | | | 0 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 33:ADC-ON | 05H | | 05H | | | 01H | | | 01H | | | 01H | | | 01H | | |  |  |  |  |
| 34:ADC0-1 | 0BH | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | |  |  |  |  |
| 35:ADC0-2 | 1 | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 36:ADC1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 37:ADC1-2 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 38:ADC2-1 | 55H | | 46H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 39:ADC2-2 | 25H | | 55H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 40:FLUSHING | 6 | | 8 | | | 8 | | | 8 | | | 8 | | | 8 | | |  |  |  |  |
| 41:OVERRIDE U | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 125 | | |  |  |  |  |
| 42:OVERRIDE L | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 125 | | |  |  |  |  |
| 43:WIRE FEED | 16 | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | |  |  |  |  |
| 44:TENSION | 6 | | 7 | | | 7 | | | 7 | | | 7 | | | 7 | | |  |  |  |  |
| 45:COND. | 30 | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | |  |  |  |  |
| 46:EST.SPEED | 2.8 | | 4.0 | | | 4.5 | | | 5.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |

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| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.2mm | WC | Both Away | Roughing~ finish 0.8 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 20 | | | | | | | | | | | | | | | | |  | | | |
| MODEL No. | 603060512 | | | | | | | | | | | | | |  | | |  | | | |
| PROCESS | 1st | | 2nd | | | 3rd | | | 4th | | | 5th | | | 6th | | |  |  |  |  |
| E No. | E1466 | | E1467 | | | E1468 | | | E1469 | | | E1470 | | | E9\*\*\* | | |  |  |  |  |
| H Value | V-corner | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Offset roughing | 0.137 | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| 2nd | 0.165 | | 0.108 | | | - | | | - | | | - | | | - | | |  |  |  |  |
| finish 5 | 0.172 | | 0.115 | | | 0.107 | | | - | | | - | | | - | | |  |  |  |  |
| finish 2 | 0.176 | | 0.119 | | | 0.111 | | | 0.106 | | | - | | | - | | |  |  |  |  |
| finish 1 | 0.177 | | 0.120 | | | 0.112 | | | 0.107 | | | 0.105 | | | - | | |  |  |  |  |
| finish 0.8 | 0.178 | | 0.121 | | | 0.113 | | | 0.108 | | | 0.106 | | | 0.105 | | |  |  |  |  |
|  | - | | - | | | - | | | - | | | - | | | - | | |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |  |  |  |  |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |  |  |  |  |
| Pressure Up.(Mpa) | - | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Low(Mpa | - | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Removal rate  (mm/min) | 2.3  ~2.1 | | 3.5  ~2.3 | | | 4.8  ~3.2 | | | 5.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 2~4 | | 6~8 | | | 0~2 | | | 3~5 | | | 3~5 | | | 2~5 | | |
| Spark lump  state |  | |  | | |  | | | Non  - | | | Non  - | | | Non  - | | |  |  |  |  |
| 12 | | 12 | | | 12 | | |
| Surface(micron) | 10 | | 7 | | | 5 | | | 1.8 | | | 1 | | | 0.8 | | |  |  |  |  |
| 01: E No. | E1466 | | E1467 | | | E1468 | | | E1469 | | | E1470 | | | E9\*\*\* | | |  |  |  |  |
| 02:WIRE DIA. | 0.200 | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | |  |  |  |  |
| 03:MATERIAL | 3 | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | |  |  |  |  |
| 04:THICKNESS | 20.0 | | 20.0 | | | 20.0 | | | 20.0 | | | 20.0 | | | 20.0 | | |  |  |  |  |
| 05:MODE | 0 | | 1 | | | 1 | | | 3 | | | 4 | | | 4 | | |  |  |  |  |
| 06:ONA | 30 | | 7 | | | 1 | | | 2 | | | 2 | | | 1 | | |  |  |  |  |
| 07:ONB | 50 | | 7 | | | 1 | | | 2 | | | 2 | | | 1 | | |  |  |  |  |
| 08:ONC | 10 | | 7 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 09:OND | 12 | | 7 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 10:OFF | 70 | | 60 | | | 160 | | | 10 | | | 4 | | | 4 | | |  |  |  |  |
| 11:TS | 10 | | 10 | | | 8 | | | 5 | | | 5 | | | 5 | | |  |  |  |  |
| 12:SCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 200 | | |  |  |  |  |
| 13:RCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 200 | | |  |  |  |  |
| 14:DCHG-S | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 8 | | |  |  |  |  |
| 15:DCHG-R | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 8 | | |  |  |  |  |
| 16:SV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 8 | | |  |  |  |  |
| 17:RV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 8 | | |  |  |  |  |
| 18:IPM | 20 | | 15 | | | 10 | | | 12 | | | 12 | | | 8 | | |  |  |  |  |
| 19:IPS | 7 | | 7 | | | 7 | | | 1 | | | 6 | | | 7 | | |  |  |  |  |
| 20:SV.MODE | 00H | | 11H | | | 11H | | | 31H | | | 31H | | | 31H | | |  |  |  |  |
| 21:SV. | 00H | | 04H | | | 04H | | | 0EH | | | 0EH | | | 0EH | | |  |  |  |  |
| 22:SV.ADJ | 60 | | 175 | | | 60 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 23:SPEED | 2.5 | | 7.0 | | | 5.0 | | | 5.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |
| 24:SM-REF | 33H | | 33H | | | 33H | | | 11 | | | 11 | | | 10H | | |  |  |  |  |
| 25:PRG-ON | 04 | | 01H | | | 01H | | | 01H | | | 01 | | | 01 | | |  |  |  |  |
| 26:PRG0-1 | 0000H | | 0D3FH | | | 0D3FH | | | 0D3DH | | | 0D3DH | | | 0D3DH | | |  |  |  |  |
| 27:PRG0-2 | 00H | | 33 | | | 33 | | | 33 | | | 33 | | | 33 | | |  |  |  |  |
| 28:PRG0-3 | 00H | | A8H | | | A8H | | | A8H | | | A8H | | | A8H | | |  |  |  |  |
| 29:PRG0-4 | 00H | | BAH | | | BAH | | | BAH | | | BAH | | | BAH | | |  |  |  |  |
| 30:PRG1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 31:PRG2-1 | 55 | | 0 | | | 0 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 32:PRG2-2 | 40 | | 0 | | | 0 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 33:ADC-ON | 05H | | 05H | | | 01H | | | 01H | | | 01H | | | 01H | | |  |  |  |  |
| 34:ADC0-1 | 0BH | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | |  |  |  |  |
| 35:ADC0-2 | 1 | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 36:ADC1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 37:ADC1-2 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 38:ADC2-1 | 55H | | 46H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 39:ADC2-2 | 25H | | 55H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 40:FLUSHING | 6 | | 8 | | | 8 | | | 8 | | | 8 | | | 8 | | |  |  |  |  |
| 41:OVERRIDE U | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 125 | | |  |  |  |  |
| 42:OVERRIDE L | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 125 | | |  |  |  |  |
| 43:WIRE FEED | 16 | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | |  |  |  |  |
| 44:TENSION | 6 | | 7 | | | 7 | | | 7 | | | 7 | | | 7 | | |  |  |  |  |
| 45:COND. | 30 | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | |  |  |  |  |
| 46:EST.SPEED | 2.3 | | 3.0 | | | 4.0 | | | 5.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |

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| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.2mm | WC | Both Away | Roughing~ finish 1 |

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| THICKNESS(mm) | 25 | | | | | | | | | | | | | | 30 | | | | | | | | | | | | | | |
| MODEL No. | 0603070512 | | | | | | | | | | | | | | 0603080512 | | | | | | | | | | | | | | |
| PROCESS | 1st | | 2nd | | | 3rd | | | 4th | | | 5th | | | 1st | | | 2nd | | | 3rd | | | 4th | | | 5th | | |
| E No. | E1476 | | E1477 | | | E1478 | | | E1479 | | | E1480 | | | E1486 | | | E1487 | | | E1488 | | | E1489 | | | E1490 | | |
| H Value | V-corner | | - | | | - | | | - | | | - | | | V-corner | | | - | | | - | | | - | | | - | | |
| Offset roughing | 0.140 | | - | | | - | | | - | | | - | | | 0.143 | | | - | | | - | | | - | | | - | | |
| 2nd | 0.168 | | 0.108 | | | - | | | - | | | - | | | 0.173 | | | 0.110 | | | - | | | - | | | - | | |
| finish 5 | 0.175 | | 0.115 | | | 0.107 | | | - | | | - | | | 0.180 | | | 0.117 | | | 0.107 | | | - | | | - | | |
| finish 2 | 0.179 | | 0.119 | | | 0.111 | | | 0.106 | | | - | | | 0.184 | | | 0.121 | | | 0.111 | | | 0.106 | | | - | | |
| finish 1 | 0.181 | | 0.121 | | | 0.113 | | | 0.108 | | | 0.106 | | | 0.186 | | | 0.123 | | | 0.113 | | | 0.108 | | | 0.106 | | |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |
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|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |
| Pressure Up.(Mpa) | - | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | |
| Low(Mpa | - | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | |
| Removal rate  (mm/min) | 1.8  ~1.6 | | 3.0  ~1.5 | | | 4.0  ~3.0 | | | 4.5 | | | 3.0 | | | 1.5  ~1.3 | | | 2.5  ~1.2 | | | 3.5  ~2.8 | | | 4.0 | | | 3.0 | | |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 2~4 | | 6~8 | | | 0~2 | | | 3~5 | | | 3~5 | | | 3~5 | | | 6~8 | | | 0~2 | | | 3~5 | | | 3~5 | | |
| Spark lump  state |  | |  | | |  | | | Non  - | | | Non  - | | |  | | |  | | |  | | | Non  - | | | Non  - | | |
| 12 | | 12 | | | 12 | | | 12 | | | 12 | | | 12 | | |
| Surface(micron) | 10 | | 7 | | | 5 | | | 1.8 | | | 1 | | | 10 | | | 7 | | | 5 | | | 1.8 | | | 1 | | |
| 01: E No. | E1476 | | E1477 | | | E1478 | | | E1479 | | | E1480 | | | E1486 | | | E1487 | | | E1488 | | | E1489 | | | E1490 | | |
| 02:WIRE DIA. | 0.200 | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | |
| 03:MATERIAL | 3 | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | |
| 04:THICKNESS | 25.0 | | 25.0 | | | 25.0 | | | 25.0 | | | 25.0 | | | 30.0 | | | 30.0 | | | 30.0 | | | 30.0 | | | 30.0 | | |
| 05:MODE | 0 | | 1 | | | 1 | | | 3 | | | 4 | | | 0 | | | 1 | | | 1 | | | 3 | | | 4 | | |
| 06:ONA | 30 | | 7 | | | 1 | | | 2 | | | 2 | | | 30 | | | 7 | | | 1 | | | 2 | | | 2 | | |
| 07:ONB | 50 | | 7 | | | 1 | | | 2 | | | 2 | | | 50 | | | 7 | | | 1 | | | 2 | | | 2 | | |
| 08:ONC | 10 | | 7 | | | 1 | | | 1 | | | 1 | | | 10 | | | 7 | | | 1 | | | 1 | | | 1 | | |
| 09:OND | 12 | | 7 | | | 1 | | | 1 | | | 1 | | | 12 | | | 7 | | | 1 | | | 1 | | | 1 | | |
| 10:OFF | 80 | | 60 | | | 150 | | | 10 | | | 4 | | | 80 | | | 60 | | | 140 | | | 10 | | | 4 | | |
| 11:TS | 10 | | 10 | | | 8 | | | 5 | | | 5 | | | 10 | | | 10 | | | 8 | | | 5 | | | 5 | | |
| 12:SCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 100 | | | 100 | | | 100 | | | 100 | | | 200 | | |
| 13:RCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 100 | | | 100 | | | 100 | | | 100 | | | 200 | | |
| 14:DCHG-S | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 10 | | | 10 | | | 10 | | | 12 | | | 12 | | |
| 15:DCHG-R | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 10 | | | 10 | | | 10 | | | 12 | | | 12 | | |
| 16:SV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 8 | | | 8 | | | 9 | | | 12 | | | 12 | | |
| 17:RV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 8 | | | 8 | | | 9 | | | 12 | | | 12 | | |
| 18:IPM | 20 | | 15 | | | 10 | | | 12 | | | 12 | | | 20 | | | 15 | | | 10 | | | 12 | | | 12 | | |
| 19:IPS | 7 | | 7 | | | 7 | | | 1 | | | 6 | | | 7 | | | 7 | | | 7 | | | 1 | | | 6 | | |
| 20:SV.MODE | 00H | | 11H | | | 11H | | | 31H | | | 31H | | | 00H | | | 11H | | | 11H | | | 31H | | | 31H | | |
| 21:SV. | 00H | | 04H | | | 04H | | | 0EH | | | 0EH | | | 00H | | | 04H | | | 04H | | | 0EH | | | 0EH | | |
| 22:SV.ADJ | 60 | | 170 | | | 55 | | | 0 | | | 0 | | | 60 | | | 170 | | | 55 | | | 0 | | | 0 | | |
| 23:SPEED | 2.0 | | 6.0 | | | 4.5 | | | 4.5 | | | 3.0 | | | 1.6 | | | 5.0 | | | 4.0 | | | 4.0 | | | 3.0 | | |
| 24:SM-REF | 33H | | 33H | | | 33H | | | 11 | | | 11 | | | 33H | | | 33H | | | 33H | | | 11 | | | 11 | | |
| 25:PRG-ON | 04 | | 01H | | | 01H | | | 01H | | | 01 | | | 04 | | | 01H | | | 01H | | | 01H | | | 01 | | |
| 26:PRG0-1 | 0000H | | 0D3FH | | | 0D3FH | | | 0D3DH | | | 0D3DH | | | 0000H | | | 0D3FH | | | 0D3FH | | | 0D3DH | | | 0D3DH | | |
| 27:PRG0-2 | 00H | | 33 | | | 33 | | | 33 | | | 33 | | | 00H | | | 33 | | | 33 | | | 33 | | | 33 | | |
| 28:PRG0-3 | 00H | | A8H | | | A8H | | | A8H | | | A8H | | | 00H | | | A8H | | | A8H | | | A8H | | | A8H | | |
| 29:PRG0-4 | 00H | | BAH | | | BAH | | | BAH | | | BAH | | | 00H | | | BAH | | | BAH | | | BAH | | | BAH | | |
| 30:PRG1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 31:PRG2-1 | 55 | | 0 | | | 0 | | | 0 | | | 0 | | | 55 | | | 0 | | | 0 | | | 0 | | | 0 | | |
| 32:PRG2-2 | 40 | | 0 | | | 0 | | | 0 | | | 0 | | | 40 | | | 0 | | | 0 | | | 0 | | | 0 | | |
| 33:ADC-ON | 05H | | 05H | | | 01H | | | 01H | | | 01H | | | 05H | | | 05H | | | 01H | | | 01H | | | 01H | | |
| 34:ADC0-1 | 0BH | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | |
| 35:ADC0-2 | 1 | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | |
| 36:ADC1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 37:ADC1-2 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 38:ADC2-1 | 55H | | 46H | | | 00H | | | 00H | | | 00H | | | 55H | | | 46H | | | 00H | | | 00H | | | 00H | | |
| 39:ADC2-2 | 25H | | 55H | | | 00H | | | 00H | | | 00H | | | 25H | | | 55H | | | 00H | | | 00H | | | 00H | | |
| 40:FLUSHING | 6 | | 8 | | | 8 | | | 8 | | | 8 | | | 6 | | | 8 | | | 8 | | | 8 | | | 8 | | |
| 41:OVERRIDE U | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 140 | | | 150 | | | 150 | | | 150 | | | 150 | | |
| 42:OVERRIDE L | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 140 | | | 150 | | | 150 | | | 150 | | | 150 | | |
| 43:WIRE FEED | 16 | | 14 | | | 14 | | | 14 | | | 14 | | | 16 | | | 14 | | | 14 | | | 14 | | | 14 | | |
| 44:TENSION | 6 | | 7 | | | 7 | | | 7 | | | 7 | | | 6 | | | 7 | | | 7 | | | 7 | | | 7 | | |
| 45:COND. | 30 | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | |
| 46:EST.SPEED | 1.7 | | 2.5 | | | 3.0 | | | 4.5 | | | 3.0 | | | 1.4 | | | 2.0 | | | 3.0 | | | 4.0 | | | 3.0 | | |

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| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.2mm | WC | Both Away | Roughing~ finish 1.5 |

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| THICKNESS(mm) | 40 | | | | | | | | | | | | | | 50 | | | | | | | | | | | | | | |
| MODEL No. | 0603090512 | | | | | | | | | | | | | | 0603100512 | | | | | | | | | | | | | | |
| PROCESS | 1st | | 2nd | | | 3rd | | | 4th | | | 5th | | | 1st | | | 2nd | | | 3rd | | | 4th | | | 5th | | |
| E No. | E1496 | | E1497 | | | E1498 | | | E1499 | | | E1500 | | | E1506 | | | E1507 | | | E1508 | | | E1509 | | | E1510 | | |
| H Value | V-corner | | - | | | - | | | - | | | - | | | V-corner | | | - | | | - | | | - | | | - | | |
| Offset roughing | 0.144 | | - | | | - | | | - | | | - | | | 0.146 | | |  | | |  | | |  | | |  | | |
| 2nd | 0.174 | | 0.110 | | | - | | | - | | | - | | | 0.173 | | | 0.110 | | |  | | |  | | |  | | |
| finish 5 | 0.181 | | 0.117 | | | 0.107 | | | - | | | - | | | 0.180 | | | 0.117 | | | 0.107 | | |  | | |  | | |
| finish 2 | 0.185 | | 0.121 | | | 0.111 | | | 0.107 | | | - | | | 0.183 | | | 0.120 | | | 0.110 | | | 0.106 | | |  | | |
| finish 1.5 | 0.188 | | 0.124 | | | 0.114 | | | 0.110 | | | 0.106 | | | 0.186 | | | 0.123 | | | 0.113 | | | 0.109 | | | 0.106 | | |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |
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| Pressure Up.(Mpa) | - | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | |
| Low(Mpa | - | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | |
| Removal rate  (mm/min) | 1.1  ~0.9 | | 1.8  ~1.0 | | | 2.5  ~2.0 | | | 4.0 | | | 4.0 | | | 0.9  ~0.7 | | | 1.6  ~0.8 | | | 2.0  ~1.0 | | | 4.0 | | | 4.0 | | |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 3~5 | | 6~8 | | | 1~3 | | | 2~4 | | | 2~4 | | | 2~4 | | | 7~9 | | | 0~2 | | | 1~2 | | | 5~7 | | |
| Spark lump  state |  | |  | | |  | | | Non  - | | | Non  - | | |  | | |  | | |  | | | Non  - | | | Non  - | | |
| 12 | | 12 | | | 12 | | | 12 | | | 12 | | | 12 | | |
| Surface(micron) | 10 | | 7 | | | 5 | | | 2.5 | | | 1.8 | | | 10 | | | 7 | | | 5 | | | 2.5 | | | 1.8 | | |
| 01: E No. | E1496 | | E1497 | | | E1498 | | | E1499 | | | E1500 | | | E1506 | | | E1507 | | | E1508 | | | E1509 | | | E1510 | | |
| 02:WIRE DIA. | 0.200 | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | |
| 03:MATERIAL | 3 | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | |
| 04:THICKNESS | 40.0 | | 40.0 | | | 40.0 | | | 40.0 | | | 40.0 | | | 50.0 | | | 50.0 | | | 50.0 | | | 50.0 | | | 50.0 | | |
| 05:MODE | 0 | | 1 | | | 1 | | | 3 | | | 3 | | | 0 | | | 1 | | | 1 | | | 3 | | | 3 | | |
| 06:ONA | 30 | | 7 | | | 1 | | | 10 | | | 2 | | | 30 | | | 9 | | | 1 | | | 10 | | | 2 | | |
| 07:ONB | 50 | | 7 | | | 1 | | | 10 | | | 2 | | | 50 | | | 9 | | | 1 | | | 10 | | | 2 | | |
| 08:ONC | 10 | | 7 | | | 1 | | | 1 | | | 1 | | | 10 | | | 8 | | | 1 | | | 1 | | | 1 | | |
| 09:OND | 12 | | 7 | | | 1 | | | 1 | | | 1 | | | 12 | | | 8 | | | 1 | | | 1 | | | 1 | | |
| 10:OFF | 80 | | 60 | | | 135 | | | 100 | | | 10 | | | 80 | | | 60 | | | 130 | | | 100 | | | 10 | | |
| 11:TS | 10 | | 10 | | | 8 | | | 5 | | | 5 | | | 10 | | | 10 | | | 8 | | | 5 | | | 5 | | |
| 12:SCT | 100 | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | |
| 13:RCT | 100 | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | |
| 14:DCHG-S | 10 | | 10 | | | 10 | | | 15 | | | 12 | | | 10 | | | 10 | | | 10 | | | 15 | | | 12 | | |
| 15:DCHG-R | 10 | | 10 | | | 10 | | | 15 | | | 12 | | | 10 | | | 10 | | | 10 | | | 15 | | | 12 | | |
| 16:SV | 8 | | 8 | | | 9 | | | 14 | | | 12 | | | 8 | | | 8 | | | 9 | | | 14 | | | 12 | | |
| 17:RV | 8 | | 8 | | | 9 | | | 14 | | | 12 | | | 8 | | | 8 | | | 9 | | | 14 | | | 12 | | |
| 18:IPM | 20 | | 15 | | | 10 | | | 14 | | | 12 | | | 20 | | | 15 | | | 10 | | | 14 | | | 12 | | |
| 19:IPS | 7 | | 7 | | | 7 | | | 1 | | | 1 | | | 7 | | | 7 | | | 7 | | | 1 | | | 1 | | |
| 20:SV.MODE | 00H | | 11H | | | 11H | | | 31H | | | 31H | | | 00H | | | 11H | | | 11H | | | 31H | | | 31H | | |
| 21:SV. | 00H | | 04H | | | 04H | | | 0EH | | | 0EH | | | 00H | | | 04H | | | 04H | | | 0EH | | | 0EH | | |
| 22:SV.ADJ | 60 | | 160 | | | 50 | | | 0 | | | 0 | | | 60 | | | 150 | | | 50 | | | 0 | | | 0 | | |
| 23:SPEED | 1.2 | | 4.0 | | | 3.5 | | | 4.0 | | | 4.0 | | | 1.0 | | | 3.0 | | | 3.0 | | | 4.0 | | | 4.0 | | |
| 24:SM-REF | 33H | | 33H | | | 33H | | | 11 | | | 11 | | | 33H | | | 33H | | | 33H | | | 10H | | | 10H | | |
| 25:PRG-ON | 04 | | 01H | | | 01H | | | 01H | | | 01 | | | 04 | | | 01H | | | 01H | | | 01H | | | 01 | | |
| 26:PRG0-1 | 0000H | | 0D3FH | | | 0D3FH | | | 0D3DH | | | 0D3DH | | | 0000H | | | 0D3FH | | | 0D3FH | | | 0D3DH | | | 0D3DH | | |
| 27:PRG0-2 | 00H | | 33 | | | 33 | | | 33 | | | 33 | | | 00H | | | 44H | | | 44H | | | 44H | | | 44H | | |
| 28:PRG0-3 | 00H | | A8H | | | A8H | | | A8H | | | A8H | | | 00H | | | A8H | | | A8H | | | A8H | | | A8H | | |
| 29:PRG0-4 | 00H | | BAH | | | BAH | | | BAH | | | BAH | | | 00H | | | BAH | | | BAH | | | BAH | | | BAH | | |
| 30:PRG1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 31:PRG2-1 | 70 | | 00H | | | 00H | | | 00H | | | 00H | | | 80 | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 32:PRG2-2 | 40 | | 00H | | | 00H | | | 00H | | | 00H | | | 40 | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 33:ADC-ON | 05H | | 05H | | | 01H | | | 01H | | | 01H | | | 05H | | | 05H | | | 01H | | | 01H | | | 01H | | |
| 34:ADC0-1 | 0BH | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | |
| 35:ADC0-2 | 1 | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | |
| 36:ADC1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 37:ADC1-2 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 38:ADC2-1 | 55H | | 46H | | | 00H | | | 00H | | | 00H | | | 55H | | | 46H | | | 00H | | | 00H | | | 00H | | |
| 39:ADC2-2 | 25H | | 55H | | | 00H | | | 00H | | | 00H | | | 25H | | | 55H | | | 00H | | | 00H | | | 00H | | |
| 40:FLUSHING | 6 | | 8 | | | 8 | | | 8 | | | 8 | | | 6 | | | 8 | | | 8 | | | 8 | | | 8 | | |
| 41:OVERRIDE U | 140 | | 150 | | | 150 | | | 150 | | | 150 | | | 140 | | | 200 | | | 150 | | | 150 | | | 150 | | |
| 42:OVERRIDE L | 140 | | 150 | | | 150 | | | 150 | | | 150 | | | 140 | | | 200 | | | 150 | | | 150 | | | 150 | | |
| 43:WIRE FEED | 14 | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | |
| 44:TENSION | 6 | | 7 | | | 7 | | | 7 | | | 7 | | | 6 | | | 7 | | | 7 | | | 7 | | | 7 | | |
| 45:COND. | 30 | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | |
| 46:EST.SPEED | 1.0 | | 1.4 | | | 2.3 | | | 4.0 | | | 4.0 | | | 0.8 | | | 1.2 | | | 1.5 | | | 4.0 | | | 4.0 | | |

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|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.2mm | WC | Both Away | Roughing~ finish 1.5 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 60 | | | | | | | | | | | | | | |  | | | | |
| MODEL No. | 0603110512 | | | | | | | | | | | | | | |  | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | | 5th | | |  |  |  |  |  |
| E No. | E1516 | | | E1517 | | | E1518 | | | E1519 | | | E1520 | | |  |  |  |  |  |
| H Value | V-corner | | | - | | | - | | | - | | | - | | |  |  |  |  |  |
| Offset roughing | 0.150 | | |  | | |  | | |  | | |  | | |  |  |  |  |  |
| 2nd | 0.175 | | | 0.110 | | |  | | |  | | |  | | |  |  |  |  |  |
| finish 5 | 0.182 | | | 0.117 | | | 0.107 | | |  | | |  | | |  |  |  |  |  |
| finish 2 | 0.186 | | | 0.121 | | | 0.111 | | | 0.106 | | |  | | |  |  |  |  |  |
| finish 1.5 | 0.188 | | | 0.123 | | | 0.113 | | | 0.108 | | | 0.105 | | |  |  |  |  |  |
| +1finish 5 | 0.202  - | | | 0.137  0.117 | | | -  0.107 | | | -  - | | | -  - | | |  |  |  |  |  |
| +1finish 2 | 0.206  - | | | 0.141  0.121 | | | -  0.111 | | | -  0.106 | | | -  - | | |  |  |  |  |  |
| +1finish 1.5 | 0.208  - | | | 0.143  0.123 | | | -  0.113 | | | -  0.108 | | | -  0.105 | | |  |  |  |  |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | | - | | |  |  |  |  |  |
| Low(Mpa | - | | | - | | | - | | | - | | | - | | |  |  |  |  |  |
| Removal rate  (mm/min) | 0.7  ~0.5 | | | 1.5  ~0.8 | | | 2.0  ~1.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 2~4 | | | 6~9 | | | 0~2 | | | 1~2 | | | 5~7 | | |
| Spark lump  state |  | | |  | | |  | | | Non  - | | | Non  - | | |  |  |  |  |  |
| 12 | | | 12 | | | 12 | | |
| Surface(micron) | 10 | | | 7 | | | 5 | | | 2.5 | | | 1.8 | | |  |  |  |  |  |
| 01: E No. | E1516 | | | E1517 | | | E1518 | | | E1519 | | | E1520 | | |  |  |  |  |  |
| 02:WIRE DIA. | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | | 0.200 | | |  |  |  |  |  |
| 03:MATERIAL | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | |  |  |  |  |  |
| 04:THICKNESS | 60.0 | | | 60.0 | | | 60.0 | | | 60.0 | | | 60.0 | | |  |  |  |  |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | | 3 | | |  |  |  |  |  |
| 06:ONA | 30 | | | 9 | | | 1 | | | 10 | | | 2 | | |  |  |  |  |  |
| 07:ONB | 50 | | | 9 | | | 1 | | | 10 | | | 2 | | |  |  |  |  |  |
| 08:ONC | 10 | | | 8 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |  |
| 09:OND | 12 | | | 8 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |  |
| 10:OFF | 85 | | | 60 | | | 125 | | | 100 | | | 10 | | |  |  |  |  |  |
| 11:TS | 10 | | | 10 | | | 8 | | | 5 | | | 5 | | |  |  |  |  |  |
| 12:SCT | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | |  |  |  |  |  |
| 13:RCT | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | |  |  |  |  |  |
| 14:DCHG-S | 10 | | | 10 | | | 10 | | | 15 | | | 12 | | |  |  |  |  |  |
| 15:DCHG-R | 10 | | | 10 | | | 10 | | | 15 | | | 12 | | |  |  |  |  |  |
| 16:SV | 8 | | | 8 | | | 9 | | | 14 | | | 12 | | |  |  |  |  |  |
| 17:RV | 8 | | | 8 | | | 9 | | | 14 | | | 12 | | |  |  |  |  |  |
| 18:IPM | 20 | | | 15 | | | 10 | | | 14 | | | 12 | | |  |  |  |  |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | | 1 | | |  |  |  |  |  |
| 20:SV.MODE | 00H | | | 11H | | | 11H | | | 31H | | | 31H | | |  |  |  |  |  |
| 21:SV. | 00H | | | 04H | | | 04H | | | 0EH | | | 0EH | | |  |  |  |  |  |
| 22:SV.ADJ | 60 | | | 140 | | | 40 | | | 0 | | | 0 | | |  |  |  |  |  |
| 23:SPEED | 0.8 | | | 2.5 | | | 2.5 | | | 3.0 | | | 3.0 | | |  |  |  |  |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 10H | | | 10H | | |  |  |  |  |  |
| 25:PRG-ON | 04 | | | 01H | | | 01H | | | 01H | | | 01 | | |  |  |  |  |  |
| 26:PRG0-1 | 0000H | | | 0D3FH | | | 0D3FH | | | 0D3DH | | | 0D3DH | | |  |  |  |  |  |
| 27:PRG0-2 | 00H | | | 44H | | | 44H | | | 44H | | | 44H | | |  |  |  |  |  |
| 28:PRG0-3 | 00H | | | A8H | | | A8H | | | A8H | | | A8H | | |  |  |  |  |  |
| 29:PRG0-4 | 00H | | | BAH | | | BAH | | | BAH | | | BAH | | |  |  |  |  |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |  |
| 31:PRG2-1 | 80 | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |  |
| 32:PRG2-2 | 40 | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |  |
| 33:ADC-ON | 05H | | | 05H | | | 01H | | | 01H | | | 01H | | |  |  |  |  |  |
| 34:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | |  |  |  |  |  |
| 35:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |  |
| 36:ADC1-1 | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |  |
| 37:ADC1-2 | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |  |
| 38:ADC2-1 | 55H | | | 46H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |  |
| 39:ADC2-2 | 28 | | | 55H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |  |
| 40:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | | 8 | | |  |  |  |  |  |
| 41:OVERRIDE U | 140 | | | 200 | | | 150 | | | 150 | | | 150 | | |  |  |  |  |  |
| 42:OVERRIDE L | 140 | | | 200 | | | 150 | | | 150 | | | 150 | | |  |  |  |  |  |
| 43:WIRE FEED | 16 | | | 14 | | | 14 | | | 14 | | | 14 | | |  |  |  |  |  |
| 44:TENSION | 6 | | | 7 | | | 7 | | | 7 | | | 7 | | |  |  |  |  |  |
| 45:COND. | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | |  |  |  |  |  |
| 46:EST.SPEED | 0.60 | | | 1.2 | | | 1.5 | | | 3.0 | | | 3.0 | | |  |  |  |  |  |

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BS 0.20mm

Finish

Cu

Both Away



|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
|  | |  |  | |  |  |
|  | B | TH AW | AY |  |  | |
|  | |  |  | |  |  |

|  |  |  |  |
| --- | --- | --- | --- |
|  |  |  |  |
|  | |  |
|  | |

Used V-corner for roughing

(No use G44 or G44H0)

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.20mm | Cu | Both Away | Roughing ~ +1 finish 4 |

|  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 5 | | | | | 10 | | | | |
| MODEL No. | 0602030510 | | | | | 0602040510 | | | | |
| PROCESS | 1st | 2nd | 3rd |  |  | 1st | 2nd | 3rd |  |  |
| E No. | E1634 | E1635 | E1636 |  |  | E1644 | E1645 | E1646 |  |  |
| H Value | V-corner |  |  |  |  | V-corner |  |  |  |  |
| Offset roughing | 0.142 | - | - |  |  | 0.148 | - | - |  |  |
| 2nd | 0.166 | 0.109 | - |  |  | 0.166 | 0.108 | - |  |  |
| finish 4 | 0.171 | 0.114 | 0.107 |  |  | 0.172 | 0.114 | 0.105 |  |  |
|  |  |  |  |  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |  |  |  |  |
| +1 finish 4 | 0.191 | 0.134  0.114 | -  0.107 |  |  | 0.192 | 0.134  0.114 | -  0.105 |  |  |
|  |  |  |  |  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |  |  |  |  |
| Pressure Up.(Mpa) | - | - | - |  |  | - | - | - |  |  |
| Low(Mpa | - | - | - |  |  | - | - | - |  |  |
| Removal rate  (mm/min) | 9.7  ~7.9 | 16.4  ~13.4 | 20.0 |  |  | 8.5  ~7.0 | 16.8  ~13.8 | 20.0 |  |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |
|  |  |  |  |  |  |
| 6~8 | 7~9 | 9 | 6~8 | 9~10 | 7~8 |
| Spark lump  state |  |  | NON  - |  |  |  |  | NON  - |  |  |
|  |  |  |  |
| 12 | 12 | 12 | 12 |
| Surface(micron) | 18 | 10 | 3 |  |  | 18 | 10 | 3 |  |  |
| 01: E No. | E1634 | E1635 | E1636 |  |  | E1644 | E1645 | E1646 |  |  |
| 02:WIRE DIA. | 0.200 | 0.200 | 0.200 |  |  | 0.200 | 0.200 | 0.200 |  |  |
| 03:MATERIAL | 2 | 2 | 2 |  |  | 2 | 2 | 2 |  |  |
| 04:THICKNESS | 5.0 | 5.0 | 5.0 |  |  | 10.0 | 10.0 | 10.0 |  |  |
| 05:MODE | 0 | 1 | 3 |  |  | 0 | 1 | 3 |  |  |
| 06:ONA | 19 | 2 | 3 |  |  | 23 | 3 | 3 |  |  |
| 07:ONB | 19 | 2 | 3 |  |  | 23 | 3 | 3 |  |  |
| 08:ONC | 15 | 1 | 1 |  |  | 15 | 1 | 1 |  |  |
| 09:OND | 15 | 1 | 1 |  |  | 15 | 1 | 1 |  |  |
| 10:OFF | 90 | 60 | 6 |  |  | 70 | 35 | 6 |  |  |
| 11:TS | 10 | 10 | 5 |  |  | 10 | 10 | 5 |  |  |
| 12:SCT | 100 | 100 | 200 |  |  | 100 | 100 | 200 |  |  |
| 13:RCT | 100 | 100 | 200 |  |  | 100 | 100 | 200 |  |  |
| 14:DCHG-S | 10 | 10 | 10 |  |  | 10 | 10 | 10 |  |  |
| 15:DCHG-R | 10 | 10 | 10 |  |  | 10 | 10 | 10 |  |  |
| 16:SV | 8 | 8 | 13 |  |  | 8 | 8 | 13 |  |  |
| 17:RV | 8 | 8 | 13 |  |  | 8 | 8 | 13 |  |  |
| 18:IPM | 23 | 18 | 13 |  |  | 26 | 18 | 13 |  |  |
| 19:IPS | 7 | 7 | 1 |  |  | 7 | 7 | 1 |  |  |
| 20:SV.MODE | 62H | 10H | 30H |  |  | 62H | 10H | 30H |  |  |
| 21:SV. | 5 H | 04H | 00H |  |  | 5 H | 04H | 00H |  |  |
| 22:SV.ADJ | 130 | 150 | 0 |  |  | 130 | 160 | 0 |  |  |
| 23:SPEED | 50.0 | 20.0 | 20.0 |  |  | 50.0 | 20.0 | 20.0 |  |  |
| 24:SM-REF | 33H | 33H | 12H |  |  | 33H | 33H | 12H |  |  |
| 25:PRG-ON | 04H | 01H | 01H |  |  | 04H | 01H | 01H |  |  |
| 26:PRG0-1 | 0000H | 0D3FH | 0D3DH |  |  | 0000H | 0D3FH | 0D3DH |  |  |
| 27:PRG0-2 | 00H | 55H | 55H |  |  | 00H | 55H | 55H |  |  |
| 28:PRG0-3 | 00H | AAH | AAH |  |  | 00H | AAH | AAH |  |  |
| 29:PRG0-4 | 00H | BAH | BBH |  |  | 00H | BAH | BBH |  |  |
| 30:PRG1-1 | 00H | 00H | 00H |  |  | 00H | 00H | 00H |  |  |
| 31:PRG2-1 | 10 | 0 | 0 |  |  | 20 | 0 | 0 |  |  |
| 32:PRG2-2 | 20 | 0 | 0 |  |  | 20 | 0 | 0 |  |  |
| 33:ADC-ON | 07H | 01H | 01H |  |  | 07H | 01H | 01H |  |  |
| 34:ADC0-1 | 0BH | 0BH | 0BH |  |  | 0BH | 0BH | 0BH |  |  |
| 35:ADC0-2 | 1 | 1 | 1 |  |  | 1 | 1 | 1 |  |  |
| 36:ADC1-1 | 85H | 00H | 00H |  |  | 85H | 00H | 00H |  |  |
| 37:ADC1-2 | 26H | 00H | 00H |  |  | 26H | 00H | 00H |  |  |
| 38:ADC2-1 | 6 H | 00H | 00H |  |  | 6 H | 00H | 00H |  |  |
| 39:ADC2-2 | 33H | 00H | 00H |  |  | 33H | 00H | 00H |  |  |
| 40:FLUSHING | 6 | 7 | 7 |  |  | 6 | 7 | 7 |  |  |
| 41:OVERRIDE U | 100 | 100 | 100 |  |  | 100 | 100 | 100 |  |  |
| 42:OVERRIDE L | 100 | 100 | 100 |  |  | 100 | 100 | 100 |  |  |
| 43:WIRE FEED | 12 | 14 | 14 |  |  | 12 | 14 | 14 |  |  |
| 44:TENSION | 6 | 7 | 7 |  |  | 6 | 7 | 7 |  |  |
| 45:COND. | 30 | 30 | 30 |  |  | 30 | 30 | 30 |  |  |
| 46:EST.SPEED | 8.8 | 14.9 | 20.0 |  |  | 7.7 | 15.3 | 20.0 |  |  |

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|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.20mm | Cu | Both Away | Roughing ~ +1 finish 4 |

THICKNESS(mm) 15 20

MODEL No. 0602050510 0602060510

PROCESS 1st 2nd 3rd 1st 2nd 3rd

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| E No. | | E1654 | E1655 | E1656 | E1664 | E1665 | E1666 |
| H Value |  | V-corner |  |  | V-corner |  |  |
| Offset | roughing | 0.153 | - | - | 0.153 | - | - |
|  | 2nd | 0.169 | 0.107 | - | 0.172 | 0.110 | - |
|  | finish 4 | 0.175 | 0.113 | 0.106 | 0.178 | 0.116 | 0.106 |

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| +1 finish 4 | 0.195 | 0.133 | - | 0.198 | 0.136 | - |
|  |  | 0.113 | 0.106 |  | 0.116 | 0.106 |

Pressure Up.(Mpa) - - - - - - Low(Mpa - - - - - -

Removal rate 5.8 15.1 5.7 10.2

(mm/min) ~4.8 ~12.3 20.0 ~4.7 ~8.4 15.0

Servo lump

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| state | 6~7 | 9~10 | 6 |  | 5~7 | 9~10 | 5 |
| Spark lump |  |  | NON |  |  |  | NON |
| state | 12 | 12 | - |  | 12 | 12 | - |
| Surface(micron) 20 12 4 20 12 4 | | | | | | | |

01: E No. E1654 E1655 E1656 E1664 E1665 E1666

02:WIRE DIA. 0.200 0.200 0.200 0.200 0.200 0.200

03:MATERIAL 2 2 2 2 2 2

04:THICKNESS 15.0 15.0 15.0 20.0 20.0 20.0

05:MODE 0 1 3 0 1 3

06:ONA 23 3 3 23 3 3

07:ONB 23 3 3 23 3 3

08:ONC 15 1 1 23 1 1

09:OND 15 1 1 23 1 1

10:OFF 65 35 6 65 30 6

11:TS 10 10 5 10 10 5



12:SCT 100 100 200 100 100 200

13:RCT 100 100 200 100 100 200

14:DCHG-S 10 10 10 10 10 10

15:DCHG-R 10 10 10 10 10 10

16:SV 8 8 13 8 8 13

17:RV 8 8 13 8 8 13

18:IPM 26 18 13 26 18 13

19:IPS 7 7 1 7 7 1

20:SV.MODE 62H 10H 30H 62H 10H 30H

21:SV. 5 H 04H 00H 5 H 04H 00H

22:SV.ADJ 130 130 0 120 140 0

23:SPEED 50.0 17.0 20.0 50.0 14.0 15.0

24:SM-REF 33H 33H 12H 33H 33H 12H

25:PRG-ON 04H 01H 01H 04H 01H 01H

26:PRG0-1 0000H 0D3FH 0D3DH 0000H 0D3FH 0D3DH

27:PRG0-2 00H 55H 55H 00H 55H 55H

28:PRG0-3 00H AAH AAH 00H AAH AAH

29:PRG0-4 00H BAH BBH 00H BAH BBH

30:PRG1-1 00H 00H 00H 00H 00H 00H

31:PRG2-1 30 0 0 35 0 0

32:PRG2-2 30 0 0 30 0 0

33:ADC-ON 07H 01H 01H 07H 01H 01H

34:ADC0-1 0BH 0BH 0BH 0BH 0BH 0BH

35:ADC0-2 1 1 1 1 1 1

36:ADC1-1 85H 00H 00H 85H 00H 00H

37:ADC1-2 26H 00H 00H 26H 00H 00H

38:ADC2-1 6 H 00H 00H 6 H 00H 00H

39:ADC2-2 33H 00H 00H 33H 00H 00H

40:FLUSHING 6 7 7 6 7 7

41:OVERRIDE U 100 100 100 140 100 100

42:OVERRIDE L 100 100 100 140 100 100

43:WIRE FEED 12 14 14 12 14 14

44:TENSION 6 7 7 6 7 7

45:COND. 30 30 30 30 30 30

46:EST.SPEED 5.3 13.7 20.0 5.2 9.3 15.0

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.20mm | Cu | Both Away | Roughing ~ +1 finish 4 |

THICKNESS(mm) 25 30

MODEL No. 0602070510 0602080510

PROCESS 1st 2nd 3rd 1st 2nd 3rd

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| E No. | | E1674 | E1675 | E1676 | E1684 | E1685 | E1686 |
| H Value |  | V-corner |  |  | V-corner |  |  |
| Offset | roughing | 0.158 | - | - | 0.161 | - | - |
|  | 2nd | 0.176 | 0.110 | - | 0.180 | 0.111 | - |
|  | finish 4 | 0.180 | 0.114 | 0.106 | 0.186 | 0.117 | 0.106 |

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| +1 finish 4 | 0.200 | 0.134 | - | 0.206 | 0.137 | - |
|  |  | 0.114 | 0.106 |  | 0.117 | 0.106 |

Pressure Up.(Mpa) - - - - - - Low(Mpa - - - - - -

Removal rate 4.7 9.5 4.0 7.0

(mm/min) ~3.9 ~7.7 15.0 ~3.3 ~5.9 10.0

Servo lump

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| state | 6~7 | 8~9 | 4~5 |  | 6~7 | 8~9 | 4 |
| Spark lump |  |  | NON |  |  |  | NON |
| state | 12 | 12 | - |  | 12 | 12 | - |
| Surface(micron) 20 12 4 20 12 4 | | | | | | | |

01: E No. E1674 E1675 E1676 E1684 E1685 E1686

02:WIRE DIA. 0.200 0.200 0.200 0.200 0.200 0.200

03:MATERIAL 2 2 2 2 2 2

04:THICKNESS 25.0 25.0 25.0 30.0 30.0 30.0

05:MODE 0 1 3 0 1 3

06:ONA 23 3 3 23 3 3

07:ONB 23 3 3 23 3 3

08:ONC 23 1 1 23 1 1

09:OND 23 1 1 23 1 1

10:OFF 60 30 6 60 30 6

11:TS 10 10 5 10 10 5



12:SCT 100 100 200 100 100 200

13:RCT 100 100 200 100 100 200

14:DCHG-S 10 10 10 10 10 10

15:DCHG-R 10 10 10 10 10 10

16:SV 8 8 13 8 8 13

17:RV 8 8 13 8 8 13

18:IPM 26 18 13 26 18 13

19:IPS 7 7 1 7 7 1

20:SV.MODE 62H 10H 30H 62H 10H 30H

21:SV. 5 H 04H 00H 5 H 04H 00H

22:SV.ADJ 120 110 0 120 100 0

23:SPEED 50.0 10.0 15.0 50.0 7.0 10.0

24:SM-REF 33H 33H 12H 33H 33H 12H

25:PRG-ON 04H 01H 01H 04H 01H 01H

26:PRG0-1 0000H 0D3FH 0D3DH 0000H 0D3FH 0D3DH

27:PRG0-2 00H 55H 55H 00H 55H 55H

28:PRG0-3 00H AAH AAH 00H AAH AAH

29:PRG0-4 00H BAH BBH 00H BAH BBH

30:PRG1-1 00H 00H 00H 00H 00H 00H

31:PRG2-1 40 0 0 40 0 0

32:PRG2-2 30 0 0 30 0 0

33:ADC-ON 07H 01H 01H 07H 01H 01H

34:ADC0-1 0BH 0BH 0BH 0BH 0BH 0BH

35:ADC0-2 1 1 1 1 1 1

36:ADC1-1 85H 00H 00H 85H 00H 00H

37:ADC1-2 26H 00H 00H 26H 00H 00H

38:ADC2-1 6 H 00H 00H 6 H 00H 00H

39:ADC2-2 33H 00H 00H 33H 00H 00H

40:FLUSHING 6 7 7 6 7 7

41:OVERRIDE U 140 100 100 140 100 100

42:OVERRIDE L 140 100 100 140 100 100

43:WIRE FEED 12 14 14 12 14 14

44:TENSION 6 7 7 6 7 7

45:COND. 30 30 30 30 30 30

46:EST.SPEED 4.3 8.6 15.0 3.6 6.6 10.0

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.20mm | Cu | Both Away | Roughing ~ +1 finish 4 |

THICKNESS(mm) 40 50

MODEL No. 0602090510 0602100510

PROCESS 1st 2nd 3rd 1st 2nd 3rd

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| E No. | | E1694 | E1695 | E1696 | E1704 | E1705 | E1706 |
| H Value |  | V-corner |  |  | V-corner |  |  |
| Offset | roughing | 0.164 | - | - | 0.169 | - | - |
|  | 2nd | 0.185 | 0.113 | - | 0.190 | 0.116 | - |
|  | finish 4 | 0.191 | 0.119 | 0.107 | 0.196 | 0.122 | 0.107 |

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| +1 finish 4 | 0.211 | 0.139 | - | 0.216 | 0.142 | - |
|  |  | 0.119 | 0.107 |  | 0.122 | 0.107 |

Pressure Up.(Mpa) - - - - - - Low(Mpa - - - - - -

Removal rate 2.8 4.8 2.1 3.7

(mm/min) ~2.3 ~4.0 10.0 ~1.7 ~3.1 10.0

Servo lump

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| state | 5~7 | 8~9 | 3 |  | 5~7 | 9~10 | 3 |
| Spark lump |  |  | NON |  |  |  | NON |
| state | 12 | 12 | - |  | 12 | 12 | - |
| Surface(micron) 20 12 4 20 12 4 | | | | | | | |

01: E No. E1694 E1695 E1696 E1704 E1705 E1706

02:WIRE DIA. 0.200 0.200 0.200 0.200 0.200 0.200

03:MATERIAL 2 2 2 2 2 2

04:THICKNESS 40.0 40.0 40.0 50.0 50.0 50.0

05:MODE 0 1 3 0 1 3

06:ONA 23 3 3 23 4 3

07:ONB 23 3 3 23 4 3

08:ONC 23 1 1 23 1 1

09:OND 23 1 1 23 1 1

10:OFF 60 30 6 60 30 6

11:TS 10 10 5 10 10 5



12:SCT 100 100 200 100 100 200

13:RCT 100 100 200 100 100 200

14:DCHG-S 10 10 10 10 10 13

15:DCHG-R 10 10 10 10 10 13

16:SV 8 8 13 8 8 16

17:RV 8 8 13 8 8 16

18:IPM 26 18 13 26 18 13

19:IPS 7 7 1 7 7 1

20:SV.MODE 62H 10H 30H 62H 10H 30H

21:SV. 5 H 04H 00H 5 H 04H 00H

22:SV.ADJ 120 110 0 120 120 0

23:SPEED 50.0 6.5 10.0 50.0 6.0 10.0

24:SM-REF 33H 33H 12H 33H 33H 12H

25:PRG-ON 04H 01H 01H 04H 01H 01H

26:PRG0-1 0000H 0D3FH 0D3DH 0000H 0D3FH 0D3DH

27:PRG0-2 00H 55H 55H 00H 55H 55H

28:PRG0-3 00H AAH AAH 00H AAH AAH

29:PRG0-4 00H BAH BBH 00H BAH BBH

30:PRG1-1 00H 00H 00H 00H 00H 00H

31:PRG2-1 40 0 0 45 0 0

32:PRG2-2 30 0 0 30 0 0

33:ADC-ON 07H 01H 01H 07H 01H 01H

34:ADC0-1 0BH 0BH 0BH 0BH 0BH 0BH

35:ADC0-2 1 1 1 1 1 1

36:ADC1-1 85H 00H 00H 85H 00H 00H

37:ADC1-2 26H 00H 00H 26H 00H 00H

38:ADC2-1 6 H 00H 00H 6 H 00H 00H

39:ADC2-2 33H 00H 00H 33H 00H 00H

40:FLUSHING 6 7 7 6 7 7

41:OVERRIDE U 140 100 100 140 100 150

42:OVERRIDE L 140 100 100 140 100 150

43:WIRE FEED 12 14 14 12 14 14

44:TENSION 6 7 7 6 7 7

45:COND. 30 30 30 30 30 30

46:EST.SPEED 2.5 4.4 10.0 1.9 3.4 10.0

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.20mm | Cu | Both Away | Roughing ~ +1 finish 4 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 60 | | | | | | |  | | | | |
| MODEL No. | 0602110510 | | | | | | |  | | | | |
| PROCESS | 1st | | 2nd | | 3rd |  |  |  |  |  |  |  |
| E No. | E1714 | | E1715 | | E1716 |  |  |  |  |  |  |  |
| H Value | V-corner | |  | |  |  |  |  |  |  |  |  |
| Offset roughing | 0.173 | | - | | - |  |  |  |  |  |  |  |
| 2nd | 0.193 | | 0.117 | | - |  |  |  |  |  |  |  |
| finish 4 | 0.198 | | 0.122 | | 0.106 |  |  |  |  |  |  |  |
|  |  | |  | |  |  |  |  |  |  |  |  |
|  |  | |  | |  |  |  |  |  |  |  |  |
| +1 finish 4 | 0.218 | | 0.142  0.122 | | -  0.106 |  |  |  |  |  |  |  |
|  |  | |  | |  |  |  |  |  |  |  |  |
|  |  | |  | |  |  |  |  |  |  |  |  |
| Pressure Up.(Mpa) | - | | - | | - |  |  |  |  |  |  |  |
| Low(Mpa | - | | - | | - |  |  |  |  |  |  |  |
| Removal rate  (mm/min) | 1.7  ~1.4 | | 3.0  ~2.4 | | 10.0 |  |  |  |  |  |  |  |
| Servo lump  state |  | |  | |  |  |  |  |  |  |  |  |
|  |  |  |  |  |
| 5~7 | | 9~10 | | 3 |
| Spark lump  state |  | |  | | NON |  |  |  |  |  |  |  |
| 12 | | 12 | | - |
| Surface(micron) | 20 | | 12 | | 4 |  |  |  |  |  |  |  |
| 01: E No. | E1714 | | E1715 | | E1716 |  |  |  |  |  |  |  |
| 02:WIRE DIA. | 0.200 | | 0.200 | | 0.200 |  |  |  |  |  |  |  |
| 03:MATERIAL | 2 | | 2 | | 2 |  |  |  |  |  |  |  |
| 04:THICKNESS | 60.0 | | 60.0 | | 60.0 |  |  |  |  |  |  |  |
| 05:MODE | 0 | | 1 | | 3 |  |  |  |  |  |  |  |
| 06:ONA | 23 | | 4 | | 3 |  |  |  |  |  |  |  |
| 07:ONB | 23 | | 4 | | 3 |  |  |  |  |  |  |  |
| 08:ONC | 23 | | 1 | | 1 |  |  |  |  |  |  |  |
| 09:OND | 23 | | 1 | | 1 |  |  |  |  |  |  |  |
| 10:OFF | 60 | | 30 | | 6 |  |  |  |  |  |  |  |
| 11:TS | 10 | | 10 | | 5 |  |  |  |  |  |  |  |
| 12:SCT | 100 | | 100 | | 200 |  |  |  |  |  |  |  |
| 13:RCT | 100 | | 100 | | 200 |  |  |  |  |  |  |  |
| 14:DCHG-S | 10 | | 10 | | 13 |  |  |  |  |  |  |  |
| 15:DCHG-R | 10 | | 10 | | 13 |  |  |  |  |  |  |  |
| 16:SV | 8 | | 8 | | 16 |  |  |  |  |  |  |  |
| 17:RV | 8 | | 8 | | 16 |  |  |  |  |  |  |  |
| 18:IPM | 26 | | 18 | | 13 |  |  |  |  |  |  |  |
| 19:IPS | 7 | | 7 | | 1 |  |  |  |  |  |  |  |
| 20:SV.MODE | 62H | | 10H | | 30H |  |  |  |  |  |  |  |
| 21:SV. | 5 H | | 04H | | 00H |  |  |  |  |  |  |  |
| 22:SV.ADJ | 120 | | 110 | | 0 |  |  |  |  |  |  |  |
| 23:SPEED | 50.0 | | 6.0 | | 10.0 |  |  |  |  |  |  |  |
| 24:SM-REF | 33H | | 33H | | 12H |  |  |  |  |  |  |  |
| 25:PRG-ON | 04H | | 01H | | 01H |  |  |  |  |  |  |  |
| 26:PRG0-1 | 0000H | | 0D3FH | | 0D3DH |  |  |  |  |  |  |  |
| 27:PRG0-2 | 00H | | 55H | | 55H |  |  |  |  |  |  |  |
| 28:PRG0-3 | 00H | | AAH | | AAH |  |  |  |  |  |  |  |
| 29:PRG0-4 | 00H | | BAH | | BBH |  |  |  |  |  |  |  |
| 30:PRG1-1 | 00H | | 00H | | 00H |  |  |  |  |  |  |  |
| 31:PRG2-1 | 50 | | 0 | | 0 |  |  |  |  |  |  |  |
| 32:PRG2-2 | 30 | | 0 | | 0 |  |  |  |  |  |  |  |
| 33:ADC-ON | 07H | | 01H | | 01H |  |  |  |  |  |  |  |
| 34:ADC0-1 | 0BH | | 0BH | | 0BH |  |  |  |  |  |  |  |
| 35:ADC0-2 | 1 | | 1 | | 1 |  |  |  |  |  |  |  |
| 36:ADC1-1 | 85H | | 00H | | 00H |  |  |  |  |  |  |  |
| 37:ADC1-2 | 26H | | 00H | | 00H |  |  |  |  |  |  |  |
| 38:ADC2-1 | 6 H | | 00H | | 00H |  |  |  |  |  |  |  |
| 39:ADC2-2 | 33H | | 00H | | 00H |  |  |  |  |  |  |  |
| 40:FLUSHING | 6 | | 7 | | 7 |  |  |  |  |  |  |  |
| 41:OVERRIDE U | 140 | | 100 | | 150 |  |  |  |  |  |  |  |
| 42:OVERRIDE L | 140 | | 100 | | 150 |  |  |  |  |  |  |  |
| 43:WIRE FEED | 12 | | 14 | | 14 |  |  |  |  |  |  |  |
| 44:TENSION | 6 | | 7 | | 7 |  |  |  |  |  |  |  |
| 45:COND. | 30 | | 30 | | 30 |  |  |  |  |  |  |  |
| 46:EST.SPEED | 1.5 | | 2.7 | | 10.0 |  |  |  |  |  |  |  |

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BS 0.25mm

Finish

St

Both Away



|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
|  | |  |  | |  |  |
|  | B | TH AW | AY |  |  | |
|  | |  |  | |  |  |

|  |  |  |  |
| --- | --- | --- | --- |
|  |  |  |  |
|  | |  |
|  | |

Used V-corner for roughing

(No use G44 or G44H0)

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | St | Both Away | Roughing ~ +1 finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 1 | | | | | | | | | | | | | | | 3 | | | | | | | | | | | | | | |
| MODEL No. | 0701051312 | | | | | | | | | | | | | | | 0701061312 | | | | | | | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | | 5th | | | 1st | | | 2nd | | | 3rd | | | 4th | | | 5th | | |
| E No. | E1016 | | | E1017 | | | E1018 | | | E1019 | | | E1020 | | | E1026 | | | E1027 | | | E1028 | | | E1029 | | | E1030 | | |
| H Value | V-corner | | | - | | | - | | | - | | | - | | | V-corner | | | - | | | - | | | - | | | - | | |
| Offset roughing | 0.148 | | | - | | | - | | | - | | | - | | | 0.157 | | | - | | | - | | | - | | | - | | |
| 2nd | 0.175 | | | 0.132 | | | - | | | - | | | - | | | 0.185 | | | 0.132 | | | - | | | - | | | - | | |
| finish 7 | 0.182 | | | 0.139 | | | 0.132 | | | - | | | - | | | 0.192 | | | 0.139 | | | 0.132 | | | - | | | - | | |
| finish 3 | 0.186 | | | 0.143 | | | 0.136 | | | 0.133 | | | - | | | 0.197 | | | 0.144 | | | 0.137 | | | 0.134 | | | - | | |
| finish 2 | 0.187 | | | 0.144 | | | 0.137 | | | 0.134 | | | 0.134 | | | 0.197 | | | 0.144 | | | 0.137 | | | 0.134 | | | 0.134 | | |
|  |  | | |  | | |  | | |  | | |  | | |  | | |  | | |  | | |  | | |  | | |
|  |  | | |  | | |  | | |  | | |  | | |  | | |  | | |  | | |  | | |  | | |
|  |  | | |  | | |  | | |  | | |  | | |  | | |  | | |  | | |  | | |  | | |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | |
| Low(Mpa) | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | |
| Removal rate  (mm/min) | 9.4  ~9.1 | | | 12.0  ~9.0 | | | 11.0  ~9.0 | | | 10.0 | | | 10.0 | | | 7.8  ~7.5 | | | 13.0  ~8.5 | | | 11.0  ~9.0 | | | 10.0 | | | 10.0 | | |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 6~8 | | | 7~9 | | | 3~6 | | | 3~5 | | | 3~5 | | | 5~8 | | | 7~10 | | | 2~5 | | | 3~5 | | | 3~5 | | |
| Spark lump  state |  | | |  | | | Non | | | Non  - | | | Non  - | | |  | | |  | | |  | | | Non  - | | | Non  - | | |
| 12 | | | 12 | | | - | | | 12 | | | 12 | | | 12 | | |
| Surface (micronRy) | 20 | | | 10 | | | 7 | | | 3~ | | | 2~ | | | 20 | | | 10 | | | 7 | | | 3~ | | | 2~ | | |
| 01: E No. | E1016 | | | E1017 | | | E1018 | | | E1019 | | | E1020 | | | E1026 | | | E1027 | | | E1028 | | | E1029 | | | E1030 | | |
| 02:WIRE DIA. | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | |
| 04:THICKNESS | 1.0 | | | 1.0 | | | 1.0 | | | 1.0 | | | 1.0 | | | 3.0 | | | 3.0 | | | 3.0 | | | 3.0 | | | 3.0 | | |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | | 3 | | | 0 | | | 1 | | | 1 | | | 3 | | | 3 | | |
| 06:ONA | 20 | | | 6 | | | 1 | | | 10 | | | 4 | | | 22 | | | 6 | | | 1 | | | 10 | | | 4 | | |
| 07:ONB | 20 | | | 6 | | | 1 | | | 10 | | | 4 | | | 45 | | | 6 | | | 1 | | | 10 | | | 4 | | |
| 08:ONC | 7 | | | 6 | | | 1 | | | 1 | | | 1 | | | 7 | | | 6 | | | 1 | | | 1 | | | 1 | | |
| 09:OND | 7 | | | 6 | | | 1 | | | 1 | | | 1 | | | 7 | | | 6 | | | 1 | | | 1 | | | 1 | | |
| 10:OFF | 160 | | | 120 | | | 200 | | | 100 | | | 50 | | | 160 | | | 120 | | | 200 | | | 100 | | | 50 | | |
| 11:TS | 10 | | | 10 | | | 8 | | | 5 | | | 5 | | | 10 | | | 10 | | | 8 | | | 5 | | | 5 | | |
| 12:SCT | 250 | | | 255 | | | 255 | | | 255 | | | 255 | | | 250 | | | 255 | | | 255 | | | 255 | | | 255 | | |
| 13:RCT | 250 | | | 20 | | | 50 | | | 20 | | | 20 | | | 250 | | | 20 | | | 50 | | | 20 | | | 20 | | |
| 14:DCHG-S | 12 | | | 10 | | | 10 | | | 15 | | | 15 | | | 12 | | | 10 | | | 10 | | | 15 | | | 15 | | |
| 15:DCHG-R | 12 | | | 10 | | | 10 | | | 15 | | | 15 | | | 12 | | | 10 | | | 10 | | | 15 | | | 15 | | |
| 16:SV | 10 | | | 8 | | | 8 | | | 14 | | | 14 | | | 10 | | | 8 | | | 8 | | | 14 | | | 14 | | |
| 17:RV | 10 | | | 8 | | | 8 | | | 14 | | | 14 | | | 10 | | | 8 | | | 8 | | | 14 | | | 14 | | |
| 18:IPM | 16 | | | 10 | | | 10 | | | 14 | | | 14 | | | 23 | | | 13 | | | 10 | | | 14 | | | 14 | | |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | | 1 | | | 7 | | | 7 | | | 7 | | | 1 | | | 1 | | |
| 20:SV.MODE | 41H | | | 21H | | | 21H | | | 31H | | | 31H | | | 41H | | | 21H | | | 21H | | | 31H | | | 31H | | |
| 21:SV. | 04H | | | 04H | | | 04H | | | 0EH | | | 0EH | | | 04H | | | 04H | | | 04H | | | 0EH | | | 0EH | | |
| 22:SV.ADJ | 160 | | | 200 | | | 180 | | | 0 | | | 0 | | | 160 | | | 200 | | | 180 | | | 0 | | | 0 | | |
| 23:SPEED | 12.0 | | | 16.0 | | | 11.0 | | | 10.0 | | | 10.0 | | | 8.5 | | | 14.0 | | | 11.0 | | | 10.0 | | | 10.0 | | |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 12H | | | 12H | | | 33H | | | 33H | | | 33H | | | 12H | | | 12H | | |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | | 01H | | | 01H | | | 04H | | | 01H | | | 01H | | | 01H | | | 01H | | |
| 26:PRG0-1 | 00H | | | 083FH | | | 0D3FH | | | 0D3DH | | | 0D3DH | | | 00H | | | 083FH | | | 0D3FH | | | 0D3DH | | | 0D3DH | | |
| 27:PRG0-2 | 00H | | | 3AH | | | 3AH | | | 3AH | | | 3AH | | | 00H | | | 3AH | | | 3AH | | | 3AH | | | 3AH | | |
| 28:PRG0-3 | 00H | | | A8H | | | A8H | | | A8H | | | A8H | | | 00H | | | A8H | | | A8H | | | A8H | | | A8H | | |
| 29:PRG0-4 | 00H | | | BBH | | | BBH | | | BBH | | | BBH | | | 00H | | | BBH | | | BBH | | | BBH | | | BBH | | |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 31:PRG2-1 | 10 | | | 0 | | | 0 | | | 0 | | | 0 | | | 10 | | | 0 | | | 0 | | | 0 | | | 0 | | |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | | 0 | | | 35 | | | 0 | | | 0 | | | 0 | | | 0 | | |
| 33:ADC-ON | 07H | | | 04H | | | 00H | | | 00H | | | 00H | | | 07H | | | 04H | | | 00H | | | 00H | | | 00H | | |
| 34:ADC0-1 | 0BH | | | 0BH | | | 00H | | | 00H | | | 00H | | | 0BH | | | 0BH | | | 00H | | | 00H | | | 00H | | |
| 35:ADC0-2 | 1 | | | 1 | | | 0 | | | 0 | | | 0 | | | 1 | | | 1 | | | 0 | | | 0 | | | 0 | | |
| 36:ADC1-1 | 85H | | | 00H | | | 00H | | | 00H | | | 00H | | | 85H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 37:ADC1-2 | 22H | | | 00H | | | 00H | | | 00H | | | 00H | | | 22H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 38:ADC2-1 | 85H | | | 6DH | | | 00H | | | 00H | | | 00H | | | 85H | | | 6DH | | | 00H | | | 00H | | | 00H | | |
| 39:ADC2-2 | 22H | | | 55H | | | 00H | | | 00H | | | 00H | | | 22H | | | 55H | | | 00H | | | 00H | | | 00H | | |
| 40:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | | 8 | | | 6 | | | 8 | | | 8 | | | 8 | | | 8 | | |
| 41:OVERRIDE U | 80 | | | 100 | | | 100 | | | 100 | | | 100 | | | 80 | | | 100 | | | 100 | | | 100 | | | 100 | | |
| 42:OVERRIDE L | 80 | | | 100 | | | 100 | | | 100 | | | 100 | | | 80 | | | 100 | | | 100 | | | 100 | | | 100 | | |
| 43:WIRE FEED | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | |
| 44:TENSION | 9 | | | 10 | | | 10 | | | 10 | | | 10 | | | 9 | | | 10 | | | 10 | | | 10 | | | 10 | | |
| 45:COND. | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | |
| 46:EST.SPEED | 9.3 | | | 10.0 | | | 10.0 | | | 10.0 | | | 10.0 | | | 7.7 | | | 10.0 | | | 10.0 | | | 10.0 | | | 10.0 | | |

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|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | St | Both Away | Roughing ~ +1 finish 1.5 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 5 | | | | | | | | | | | | | | | 10 | | | | | | | | | | | | | | |
| MODEL No. | 0701030527 | | | | | | | | | | | | | | | 0701040527 | | | | | | | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | | 5th | | | 1st | | | 2nd | | | 3rd | | | 4th | | | 5th | | |
| E No. | E1036 | | | E1037 | | | E1038 | | | E1039 | | | E1040 | | | E1046 | | | E1047 | | | E1048 | | | E1049 | | | E1050 | | |
| H Value | V-corner | | | - | | | - | | | - | | | - | | | V-corner | | | - | | | - | | | - | | | - | | |
| Offset roughing | 0.160 | | | - | | | - | | | - | | | - | | | 0.160 | | | - | | | - | | | - | | | - | | |
| 2nd | 0.184 | | | 0.131 | | | - | | | - | | | - | | | 0.184 | | | 0.131 | | | - | | | - | | | - | | |
| finish 7 | 0.191 | | | 0.138 | | | 0.132 | | | - | | | - | | | 0.191 | | | 0.138 | | | 0.132 | | | - | | | - | | |
| finish 3 | 0.193 | | | 0.140 | | | 0.134 | | | 0.132 | | | - | | | 0.193 | | | 0.140 | | | 0.134 | | | 0.132 | | | - | | |
| finish 1.5 | 0.195 | | | 0.142 | | | 0.136 | | | 0.134 | | | 0.134 | | | 0.195 | | | 0.142 | | | 0.136 | | | 0.134 | | | 0.134 | | |
| +1 finish 7 | 0.207 | | | 0.154  0.138 | | | 0.132 | | | - | | | -  - | | | 0.209 | | | 0.156  0.138 | | | 0.132 | | | - | | | -  - | | |
| +1 finish 3  +1 finish 1.5 | 0.209 | | | 0.156  0.140 | | | -  0.134 | | | -  0.132 | | | -  - | | | 0.211 | | | 0.158  0.140 | | | -  0.134 | | | -  0.132 | | | -  - | | |
| 0.211 | | | 0.158  0.142 | | | -  0.136 | | | -  0.134 | | | -  0.134 | | | 0.213 | | | 0.160  0.142 | | | -  0.136 | | | -  0.134 | | | -  0.134 | | |
| Pressure Up.(Mpa) | 0.10 | | | - | | | - | | | - | | | - | | | 0.10 | | | - | | | - | | | - | | | - | | |
| Low(Mpa) | 0.10 | | | - | | | - | | | - | | | - | | | 0.10 | | | - | | | - | | | - | | | - | | |
| Removal rate  (mm/min) | 7.2  ~6.0 | | | 10.0  ~8.0 | | | 11.0  ~6.0 | | | 10.0 | | | 10.0 | | | 6.0  ~5.0 | | | 9.0  ~6.0 | | | 11.0  ~6.0 | | | 10.0 | | | 10.0 | | |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 6~8 | | | 7~9 | | | 3~6 | | | 3~5 | | | 3~5 | | | 5~8 | | | 7~10 | | | 2~5 | | | 3~5 | | | 3~5 | | |
| Spark lump  state |  | | |  | | |  | | | Non  - | | | Non  - | | |  | | |  | | |  | | | Non  - | | | Non  - | | |
| 12 | | | 12 | | | - | | | 12 | | | 12 | | | 12 | | |
| Surface (micronRy) | 20 | | | 10 | | | 7 | | | 3~ | | | 1.5~ | | | 20 | | | 10 | | | 7 | | | 3~ | | | 1.5~ | | |
| 01: E No. | E1036 | | | E1037 | | | E1038 | | | E1039 | | | E1040 | | | E1046 | | | E1047 | | | E1048 | | | E1049 | | | E1050 | | |
| 02:WIRE DIA. | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | |
| 04:THICKNESS | 5.0 | | | 5.0 | | | 5.0 | | | 5.0 | | | 5.0 | | | 10.0 | | | 10.0 | | | 10.0 | | | 10.0 | | | 10.0 | | |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | | 3 | | | 0 | | | 1 | | | 1 | | | 3 | | | 3 | | |
| 06:ONA | 22 | | | 6 | | | 1 | | | 10 | | | 4 | | | 28 | | | 6 | | | 1 | | | 10 | | | 4 | | |
| 07:ONB | 45 | | | 6 | | | 1 | | | 10 | | | 4 | | | 56 | | | 6 | | | 1 | | | 10 | | | 4 | | |
| 08:ONC | 7 | | | 6 | | | 1 | | | 1 | | | 1 | | | 7 | | | 6 | | | 1 | | | 1 | | | 1 | | |
| 09:OND | 7 | | | 6 | | | 1 | | | 1 | | | 1 | | | 7 | | | 6 | | | 1 | | | 1 | | | 1 | | |
| 10:OFF | 100 | | | 100 | | | 200 | | | 100 | | | 50 | | | 90 | | | 100 | | | 150 | | | 100 | | | 50 | | |
| 11:TS | 10 | | | 10 | | | 8 | | | 5 | | | 5 | | | 10 | | | 10 | | | 8 | | | 5 | | | 5 | | |
| 12:SCT | 250 | | | 255 | | | 255 | | | 255 | | | 255 | | | 250 | | | 255 | | | 255 | | | 255 | | | 255 | | |
| 13:RCT | 250 | | | 20 | | | 50 | | | 20 | | | 20 | | | 250 | | | 20 | | | 50 | | | 20 | | | 20 | | |
| 14:DCHG-S | 7 | | | 10 | | | 10 | | | 15 | | | 15 | | | 7 | | | 10 | | | 10 | | | 15 | | | 15 | | |
| 15:DCHG-R | 7 | | | 10 | | | 10 | | | 15 | | | 15 | | | 7 | | | 10 | | | 10 | | | 15 | | | 15 | | |
| 16:SV | 10 | | | 8 | | | 8 | | | 14 | | | 14 | | | 10 | | | 8 | | | 8 | | | 14 | | | 14 | | |
| 17:RV | 10 | | | 8 | | | 8 | | | 14 | | | 14 | | | 10 | | | 8 | | | 8 | | | 14 | | | 14 | | |
| 18:IPM | 24 | | | 15 | | | 10 | | | 14 | | | 14 | | | 24 | | | 15 | | | 10 | | | 14 | | | 14 | | |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | | 1 | | | 7 | | | 7 | | | 7 | | | 1 | | | 1 | | |
| 20:SV.MODE | 41H | | | 21H | | | 21H | | | 31H | | | 31H | | | 41H | | | 21H | | | 11H | | | 31H | | | 31H | | |
| 21:SV. | 04H | | | 04H | | | 04H | | | 0EH | | | 0EH | | | 04H | | | 04H | | | 04H | | | 0EH | | | 0EH | | |
| 22:SV.ADJ | 160 | | | 200 | | | 180 | | | 0 | | | 0 | | | 130 | | | 115 | | | 150 | | | 0 | | | 0 | | |
| 23:SPEED | 8.0 | | | 13.0 | | | 11.0 | | | 10.0 | | | 10.0 | | | 6.4 | | | 12.0 | | | 12.0 | | | 10.0 | | | 10.0 | | |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 12H | | | 12H | | | 33H | | | 33H | | | 33H | | | 11H | | | 11H | | |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | | 01H | | | 01H | | | 04H | | | 01H | | | 01H | | | 01H | | | 01H | | |
| 26:PRG0-1 | 00H | | | 083FH | | | 0D3FH | | | 0D3DH | | | 0D3DH | | | 00H | | | 083FH | | | 0D3FH | | | 0D3DH | | | 0D3DH | | |
| 27:PRG0-2 | 00H | | | 3AH | | | 3AH | | | 3AH | | | 3AH | | | 00H | | | 3AH | | | 3AH | | | 3AH | | | 3AH | | |
| 28:PRG0-3 | 00H | | | A8H | | | A8H | | | A8H | | | A8H | | | 00H | | | A8H | | | A8H | | | A8H | | | A8H | | |
| 29:PRG0-4 | 00H | | | BBH | | | BBH | | | BBH | | | BBH | | | 00H | | | BBH | | | BBH | | | BBH | | | BBH | | |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 31:PRG2-1 | 10 | | | 0 | | | 0 | | | 0 | | | 0 | | | 15 | | | 0 | | | 0 | | | 0 | | | 0 | | |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | | | 0 | | | 35 | | | 0 | | | 0 | | | 0 | | | 0 | | |
| 33:ADC-ON | 05H | | | 04H | | | 00H | | | 00H | | | 00H | | | 05H | | | 04H | | | 00H | | | 00H | | | 00H | | |
| 34:ADC0-1 | 0BH | | | 0BH | | | 00H | | | 00H | | | 00H | | | 0BH | | | 0BH | | | 00H | | | 00H | | | 00H | | |
| 35:ADC0-2 | 1 | | | 1 | | | 0 | | | 0 | | | 0 | | | 1 | | | 1 | | | 0 | | | 0 | | | 0 | | |
| 36:ADC1-1 | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 37:ADC1-2 | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 38:ADC2-1 | 3FH | | | 6DH | | | 00H | | | 00H | | | 00H | | | 3FH | | | 6DH | | | 00H | | | 00H | | | 00H | | |
| 39:ADC2-2 | 25H | | | 55H | | | 00H | | | 00H | | | 00H | | | 25H | | | 55H | | | 00H | | | 00H | | | 00H | | |
| 40:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | | 8 | | | 6 | | | 8 | | | 8 | | | 8 | | | 8 | | |
| 41:OVERRIDE U | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | |
| 42:OVERRIDE L | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | | 100 | | |
| 43:WIRE FEED | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | |
| 44:TENSION | 9 | | | 10 | | | 10 | | | 10 | | | 10 | | | 9 | | | 10 | | | 10 | | | 10 | | | 10 | | |
| 45:COND. | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | |
| 46:EST.SPEED | 7.0 | | | 9.0 | | | 10.0 | | | 10.0 | | | 10.0 | | | 5.8 | | | 8.0 | | | 9.0 | | | 10.0 | | | 10.0 | | |

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Non

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | St | Both Away | Roughing ~ +1 finish 1.5 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 15 | | | | | | | | | | | | | 20 | | | | | | | | | | | | | |
| MODEL No. | 0701050527 | | | | | | | | | | | | | 0701060527 | | | | | | | | | | | | | |
| PROCESS | 1st | | | 2nd | | 3rd | | 4th | | | 5th | | | 1st | | 2nd | | | 3rd | | | 4th | | | 5th | | |
| E No. | E1056 | | | E1057 | | E1058 | | E1059 | | | E1060 | | | E1066 | | E1067 | | | E1068 | | | E1069 | | | E1070 | | |
| H Value | V-corner | | | - | | - | | - | | | - | | | V-corner | | - | | | - | | | - | | | - | | |
| Offset roughing | 0.162 | | | - | | - | | - | | | - | | | 0.163 | | **-** | | | **-** | | | **-** | | | **-** | | |
| 2nd | 0.184 | | | 0.131 | | - | | - | | | - | | | 0.187 | | 0.131 | | | - | | | - | | | - | | |
| finish 7 | 0.190 | | | 0.137 | | 0.131 | | - | | | - | | | 0.193 | | 0.137 | | | 0.131 | | | - | | | - | | |
| finish 3 | 0.192 | | | 0.139 | | 0.133 | | 0.131 | | | - | | | 0.196 | | 0.140 | | | 0.134 | | | 0.132 | | | - | | |
| finish 1.5 | 0.194 | | | 0.141 | | 0.135 | | 0.133 | | | 0.133 | | | 0.198 | | 0.142 | | | 0.136 | | | 0.134 | | | 0.134 | | |
| +1 finish 7 | 0.211 | | | 0.158  0.137 | | -  0.131 | | -  - | | | -  - | | | 0.215 | | 0.159  0.137 | | | -  0.131 | | | -  - | | | -  - | | |
| +1 finish 3  +1 finish 1.5 | 0.213 | | | 0.160  0.139 | | -  0.133 | | -  0.131 | | | -  - | | | 0.218 | | 0.162  0.140 | | | -  0.134 | | | -  0.132 | | | -  - | | |
| 0.215 | | | 0.162  0.141 | | -  0.135 | | -  0.133 | | | -  0.133 | | | 0.220 | | 0.164  0.142 | | | -  0.136 | | | -  0.134 | | | -  0.134 | | |
| Pressure Up.(Mpa) | 0.2 | | | - | | - | | - | | | - | | | 0.2 | | - | | | - | | | - | | | - | | |
| Low(Mpa) | 0.2 | | | - | | - | | - | | | - | | | 0.2 | | - | | | - | | | - | | | - | | |
| Removal rate  (mm/min) | 5.2  ~4.5 | | | 8.5  ~5.5 | | 9.0  ~7.0 | | 10.0 | | | 10.0 | | | 4.5  ~3.8 | | 8.0  ~5.0 | | | 8.0  ~5.0 | | | 10.0 | | | 9.0 | | |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 4~6 | | | 9~10 | | 2~5 | | 1~3 | | | 1~3 | | | 4~5 | | 8~10 | | | 1~3 | | | 1~2 | | | 1~3 | | |
| Spark lump  state |  | | |  | |  | | Non  - | | | Non  - | | |  | |  | | |  | | | Non  - | | | Non  - | | |
| 12 | | | 12 | | 12 | | 12 | | 12 | | | 12 | | |
| Surface (micronRy) | 20 | | | 10 | | 7 | | 3~ | | | 1.5~ | | | 20 | | 12 | | | 7 | | | 3~ | | | 1.5~ | | |
| 01: E No. | E1056 | | | E1057 | | E1058 | | E1059 | | | E1060 | | | E1066 | | E1067 | | | E1068 | | | E1069 | | | E1070 | | |
| 02:WIRE DIA. | 0.250 | | | 0.250 | | 0.250 | | 0.250 | | | 0.250 | | | 0.250 | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | |
| 03:MATERIAL | 1 | | | 1 | | 1 | | 1 | | | 1 | | | 1 | | 1 | | | 1 | | | 1 | | | 1 | | |
| 04:THICKNESS | 15.0 | | | 15.0 | | 15.0 | | 15.0 | | | 15.0 | | | 20.0 | | 20.0 | | | 20.0 | | | 20.0 | | | 20.0 | | |
| 05:MODE | 0 | | | 1 | | 1 | | 3 | | | 3 | | | 0 | | 1 | | | 1 | | | 3 | | | 3 | | |
| 06:ONA | 30 | | | 6 | | 1 | | 10 | | | 4 | | | 33 | | 8 | | | 1 | | | 10 | | | 4 | | |
| 07:ONB | 60 | | | 6 | | 1 | | 10 | | | 4 | | | 66 | | 8 | | | 1 | | | 10 | | | 4 | | |
| 08:ONC | 7 | | | 6 | | 1 | | 1 | | | 1 | | | 7 | | 8 | | | 1 | | | 1 | | | 1 | | |
| 09:OND | 7 | | | 6 | | 1 | | 1 | | | 1 | | | 7 | | 8 | | | 1 | | | 1 | | | 1 | | |
| 10:OFF | 85 | | | 80 | | 140 | | 100 | | | 50 | | | 85 | | 60 | | | 140 | | | 100 | | | 40 | | |
| 11:TS | 10 | | | 10 | | 8 | | 5 | | | 5 | | | 10 | | 10 | | | 8 | | | 5 | | | 5 | | |
| 12:SCT | 250 | | | 255 | | 255 | | 255 | | | 255 | | | 250 | | 255 | | | 255 | | | 255 | | | 255 | | |
| 13:RCT | 250 | | | 20 | | 50 | | 20 | | | 20 | | | 250 | | 20 | | | 50 | | | 20 | | | 20 | | |
| 14:DCHG-S | 7 | | | 10 | | 10 | | 15 | | | 15 | | | 7 | | 10 | | | 10 | | | 15 | | | 15 | | |
| 15:DCHG-R | 7 | | | 10 | | 10 | | 15 | | | 15 | | | 7 | | 10 | | | 10 | | | 15 | | | 15 | | |
| 16:SV | 10 | | | 8 | | 8 | | 14 | | | 14 | | | 10 | | 8 | | | 8 | | | 14 | | | 14 | | |
| 17:RV | 10 | | | 8 | | 8 | | 14 | | | 14 | | | 10 | | 8 | | | 8 | | | 14 | | | 14 | | |
| 18:IPM | 24 | | | 15 | | 10 | | 14 | | | 14 | | | 24 | | 15 | | | 10 | | | 14 | | | 14 | | |
| 19:IPS | 7 | | | 7 | | 7 | | 1 | | | 1 | | | 7 | | 7 | | | 7 | | | 1 | | | 1 | | |
| 20:SV.MODE | 41H | | | 11H | | 11H | | 31H | | | 31H | | | 41H | | 11H | | | 11H | | | 31H | | | 31H | | |
| 21:SV. | 04H | | | 04H | | 04H | | 0EH | | | 0EH | | | 04H | | 04H | | | 04H | | | 0EH | | | 0EH | | |
| 22:SV.ADJ | 100 | | | 190 | | 100 | | 0 | | | 0 | | | 90 | | 190 | | | 90 | | | 0 | | | 0 | | |
| 23:SPEED | 5.5 | | | 11.0 | | 12.0 | | 10.0 | | | 10.0 | | | 4.9 | | 10.0 | | | 12.0 | | | 10.0 | | | 9.0 | | |
| 24:SM-REF | 33H | | | 33H | | 33H | | 11H | | | 11H | | | 33H | | 33H | | | 33H | | | 11H | | | 11H | | |
| 25:PRG-ON | 04H | | | 01H | | 01H | | 01H | | | 01H | | | 04H | | 01H | | | 01H | | | 01H | | | 01H | | |
| 26:PRG0-1 | 00H | | | 083FH | | 0D3FH | | 0D3DH | | | 0D3DH | | | 00H | | 0C3FH | | | 0D3FH | | | 0D3DH | | | 0D3DH | | |
| 27:PRG0-2 | 00H | | | 3AH | | 3AH | | 3AH | | | 3AH | | | 00H | | 3AH | | | 3AH | | | 3AH | | | 3AH | | |
| 28:PRG0-3 | 00H | | | A8H | | A8H | | A8H | | | A8H | | | 00H | | A8H | | | A8H | | | A8H | | | A8H | | |
| 29:PRG0-4 | 00H | | | BBH | | BBH | | BBH | | | BBH | | | 00H | | BBH | | | BBH | | | BBH | | | BBH | | |
| 30:PRG1-1 | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | |
| 31:PRG2-1 | 20 | | | 0 | | 0 | | 0 | | | 0 | | | 30 | | 0 | | | 0 | | | 0 | | | 0 | | |
| 32:PRG2-2 | 35 | | | 0 | | 0 | | 0 | | | 0 | | | 35 | | 0 | | | 0 | | | 0 | | | 0 | | |
| 33:ADC-ON | 05H | | | 04H | | 00H | | 00H | | | 00H | | | 05H | | 04H | | | 00H | | | 00H | | | 00H | | |
| 34:ADC0-1 | 0BH | | | 0BH | | 00H | | 00H | | | 00H | | | 0BH | | 0BH | | | 00H | | | 00H | | | 00H | | |
| 35:ADC0-2 | 1 | | | 1 | | 0 | | 0 | | | 0 | | | 1 | | 1 | | | 0 | | | 0 | | | 0 | | |
| 36:ADC1-1 | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | |
| 37:ADC1-2 | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | |
| 38:ADC2-1 | 2FH | | | 6DH | | 00H | | 00H | | | 00H | | | 2FH | | 6DH | | | 00H | | | 00H | | | 00H | | |
| 39:ADC2-2 | 25H | | | 55H | | 00H | | 00H | | | 00H | | | 25H | | 55H | | | 00H | | | 00H | | | 00H | | |
| 40:FLUSHING | 6 | | | 8 | | 8 | | 8 | | | 8 | | | 6 | | 8 | | | 8 | | | 8 | | | 8 | | |
| 41:OVERRIDE U | 140 | | | 100 | | 100 | | 100 | | | 100 | | | 140 | | 100 | | | 100 | | | 100 | | | 100 | | |
| 42:OVERRIDE L | 140 | | | 100 | | 100 | | 100 | | | 100 | | | 140 | | 100 | | | 100 | | | 100 | | | 100 | | |
| 43:WIRE FEED | 14 | | | 14 | | 14 | | 14 | | | 14 | | | 14 | | 14 | | | 14 | | | 14 | | | 14 | | |
| 44:TENSION | 9 | | | 10 | | 10 | | 10 | | | 10 | | | 9 | | 10 | | | 10 | | | 10 | | | 10 | | |
| 45:COND. | 30 | | | 30 | | 30 | | 30 | | | 30 | | | 30 | | 30 | | | 30 | | | 30 | | | 30 | | |
| 46:EST.SPEED | 5.0 | | | 8.0 | | 8.0 | | 10.0 | | | 10.0 | | | 4.4 | | 7.0 | | | 8.0 | | | 10.0 | | | 9.0 | | |

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|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | St | Both Away | Roughing ~ +1 finish 1.5 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 25 | | | | | | | | | | | | | 30 | | | | | | | | | | | | |
| MODEL No. | 0701070527 | | | | | | | | | | | | | 0701080527 | | | | | | | | | | | | |
| PROCESS | 1st | | 2nd | | | 3rd | | | 4th | | 5th | | | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | |
| E No. | E1076 | | E1077 | | | E1078 | | | E1079 | | E1080 | | | E1086 | | | E1087 | | | E1088 | | | E1089 | | E1090 | |
| H Value | V-corner | | - | | | - | | | - | | - | | | V-corner | | | - | | | - | | | - | | - | |
| Offset roughing | 0.166 | | - | | | - | | | - | | - | | | 0.169 | | | - | | | - | | | - | | - | |
| 2nd | 0.191 | | 0.131 | | | - | | | - | | - | | | 0.195 | | | 0.131 | | | - | | | - | | - | |
| finish 7 | 0.197 | | 0.137 | | | 0.131 | | | - | | - | | | 0.202 | | | 0.138 | | | 0.131 | | | - | | - | |
| finish 3 | 0.199 | | 0.139 | | | 0.133 | | | 0.131 | | - | | | 0.204 | | | 0.140 | | | 0.133 | | | 0.131 | | - | |
| finish 1.5 | 0.201 | | 0.141 | | | 0.135 | | | 0.133 | | 0.133 | | | 0.206 | | | 0.142 | | | 0.135 | | | 0.133 | | 0.133 | |
| +1 finish 7 | 0.220 | | 0.160  0.137 | | | -  0.131 | | | -  - | | -  - | | | 0.226 | | | 0.162  0.138 | | | -  0.131 | | | -  - | | -  - | |
| +1 finish 3  +1 finish 1.5 | 0.222 | | 0.162  0.139 | | | -  0.133 | | | -  0.131 | | -  - | | | 0.228 | | | 0.164  0.140 | | | -  0.133 | | | -  0.131 | | -  - | |
| 0.224 | | 0.164  0.141 | | | -  0.135 | | | -  0.133 | | -  0.133 | | | 0.230 | | | 0.166  0.142 | | | -  0.135 | | | -  0.133 | | -  0.133 | |
| Pressure Up.(Mpa) | 0.2 | | - | | | - | | | - | | - | | | 0.2 | | | - | | | - | | | - | | - | |
| Low(Mpa) | 0.2 | | - | | | - | | | - | | - | | | 0.2 | | | - | | | - | | | - | | - | |
| Removal rate  (mm/min) | 3.8  ~3.0 | | 6.0  ~4.0 | | | 9.0  ~5.0 | | | 9.0 | | 8.0 | | | 3.3  ~2.8 | | | 6.0  ~3.5 | | | 9.0  ~5.0 | | | 9.0 | | 8.0 | |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 4~5 | | 8~10 | | | 1~3 | | | 1~2 | | 1~3 | | | 2~4 | | | 8~10 | | | 1~3 | | | 1~2 | | 1~2 | |
| Spark lump  state |  | |  | | |  | | | Non  - | | Non  - | | |  | | |  | | |  | | | Non  - | | Non  - | |
| 12 | | 12 | | | 12 | | | 12 | | | 12 | | | 12 | | |
| Surface (micronRy) | 20 | | 12 | | | 7 | | | 3~ | | 1.5~ | | | 20 | | | 12 | | | 7 | | | 3~ | | 1.5~ | |
| 01: E No. | E1076 | | E1077 | | | E1078 | | | E1079 | | E1080 | | | E1086 | | | E1087 | | | E1088 | | | E1089 | | E1090 | |
| 02:WIRE DIA. | 0.250 | | 0.250 | | | 0.250 | | | 0.250 | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | 0.250 | |
| 03:MATERIAL | 1 | | 1 | | | 1 | | | 1 | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | 1 | |
| 04:THICKNESS | 25.0 | | 25.0 | | | 25.0 | | | 25.0 | | 25.0 | | | 30.0 | | | 30.0 | | | 30.0 | | | 30.0 | | 30.0 | |
| 05:MODE | 0 | | 1 | | | 1 | | | 3 | | 3 | | | 0 | | | 1 | | | 1 | | | 3 | | 3 | |
| 06:ONA | 35 | | 8 | | | 1 | | | 10 | | 4 | | | 38 | | | 8 | | | 1 | | | 10 | | 4 | |
| 07:ONB | 68 | | 8 | | | 1 | | | 10 | | 4 | | | 70 | | | 8 | | | 1 | | | 10 | | 4 | |
| 08:ONC | 7 | | 8 | | | 1 | | | 1 | | 1 | | | 7 | | | 8 | | | 1 | | | 1 | | 1 | |
| 09:OND | 7 | | 8 | | | 1 | | | 1 | | 1 | | | 7 | | | 8 | | | 1 | | | 1 | | 1 | |
| 10:OFF | 85 | | 60 | | | 140 | | | 100 | | 40 | | | 85 | | | 60 | | | 140 | | | 100 | | 40 | |
| 11:TS | 10 | | 10 | | | 8 | | | 5 | | 5 | | | 10 | | | 10 | | | 8 | | | 5 | | 5 | |
| 12:SCT | 250 | | 255 | | | 255 | | | 255 | | 255 | | | 250 | | | 255 | | | 255 | | | 255 | | 255 | |
| 13:RCT | 250 | | 20 | | | 50 | | | 20 | | 20 | | | 250 | | | 20 | | | 50 | | | 20 | | 20 | |
| 14:DCHG-S | 7 | | 10 | | | 10 | | | 15 | | 15 | | | 7 | | | 10 | | | 10 | | | 15 | | 15 | |
| 15:DCHG-R | 7 | | 10 | | | 10 | | | 15 | | 15 | | | 7 | | | 10 | | | 10 | | | 15 | | 15 | |
| 16:SV | 10 | | 8 | | | 8 | | | 14 | | 14 | | | 10 | | | 8 | | | 8 | | | 14 | | 14 | |
| 17:RV | 10 | | 8 | | | 8 | | | 14 | | 14 | | | 10 | | | 8 | | | 8 | | | 14 | | 14 | |
| 18:IPM | 24 | | 15 | | | 10 | | | 14 | | 14 | | | 24 | | | 15 | | | 10 | | | 14 | | 14 | |
| 19:IPS | 7 | | 7 | | | 7 | | | 1 | | 1 | | | 7 | | | 7 | | | 7 | | | 1 | | 1 | |
| 20:SV.MODE | 41H | | 11H | | | 11H | | | 31H | | 31H | | | 41H | | | 11H | | | 11H | | | 31H | | 31H | |
| 21:SV. | 04H | | 04H | | | 04H | | | 0EH | | 0EH | | | 04H | | | 04H | | | 04H | | | 0EH | | 0EH | |
| 22:SV.ADJ | 85 | | 170 | | | 70 | | | 0 | | 0 | | | 80 | | | 150 | | | 50 | | | 0 | | 0 | |
| 23:SPEED | 4.1 | | 8.0 | | | 11.0 | | | 9.0 | | 8.0 | | | 3.6 | | | 7.6 | | | 11.0 | | | 9.0 | | 8.0 | |
| 24:SM-REF | 33H | | 33H | | | 33H | | | 11H | | 11H | | | 33H | | | 33H | | | 33H | | | 11H | | 11H | |
| 25:PRG-ON | 04H | | 01H | | | 01H | | | 01H | | 01H | | | 04H | | | 01H | | | 01H | | | 01H | | 01H | |
| 26:PRG0-1 | 00H | | 0C3FH | | | 0D3FH | | | 0D3DH | | 0D3DH | | | 00H | | | 0C3FH | | | 0D3FH | | | 0D3DH | | 0D3DH | |
| 27:PRG0-2 | 00H | | 3AH | | | 3AH | | | 3AH | | 3AH | | | 00H | | | 3AH | | | 3AH | | | 3AH | | 3AH | |
| 28:PRG0-3 | 00H | | A8H | | | A8H | | | A8H | | A8H | | | 00H | | | A8H | | | A8H | | | A8H | | A8H | |
| 29:PRG0-4 | 00H | | BBH | | | BBH | | | BBH | | BBH | | | 00H | | | BBH | | | BBH | | | BBH | | BBH | |
| 30:PRG1-1 | 00H | | 00H | | | 00H | | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | 00H | |
| 31:PRG2-1 | 35 | | 0 | | | 0 | | | 0 | | 0 | | | 35 | | | 0 | | | 0 | | | 0 | | 0 | |
| 32:PRG2-2 | 35 | | 0 | | | 0 | | | 0 | | 0 | | | 35 | | | 0 | | | 0 | | | 0 | | 0 | |
| 33:ADC-ON | 05H | | 04H | | | 00H | | | 00H | | 00H | | | 05H | | | 04H | | | 00H | | | 00H | | 00H | |
| 34:ADC0-1 | 0BH | | 0BH | | | 00H | | | 00H | | 00H | | | 0BH | | | 0BH | | | 00H | | | 00H | | 00H | |
| 35:ADC0-2 | 1 | | 1 | | | 0 | | | 0 | | 0 | | | 1 | | | 1 | | | 0 | | | 0 | | 0 | |
| 36:ADC1-1 | 00H | | 00H | | | 00H | | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | 00H | |
| 37:ADC1-2 | 00H | | 00H | | | 00H | | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | 00H | |
| 38:ADC2-1 | 2FH | | 6DH | | | 00H | | | 00H | | 00H | | | 2FH | | | 6DH | | | 00H | | | 00H | | 00H | |
| 39:ADC2-2 | 25H | | 55H | | | 00H | | | 00H | | 00H | | | 25H | | | 55H | | | 00H | | | 00H | | 00H | |
| 40:FLUSHING | 6 | | 8 | | | 8 | | | 8 | | 8 | | | 6 | | | 8 | | | 8 | | | 8 | | 8 | |
| 41:OVERRIDE U | 140 | | 100 | | | 100 | | | 100 | | 100 | | | 140 | | | 100 | | | 100 | | | 100 | | 100 | |
| 42:OVERRIDE L | 140 | | 100 | | | 100 | | | 100 | | 100 | | | 140 | | | 100 | | | 100 | | | 100 | | 100 | |
| 43:WIRE FEED | 14 | | 14 | | | 14 | | | 14 | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | 14 | |
| 44:TENSION | 9 | | 10 | | | 10 | | | 10 | | 10 | | | 9 | | | 10 | | | 10 | | | 10 | | 10 | |
| 45:COND. | 30 | | 30 | | | 30 | | | 30 | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | 30 | |
| 46:EST.SPEED | 3.7 | | 5.6 | | | 7.0 | | | 9.0 | | 8.0 | | | 3.2 | | | 5.0 | | | 6.5 | | | 9.0 | | 8.0 | |

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|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | St | Both Away | Roughing ~ +1 finish 2 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 40 | | | | | | | | | | | | | 50 | | | | | | | | | | |
| MODEL No. | 0701090527 | | | | | | | | | | | | | 0701100527 | | | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | 4th | | 5th | | | 1st | | | 2nd | | | 3rd | | | 4th | 5th |
| E No. | E1096 | | | E1097 | | | E1098 | | E1099 | | E1100 | | | E1106 | | | E1107 | | | E1108 | | | E1109 | E1110 |
| H Value | V-corner | | | - | | | - | | - | | - | | | V-corner | | | - | | | - | | | - | - |
| Offset roughing | 0.172 | | | - | | | - | | - | | - | | | 0.176 | | | - | | | - | | | - | - |
| 2nd | 0.201 | | | 0.133 | | | - | | - | | - | | | 0.206 | | | 0.133 | | | - | | | - | - |
| finish 7 | 0.206 | | | 0.138 | | | 0.131 | | - | | - | | | 0.211 | | | 0.138 | | | 0.131 | | | - | - |
| finish 4 | 0.208 | | | 0.140 | | | 0.133 | | 0.131 | | - | | | 0.213 | | | 0.140 | | | 0.133 | | | 0.131 | - |
| finish 2 | 0.210 | | | 0.142 | | | 0.135 | | 0.133 | | 0.133 | | | 0.215 | | | 0.142 | | | 0.135 | | | 0.133 | 0.133 |
| +1 finish 7 | 0.231 | | | 0.163  0.138 | | | -  0.131 | | -  - | | -  - | | | 0.238 | | | 0.165  0.138 | | | -  0.131 | | | -  - | -  - |
| +1 finish 4  +1 finish 2 | 0.233 | | | 0.165  0.140 | | | -  0.133 | | -  0.131 | | -  - | | | 0.240 | | | 0.167  0.140 | | | -  0.133 | | | -  0.131 | -  - |
| 0.235 | | | 0.167  0.142 | | | -  0.135 | | -  0.133 | | -  0.133 | | | 0.242 | | | 0.169  0.142 | | | -  0.135 | | | -  0.133 | -  0.133 |
| Pressure Up.(Mpa) | 0.2 | | | - | | | - | | - | | - | | | 0.2 | | | - | | | - | | | - | - |
| Low(Mpa) | 0.2 | | | - | | | - | | - | | - | | | 0.2 | | | - | | | - | | | - | - |
| Removal rate  (mm/min) | 2.5  ~2.0 | | | 4.5  ~3.0 | | | 8.0  ~4.0 | | 8.0 | | 7.0 | | | 2.0  ~1.6 | | | 3.5  ~2.0 | | | 6.0  ~3.0 | | | 7.0 | 6.0 |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 4~6 | | | 8~10 | | | 1~2 | | 1~2 | | 3~5 | | | 3~5 | | | 8~10 | | | 0~2 | | | 0~1 | 0~2 |
| Spark lump  state |  | | |  | | |  | | Non  - | | Non  - | | |  | | |  | | |  | | | Non  - | Non  - |
| 12 | | | 12 | | | 12 | | 12 | | | 12 | | | 12 | | |
| Surface (micronRy) | 20 | | | 12 | | | 7 | | 4~ | | 2~ | | | 20 | | | 12 | | | 7 | | | 4~ | 2~ |
| 01: E No. | E1096 | | | E1097 | | | E1098 | | E1099 | | E1100 | | | E1106 | | | E1107 | | | E1108 | | | E1109 | E1110 |
| 02:WIRE DIA. | 0.250 | | | 0.250 | | | 0.250 | | 0.250 | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | 0.250 |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | 1 | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | 1 |
| 04:THICKNESS | 40.0 | | | 40.0 | | | 40.0 | | 40.0 | | 40.0 | | | 50.0 | | | 50.0 | | | 50.0 | | | 50.0 | 50.0 |
| 05:MODE | 0 | | | 1 | | | 1 | | 3 | | 3 | | | 0 | | | 1 | | | 1 | | | 3 | 3 |
| 06:ONA | 38 | | | 8 | | | 1 | | 12 | | 5 | | | 38 | | | 8 | | | 1 | | | 12 | 5 |
| 07:ONB | 70 | | | 8 | | | 1 | | 12 | | 5 | | | 70 | | | 8 | | | 1 | | | 12 | 5 |
| 08:ONC | 7 | | | 8 | | | 1 | | 2 | | 1 | | | 7 | | | 8 | | | 1 | | | 2 | 1 |
| 09:OND | 7 | | | 8 | | | 1 | | 2 | | 1 | | | 7 | | | 8 | | | 1 | | | 2 | 1 |
| 10:OFF | 85 | | | 60 | | | 140 | | 100 | | 50 | | | 85 | | | 60 | | | 140 | | | 100 | 50 |
| 11:TS | 10 | | | 10 | | | 8 | | 5 | | 5 | | | 10 | | | 10 | | | 8 | | | 5 | 5 |
| 12:SCT | 250 | | | 255 | | | 255 | | 255 | | 255 | | | 250 | | | 255 | | | 255 | | | 255 | 255 |
| 13:RCT | 250 | | | 20 | | | 50 | | 20 | | 20 | | | 250 | | | 20 | | | 50 | | | 20 | 20 |
| 14:DCHG-S | 7 | | | 10 | | | 10 | | 15 | | 15 | | | 7 | | | 10 | | | 10 | | | 15 | 15 |
| 15:DCHG-R | 7 | | | 10 | | | 10 | | 15 | | 15 | | | 7 | | | 10 | | | 10 | | | 15 | 15 |
| 16:SV | 10 | | | 8 | | | 8 | | 14 | | 14 | | | 10 | | | 8 | | | 8 | | | 14 | 14 |
| 17:RV | 10 | | | 8 | | | 8 | | 14 | | 14 | | | 10 | | | 8 | | | 8 | | | 14 | 14 |
| 18:IPM | 24 | | | 15 | | | 10 | | 14 | | 14 | | | 24 | | | 15 | | | 10 | | | 14 | 14 |
| 19:IPS | 7 | | | 7 | | | 7 | | 1 | | 1 | | | 7 | | | 7 | | | 7 | | | 1 | 1 |
| 20:SV.MODE | 41H | | | 11H | | | 11H | | 31H | | 31H | | | 41H | | | 11H | | | 11H | | | 31H | 31H |
| 21:SV. | 04H | | | 04H | | | 04H | | 0EH | | 0EH | | | 04H | | | 04H | | | 04H | | | 0EH | 0EH |
| 22:SV.ADJ | 80 | | | 140 | | | 45 | | 0 | | 0 | | | 80 | | | 130 | | | 42 | | | 0 | 0 |
| 23:SPEED | 2.7 | | | 5.7 | | | 10.0 | | 8.0 | | 7.0 | | | 2.1 | | | 4.6 | | | 9.0 | | | 7.0 | 6.0 |
| 24:SM-REF | 33H | | | 33H | | | 33H | | 10H | | 10H | | | 33H | | | 33H | | | 33H | | | 10H | 10H |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | 01H | | 01H | | | 04H | | | 01H | | | 01H | | | 01H | 01H |
| 26:PRG0-1 | 00H | | | 0C3FH | | | 0D3FH | | 0D3DH | | 0D3DH | | | 00H | | | 0C3FH | | | 0D3FH | | | 0D3DH | 0D3DH |
| 27:PRG0-2 | 00H | | | 4AH | | | 4AH | | 4AH | | 4AH | | | 00H | | | 4AH | | | 4AH | | | 4AH | 4AH |
| 28:PRG0-3 | 00H | | | A8H | | | A8H | | A8H | | A8H | | | 00H | | | A8H | | | A8H | | | A8H | A8H |
| 29:PRG0-4 | 00H | | | BBH | | | BBH | | BBH | | BBH | | | 00H | | | BBH | | | BBH | | | BBH | BBH |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | 00H |
| 31:PRG2-1 | 40 | | | 0 | | | 0 | | 0 | | 0 | | | 40 | | | 0 | | | 0 | | | 0 | 0 |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | 0 | | 0 | | | 35 | | | 0 | | | 0 | | | 0 | 0 |
| 33:ADC-ON | 05H | | | 04H | | | 00H | | 00H | | 00H | | | 05H | | | 04H | | | 00H | | | 00H | 00H |
| 34:ADC0-1 | 0BH | | | 0BH | | | 00H | | 00H | | 00H | | | 0BH | | | 0BH | | | 00H | | | 00H | 00H |
| 35:ADC0-2 | 1 | | | 1 | | | 0 | | 0 | | 0 | | | 1 | | | 1 | | | 0 | | | 0 | 0 |
| 36:ADC1-1 | 00H | | | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | 00H |
| 37:ADC1-2 | 00H | | | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | 00H |
| 38:ADC2-1 | 2FH | | | 6DH | | | 00H | | 00H | | 00H | | | 2FH | | | 6DH | | | 00H | | | 00H | 00H |
| 39:ADC2-2 | 25H | | | 55H | | | 00H | | 00H | | 00H | | | 25H | | | 55H | | | 00H | | | 00H | 00H |
| 40:FLUSHING | 6 | | | 8 | | | 8 | | 8 | | 8 | | | 6 | | | 8 | | | 8 | | | 8 | 8 |
| 41:OVERRIDE U | 140 | | | 100 | | | 100 | | 100 | | 100 | | | 140 | | | 100 | | | 100 | | | 100 | 100 |
| 42:OVERRIDE L | 140 | | | 100 | | | 100 | | 100 | | 100 | | | 140 | | | 100 | | | 100 | | | 100 | 100 |
| 43:WIRE FEED | 14 | | | 14 | | | 14 | | 14 | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | 14 |
| 44:TENSION | 9 | | | 10 | | | 10 | | 10 | | 10 | | | 9 | | | 10 | | | 10 | | | 10 | 10 |
| 45:COND. | 30 | | | 30 | | | 30 | | 30 | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | 30 |
| 46:EST.SPEED | 2.4 | | | 4.0 | | | 5.5 | | 8.0 | | 7.0 | | | 1.9 | | | 3.0 | | | 4.5 | | | 7.0 | 6.0 |

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| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | St | Both Away | Roughing ~ +1 finish 2 |

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 60 | | | | | | | | | | |  | | | | |
| MODEL No. | 0701110527 | | | | | | | | | | |  | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | 5th |  |  |  |  |  |
| E No. | E1116 | | | E1117 | | | E1118 | | | E1119 | E1120 |  |  |  |  |  |
| H Value | V-corner | | | - | | | - | | | - | - |  |  |  |  |  |
| Offset roughing | 0.180 | | | - | | | - | | | - | - |  |  |  |  |  |
| 2nd | 0.210 | | | 0.133 | | | - | | | - | - |  |  |  |  |  |
| finish 7 | 0.216 | | | 0.140 | | | 0.132 | | | - | - |  |  |  |  |  |
| finish 4 | 0.219 | | | 0.142 | | | 0.134 | | | 0.132 | - |  |  |  |  |  |
| finish 2 | 0.221 | | | 0.144 | | | 0.136 | | | 0.134 | 0.134 |  |  |  |  |  |
| +1 finish 7 | 0.242 | | | 0.165  0.138 | | | -  0.131 | | | -  - | -  - |  |  |  |  |  |
| +1 finish 4  +1 finish 2 | 0.246 | | | 0.169  0.142 | | | -  0.134 | | | -  0.132 | -  - |  |  |  |  |  |
| 0.248 | | | 0.171  0.144 | | | -  0.136 | | | -  0.134 | -  0.134 |  |  |  |  |  |
| Pressure Up.(Mpa) | 0.2 | | | - | | | - | | | - | - |  |  |  |  |  |
| Low(Mpa) | 0.2 | | | - | | | - | | | - | - |  |  |  |  |  |
| Removal rate  (mm/min) | 1.5  ~1.0 | | | 2.5  ~1.5 | | | 5.0  ~2.0 | | | 6.0 | 5.0 |  |  |  |  |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 3~5 | | | 7~9 | | | 0~2 | | | 0~2 | 1~3 |
| Spark lump  state |  | | |  | | |  | | | Non  - | Non  - |  |  |  |  |  |
| 12 | | | 12 | | | 12 | | |
| Surface (micronRy) | 20 | | | 12 | | | 7 | | | 4~ | 2~ |  |  |  |  |  |
| 01: E No. | E1116 | | | E1117 | | | E1118 | | | E1119 | E1120 |  |  |  |  |  |
| 02:WIRE DIA. | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | 0.250 |  |  |  |  |  |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | | 1 | 1 |  |  |  |  |  |
| 04:THICKNESS | 60.0 | | | 60.0 | | | 60.0 | | | 60.0 | 60.0 |  |  |  |  |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | 3 |  |  |  |  |  |
| 06:ONA | 38 | | | 8 | | | 1 | | | 12 | 6 |  |  |  |  |  |
| 07:ONB | 70 | | | 8 | | | 1 | | | 12 | 6 |  |  |  |  |  |
| 08:ONC | 7 | | | 8 | | | 1 | | | 2 | 1 |  |  |  |  |  |
| 09:OND | 7 | | | 8 | | | 1 | | | 2 | 1 |  |  |  |  |  |
| 10:OFF | 90 | | | 60 | | | 140 | | | 100 | 50 |  |  |  |  |  |
| 11:TS | 10 | | | 10 | | | 8 | | | 5 | 5 |  |  |  |  |  |
| 12:SCT | 250 | | | 255 | | | 255 | | | 255 | 255 |  |  |  |  |  |
| 13:RCT | 250 | | | 20 | | | 50 | | | 20 | 20 |  |  |  |  |  |
| 14:DCHG-S | 7 | | | 10 | | | 10 | | | 15 | 15 |  |  |  |  |  |
| 15:DCHG-R | 7 | | | 10 | | | 10 | | | 15 | 15 |  |  |  |  |  |
| 16:SV | 10 | | | 8 | | | 8 | | | 14 | 14 |  |  |  |  |  |
| 17:RV | 10 | | | 8 | | | 8 | | | 14 | 14 |  |  |  |  |  |
| 18:IPM | 23 | | | 15 | | | 10 | | | 14 | 14 |  |  |  |  |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | 1 |  |  |  |  |  |
| 20:SV.MODE | 41H | | | 11H | | | 11H | | | 31H | 31H |  |  |  |  |  |
| 21:SV. | 04H | | | 04H | | | 04H | | | 0EH | 0EH |  |  |  |  |  |
| 22:SV.ADJ | 80 | | | 125 | | | 40 | | | 0 | 0 |  |  |  |  |  |
| 23:SPEED | 1.6 | | | 3.8 | | | 8.0 | | | 6.0 | 5.0 |  |  |  |  |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 10H | 10H |  |  |  |  |  |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | | 01H | 01H |  |  |  |  |  |
| 26:PRG0-1 | 00H | | | 0C3FH | | | 0D3FH | | | 0D3DH | 0D3DH |  |  |  |  |  |
| 27:PRG0-2 | 00H | | | 4AH | | | 4AH | | | 4AH | 4AH |  |  |  |  |  |
| 28:PRG0-3 | 00H | | | A8H | | | A8H | | | A8H | A8H |  |  |  |  |  |
| 29:PRG0-4 | 00H | | | BBH | | | BBH | | | BBH | BBH |  |  |  |  |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | 00H |  |  |  |  |  |
| 31:PRG2-1 | 35 | | | 0 | | | 0 | | | 0 | 0 |  |  |  |  |  |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | | 0 | 0 |  |  |  |  |  |
| 33:ADC-ON | 05H | | | 04H | | | 00H | | | 00H | 00H |  |  |  |  |  |
| 34:ADC0-1 | 0BH | | | 0BH | | | 00H | | | 00H | 00H |  |  |  |  |  |
| 35:ADC0-2 | 1 | | | 1 | | | 0 | | | 0 | 0 |  |  |  |  |  |
| 36:ADC1-1 | 00H | | | 00H | | | 00H | | | 00H | 00H |  |  |  |  |  |
| 37:ADC1-2 | 00H | | | 00H | | | 00H | | | 00H | 00H |  |  |  |  |  |
| 38:ADC2-1 | 2FH | | | 6DH | | | 00H | | | 00H | 00H |  |  |  |  |  |
| 39:ADC2-2 | 25H | | | 55H | | | 00H | | | 00H | 00H |  |  |  |  |  |
| 40:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | 8 |  |  |  |  |  |
| 41:OVERRIDE U | 140 | | | 100 | | | 100 | | | 100 | 100 |  |  |  |  |  |
| 42:OVERRIDE L | 140 | | | 100 | | | 100 | | | 100 | 100 |  |  |  |  |  |
| 43:WIRE FEED | 14 | | | 14 | | | 14 | | | 14 | 14 |  |  |  |  |  |
| 44:TENSION | 9 | | | 10 | | | 10 | | | 10 | 10 |  |  |  |  |  |
| 45:COND. | 30 | | | 30 | | | 30 | | | 30 | 30 |  |  |  |  |  |
| 46:EST.SPEED | 1.45 | | | 2.2 | | | 3.5 | | | 6.0 | 5.0 |  |  |  |  |  |

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| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | St | Both Away | Roughing ~ +1 finish 4 |

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 80 | | | | | | | | | | | | | 100 | | | | | | | | | | |
| MODEL No. | 0701120510 | | | | | | | | | | | | | 0701130510 | | | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | 4th | | 5th | | | 1st | | | 2nd | | | 3rd | | | 4th | 5th |
| E No. | E1126 | | | E1127 | | | E1128 | | E1129 | | E1130 | | | E1136 | | | E1137 | | | E1138 | | | E1139 | E1140 |
| H Value | V-corner | | | - | | | - | | - | | - | | | V-corner | | | - | | | - | | | - | - |
| Offset roughing | 0.183 | | | - | | | - | | - | | - | | | 0.185 | | | - | | | - | | | - | - |
| 2nd | 0.214 | | | 0.137 | | | - | | - | | - | | | 0.217 | | | 0.137 | | | - | | | - | - |
| finish 10 | 0.222 | | | 0.145 | | | 0.136 | | - | | - | | | 0.226 | | | 0.146 | | | 0.135 | | | - | - |
| finish 7 | 0.226 | | | 0.149 | | | 0.138 | | 0.133 | | - | | | 0.231 | | | 0.151 | | | 0.140 | | | 0.135 | - |
| finish 4 | 0.231 | | | 0.154 | | | 0.143 | | 0.136 | | 0.136 | | | 0.233 | | | 0.153 | | | 0.142 | | | 0.137 | 0.137 |
| +1 finish 10 | 0.251 | | | 0.174  0.145 | | | -  0.136 | | -  - | | -  - | | | 0.258 | | | 0.178  0.146 | | | -  0.135 | | | -  - | -  - |
| +1 finish 7  +1 finish 4 | 0.255 | | | 0.178  0.149 | | | -  0.,138 | | -  0.133 | | -  - | | | 0.263 | | | 0.183  0.151 | | | -  0.140 | | | -  0.135 | -  - |
| 0.260 | | | 0.183  0.154 | | | -  0.143 | | -  0.136 | | -  0.136 | | | 0.265 | | | 0.185  0.153 | | | -  0.142 | | | -  0.137 | -  0.137 |
| Pressure Up.(Mpa) | 0.2 | | | - | | | - | | - | | - | | | 0.2 | | | - | | | - | | | - | - |
| Low(Mpa) | 0.2 | | | - | | | - | | - | | - | | | 0.2 | | | - | | | - | | | - | - |
| Removal rate  (mm/min) | 0.95  ~0.7 | | | 3.5  ~2.8 | | | 10.0  ~6.0 | | 9.0 | | 9.0 | | | 0.7  ~0.5 | | | 2.8  ~2.0 | | | 8.0  ~5.0 | | | 7.0 | 7.0 |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 4~6 | | | 10~12 | | | 4~6 | | 4~6 | | 0~3 | | | 3~5 | | | 10~12 | | | 4~6 | | | 2~6 | 0~3 |
| Spark lump  state |  | | |  | | |  | |  | |  | | |  | | |  | | |  | | |  |  |
| 12 | | | 12 | | | 12 | | 12 | | 12 | | | 12 | | | 12 | | | 12 | | | 12 | 12 |
| Surface (micronRy) | 20 | | | 14 | | | 10 | | 7~ | | 4~ | | | 20 | | | 14 | | | 10 | | | 7~ | 4~ |
| 01: E No. | E1126 | | | E1127 | | | E1128 | | E1129 | | E1130 | | | E1136 | | | E1137 | | | E1138 | | | E1139 | E1140 |
| 02:WIRE DIA. | 0.250 | | | 0.250 | | | 0.250 | | 0.250 | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | 0.250 |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | 1 | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | 1 |
| 04:THICKNESS | 80.0 | | | 80.0 | | | 80.0 | | 80.0 | | 80.0 | | | 100.0 | | | 100.0 | | | 100.0 | | | 100.0 | 100.0 |
| 05:MODE | 0 | | | 0 | | | 1 | | 1 | | 2 | | | 0 | | | 0 | | | 1 | | | 1 | 2 |
| 06:ONA | 38 | | | 15 | | | 2 | | 1 | | 8 | | | 38 | | | 15 | | | 2 | | | 1 | 8 |
| 07:ONB | 70 | | | 15 | | | 2 | | 1 | | 8 | | | 70 | | | 15 | | | 2 | | | 1 | 8 |
| 08:ONC | 7 | | | 6 | | | 2 | | 1 | | 1 | | | 7 | | | 6 | | | 2 | | | 1 | 1 |
| 09:OND | 7 | | | 6 | | | 2 | | 1 | | 1 | | | 7 | | | 6 | | | 2 | | | 1 | 1 |
| 10:OFF | 110 | | | 30 | | | 55 | | 60 | | 25 | | | 110 | | | 30 | | | 50 | | | 60 | 25 |
| 11:TS | 10 | | | 10 | | | 10 | | 8 | | 8 | | | 10 | | | 10 | | | 10 | | | 8 | 8 |
| 12:SCT | 250 | | | 255 | | | 255 | | 255 | | 255 | | | 250 | | | 255 | | | 255 | | | 255 | 255 |
| 13:RCT | 250 | | | 50 | | | 50 | | 50 | | 50 | | | 250 | | | 50 | | | 50 | | | 50 | 50 |
| 14:DCHG-S | 7 | | | 10 | | | 10 | | 14 | | 20 | | | 7 | | | 10 | | | 10 | | | 14 | 20 |
| 15:DCHG-R | 7 | | | 10 | | | 10 | | 14 | | 20 | | | 7 | | | 10 | | | 10 | | | 14 | 20 |
| 16:SV | 10 | | | 8 | | | 9 | | 10 | | 16 | | | 10 | | | 8 | | | 9 | | | 10 | 16 |
| 17:RV | 10 | | | 8 | | | 9 | | 10 | | 16 | | | 10 | | | 8 | | | 9 | | | 10 | 16 |
| 18:IPM | 23 | | | 22 | | | 15 | | 12 | | 16 | | | 23 | | | 22 | | | 15 | | | 12 | 16 |
| 19:IPS | 7 | | | 7 | | | 7 | | 7 | | 8 | | | 7 | | | 7 | | | 7 | | | 7 | 8 |
| 20:SV.MODE | 41H | | | 11H | | | 11H | | 11H | | 11H | | | 41H | | | 11H | | | 11H | | | 11H | 11H |
| 21:SV. | 04H | | | 07H | | | 0EH | | 0EH | | 0EH | | | 04H | | | 07H | | | 0EH | | | 0EH | 0EH |
| 22:SV.ADJ | 80 | | | 200 | | | 40 | | 0 | | 0 | | | 80 | | | 170 | | | 30 | | | 0 | 0 |
| 23:SPEED | 1.0 | | | 4.0 | | | 10.0 | | 9.0 | | 9.0 | | | 0.73 | | | 3.3 | | | 8.0 | | | 7.0 | 7.0 |
| 24:SM-REF | 33H | | | 33H | | | 33H | | 31H | | 30H | | | 33H | | | 33H | | | 33H | | | 31H | 30H |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | 01H | | 01H | | | 04H | | | 01H | | | 01H | | | 01H | 01H |
| 26:PRG0-1 | 00H | | | 0F3AH | | | 0F3AH | | 0F3AH | | 0F3AH | | | 00H | | | 0F3AH | | | 0F3AH | | | 0F3AH | 0F3AH |
| 27:PRG0-2 | 00H | | | 11H | | | 22H | | 22H | | 22H | | | 00H | | | 11H | | | 22H | | | 22H | 22H |
| 28:PRG0-3 | 00H | | | AAH | | | AAH | | AAH | | AAH | | | 00H | | | AAH | | | AAH | | | AAH | AAH |
| 29:PRG0-4 | 00H | | | BBH | | | BBH | | BBH | | BBH | | | 00H | | | BBH | | | BBH | | | BBH | BBH |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | 00H |
| 31:PRG2-1 | 35 | | | 0 | | | 0 | | 0 | | 0 | | | 35 | | | 0 | | | 0 | | | 0 | 0 |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | 0 | | 0 | | | 35 | | | 0 | | | 0 | | | 0 | 0 |
| 33:ADC-ON | 05H | | | 04H | | | 00H | | 00H | | 00H | | | 05H | | | 04H | | | 00H | | | 00H | 00H |
| 34:ADC0-1 | 0BH | | | 0BH | | | 00H | | 00H | | 00H | | | 0BH | | | 0BH | | | 00H | | | 00H | 00H |
| 35:ADC0-2 | 1 | | | 1 | | | 0 | | 0 | | 0 | | | 1 | | | 1 | | | 0 | | | 0 | 0 |
| 36:ADC1-1 | 00H | | | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | 00H |
| 37:ADC1-2 | 00H | | | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | 00H |
| 38:ADC2-1 | 2FH | | | 6DH | | | 00H | | 00H | | 00H | | | 2FH | | | 6DH | | | 00H | | | 00H | 00H |
| 39:ADC2-2 | 25H | | | 55H | | | 00H | | 00H | | 00H | | | 25H | | | 55H | | | 00H | | | 00H | 00H |
| 40:FLUSHING | 6 | | | 8 | | | 8 | | 8 | | 8 | | | 6 | | | 8 | | | 8 | | | 8 | 8 |
| 41:OVERRIDE U | 140 | | | 120 | | | 120 | | 120 | | 120 | | | 140 | | | 120 | | | 120 | | | 120 | 120 |
| 42:OVERRIDE L | 140 | | | 120 | | | 120 | | 120 | | 120 | | | 140 | | | 120 | | | 120 | | | 120 | 120 |
| 43:WIRE FEED | 14 | | | 14 | | | 14 | | 14 | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | 14 |
| 44:TENSION | 9 | | | 10 | | | 10 | | 10 | | 10 | | | 9 | | | 10 | | | 10 | | | 10 | 10 |
| 45:COND. | 30 | | | 30 | | | 30 | | 30 | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | 30 |
| 46:EST.SPEED | 0.9 | | | 3.0 | | | 9.5 | | 9.0 | | 9.0 | | | 0.65 | | | 2.5 | | | 8.0 | | | 7.0 | 7.0 |

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| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | St | Both Away | Roughing ~ +1 finish 4 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 125 | | | | | | | | | | | | | 150 | | | | | | | | | | |
| MODEL No. | 0701140510 | | | | | | | | | | | | | 0701150510 | | | | | | | | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | 4th | | 5th | | | 1st | | | 2nd | | | 3rd | | | 4th | 5th |
| E No. | E1146 | | | E1147 | | | E1148 | | E1149 | | E1150 | | | E1156 | | | E1157 | | | E1158 | | | E1159 | E1160 |
| H Value | V-corner | | | - | | | - | | - | | - | | | V-corner | | | - | | | - | | | - | - |
| Offset roughing | 0.187 | | | - | | | - | | - | | - | | | 0.189 | | | - | | | - | | | - | - |
| 2nd | 0.222 | | | 0.140 | | | - | | - | | - | | | 0.224 | | | 0.140 | | | - | | | - | - |
| finish 10 | 0.232 | | | 0.150 | | | 0.140 | | - | | - | | | 0.234 | | | 0.150 | | | 0.140 | | | - | - |
| finish 7 | 0.235 | | | 0.153 | | | 0.143 | | 0.135 | | - | | | 0.237 | | | 0.153 | | | 0.143 | | | 0.135 | - |
| finish 4 | 0.237 | | | 0.155 | | | 0.145 | | 0.137 | | 0.137 | | | 0.239 | | | 0.155 | | | 0.145 | | | 0.137 | 0.137 |
| +1 finish 10 | 0.267 | | | 0.185  0.150 | | | -  0.140 | | -  - | | -  - | | | 0.273 | | | 0.189  0.150 | | | -  0.140 | | | -  - | -  - |
| +1 finish 7  +1 finish 4 | 0.270 | | | 0.188  0.153 | | | -  0.143 | | -  0.135 | | -  - | | | 0.276 | | | 0.192  0.153 | | | -  0.143 | | | -  0.135 | -  - |
| 0.272 | | | 0.190  0.155 | | | -  0.145 | | -  0.137 | | -  0.137 | | | 0.278 | | | 0.194  0.155 | | | -  0.145 | | | -  0.137 | -  0.137 |
| Pressure Up.(Mpa) | 0.2 | | | - | | | - | | - | | - | | | 0.2 | | | - | | | - | | | - | - |
| Low(Mpa) | 0.2 | | | - | | | - | | - | | - | | | 0.2 | | | - | | | - | | | - | - |
| Removal rate  (mm/min) | 0.46  ~0.38 | | | 2.3  ~1.5 | | | 7.0  ~5.0 | | 6.0 | | 6.0 | | | 0.34  ~0.28 | | | 1.8  ~1.3 | | | 6.0  ~4.0 | | | 5.0 | 5.0 |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 4~6 | | | 10~12 | | | 2~4 | | 1~3 | | 0~3 | | | 3~5 | | | 10~12 | | | 2~4 | | | 1~3 | 0~3 |
| Spark lump  state |  | | |  | | |  | |  | |  | | |  | | |  | | |  | | |  |  |
| 12 | | | 12 | | | 12 | | 12 | | 12 | | | 12 | | | 12 | | | 12 | | | 12 | 12 |
| Surface (micronRy) | 20 | | | 14 | | | 10 | | 7~ | | 4~ | | | 20 | | | 14 | | | 10 | | | 7~ | 4~ |
| 01: E No. | E1146 | | | E1147 | | | E1148 | | E1149 | | E1150 | | | E1156 | | | E1157 | | | E1158 | | | E1159 | E1160 |
| 02:WIRE DIA. | 0.250 | | | 0.250 | | | 0.250 | | 0.250 | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | 0.250 |
| 03:MATERIAL | 1 | | | 1 | | | 1 | | 1 | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | 1 |
| 04:THICKNESS | 125.0 | | | 125.0 | | | 125.0 | | 125.0 | | 125.0 | | | 150.0 | | | 150.0 | | | 150.0 | | | 150.0 | 150.0 |
| 05:MODE | 0 | | | 0 | | | 1 | | 1 | | 2 | | | 0 | | | 0 | | | 1 | | | 1 | 2 |
| 06:ONA | 38 | | | 15 | | | 2 | | 1 | | 8 | | | 38 | | | 15 | | | 2 | | | 1 | 8 |
| 07:ONB | 70 | | | 15 | | | 2 | | 1 | | 8 | | | 70 | | | 15 | | | 2 | | | 1 | 8 |
| 08:ONC | 7 | | | 6 | | | 2 | | 1 | | 1 | | | 7 | | | 6 | | | 2 | | | 1 | 1 |
| 09:OND | 7 | | | 6 | | | 2 | | 1 | | 1 | | | 7 | | | 6 | | | 2 | | | 1 | 1 |
| 10:OFF | 120 | | | 30 | | | 55 | | 60 | | 25 | | | 120 | | | 30 | | | 50 | | | 50 | 25 |
| 11:TS | 10 | | | 10 | | | 10 | | 8 | | 8 | | | 10 | | | 10 | | | 10 | | | 8 | 8 |
| 12:SCT | 250 | | | 255 | | | 255 | | 255 | | 255 | | | 250 | | | 255 | | | 255 | | | 255 | 255 |
| 13:RCT | 250 | | | 50 | | | 50 | | 50 | | 50 | | | 250 | | | 50 | | | 50 | | | 50 | 50 |
| 14:DCHG-S | 7 | | | 10 | | | 10 | | 14 | | 20 | | | 7 | | | 10 | | | 10 | | | 14 | 20 |
| 15:DCHG-R | 7 | | | 10 | | | 10 | | 14 | | 20 | | | 7 | | | 10 | | | 10 | | | 14 | 20 |
| 16:SV | 10 | | | 8 | | | 9 | | 10 | | 17 | | | 10 | | | 8 | | | 9 | | | 10 | 17 |
| 17:RV | 10 | | | 8 | | | 9 | | 10 | | 17 | | | 10 | | | 8 | | | 9 | | | 10 | 17 |
| 18:IPM | 22 | | | 22 | | | 15 | | 12 | | 17 | | | 21 | | | 22 | | | 15 | | | 12 | 17 |
| 19:IPS | 7 | | | 7 | | | 7 | | 7 | | 8 | | | 7 | | | 7 | | | 7 | | | 7 | 8 |
| 20:SV.MODE | 41H | | | 11H | | | 11H | | 11H | | 11H | | | 41H | | | 11H | | | 11H | | | 11H | 11H |
| 21:SV. | 04H | | | 07H | | | 0EH | | 0EH | | 0EH | | | 04H | | | 07H | | | 0EH | | | 0EH | 0EH |
| 22:SV.ADJ | 80 | | | 160 | | | 25 | | 0 | | 0 | | | 80 | | | 150 | | | 20 | | | 0 | 0 |
| 23:SPEED | 0.50 | | | 2.6 | | | 7.0 | | 6.0 | | 6.0 | | | 0.38 | | | 2.1 | | | 6.0 | | | 5.0 | 5.0 |
| 24:SM-REF | 33H | | | 33H | | | 33H | | 31H | | 30H | | | 33H | | | 33H | | | 33H | | | 31H | 30H |
| 25:PRG-ON | 04H | | | 01H | | | 01H | | 01H | | 01H | | | 04H | | | 01H | | | 01H | | | 01H | 01H |
| 26:PRG0-1 | 00H | | | 0F3AH | | | 0F3AH | | 0F3AH | | 0F3AH | | | 00H | | | 0F3AH | | | 0F3AH | | | 0F3AH | 0F3AH |
| 27:PRG0-2 | 00H | | | 11H | | | 22H | | 22H | | 22H | | | 00H | | | 11H | | | 22H | | | 22H | 22H |
| 28:PRG0-3 | 00H | | | AAH | | | AAH | | AAH | | AAH | | | 00H | | | AAH | | | AAH | | | AAH | AAH |
| 29:PRG0-4 | 00H | | | BBH | | | BBH | | BBH | | BBH | | | 00H | | | BBH | | | BBH | | | BBH | BBH |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | 00H |
| 31:PRG2-1 | 35 | | | 0 | | | 0 | | 0 | | 0 | | | 35 | | | 0 | | | 0 | | | 0 | 0 |
| 32:PRG2-2 | 35 | | | 0 | | | 0 | | 0 | | 0 | | | 35 | | | 0 | | | 0 | | | 0 | 0 |
| 33:ADC-ON | 05H | | | 04H | | | 00H | | 00H | | 00H | | | 05H | | | 04H | | | 00H | | | 00H | 00H |
| 34:ADC0-1 | 0BH | | | 0BH | | | 00H | | 00H | | 00H | | | 0BH | | | 0BH | | | 00H | | | 00H | 00H |
| 35:ADC0-2 | 1 | | | 1 | | | 0 | | 0 | | 0 | | | 1 | | | 1 | | | 0 | | | 0 | 0 |
| 36:ADC1-1 | 00H | | | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | 00H |
| 37:ADC1-2 | 00H | | | 00H | | | 00H | | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | 00H |
| 38:ADC2-1 | 2FH | | | 6DH | | | 00H | | 00H | | 00H | | | 2FH | | | 6DH | | | 00H | | | 00H | 00H |
| 39:ADC2-2 | 25H | | | 55H | | | 00H | | 00H | | 00H | | | 25H | | | 55H | | | 00H | | | 00H | 00H |
| 40:FLUSHING | 6 | | | 8 | | | 8 | | 8 | | 8 | | | 6 | | | 8 | | | 8 | | | 8 | 8 |
| 41:OVERRIDE U | 140 | | | 150 | | | 150 | | 150 | | 150 | | | 140 | | | 150 | | | 150 | | | 150 | 150 |
| 42:OVERRIDE L | 140 | | | 150 | | | 150 | | 150 | | 150 | | | 140 | | | 150 | | | 150 | | | 150 | 150 |
| 43:WIRE FEED | 16 | | | 14 | | | 14 | | 14 | | 14 | | | 16 | | | 14 | | | 14 | | | 14 | 14 |
| 44:TENSION | 9 | | | 10 | | | 10 | | 10 | | 10 | | | 9 | | | 10 | | | 10 | | | 10 | 10 |
| 45:COND. | 30 | | | 30 | | | 30 | | 30 | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | 30 |
| 46:EST.SPEED | 0.44 | | | 2.0 | | | 7.0 | | 6.0 | | 6.0 | | | 0.33 | | | 1.5 | | | 6.0 | | | 5.0 | 5.0 |

- 297 -

Non

Non

Non

Non

- 298 -

BS 0.25mm

Finish

Both Away



Use laminer nozzle(dia. 5mm)

Used V-corner for roughing

(No use G44 or G44H0)

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | WC | Both Away | Roughing~ finish 0.8 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 5 | | | | | | | | | | | | | | |  | | | |
| MODEL No. | 0703030514 | | | | | | | | | | | | | | |  | | | |
| PROCESS | 1st | | | 2nd | | | 3rd | | | 4th | | 5th | | 6th | |  |  |  |  |
| E No. | E1436 | | | E1437 | | | E1438 | | | E1439 | | E1440 | | E9\*\*\* | |  |  |  |  |
| H Value | V-corner | | | - | | | - | | | - | | - | | - | |  |  |  |  |
| Offset roughing | 0.158 | | | - | | | - | | | - | | - | | - | |  |  |  |  |
| 2nd | 0.184 | | | 0.131 | | | - | | | - | | - | | - | |  |  |  |  |
| finish 5 | 0.190 | | | 0.137 | | | 0.131 | | | - | | - | | - | |  |  |  |  |
| finish 2 | 0.195 | | | 0.142 | | | 0.136 | | | 0.131 | | - | | - | |  |  |  |  |
| finish 1 | 0.196 | | | 0.143 | | | 0.137 | | | 0.132 | | 0.130 | | - | |  |  |  |  |
| finish 0.8 | 0.196 | | | 0.143 | | | 0.137 | | | 0.132 | | 0.130 | | 0.130 | |  |  |  |  |
|  | - | | | - | | | - | | | - | | - | | - | |
|  | -  - | | | -  - | | | -  - | | | -  - | | -  - | | -  - | |  |  |  |  |
|  | -  - | | | -  - | | | -  - | | | -  - | | -  - | | -  - | |  |  |  |  |
| Pressure Up.(Mpa) | - | | | - | | | - | | | - | | - | | - | |  |  |  |  |
| Low(Mpa | - | | | - | | | - | | | - | | - | | - | |  |  |  |  |
| Removal rate  (mm/min) | 5.2  ~5.0 | | | 9.0  ~6.0 | | | 10.0  ~7.0 | | | 10.0 | | 3.0 | | 3.0 | |  |  |  |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 4~7 | | | 6~8 | | | 3~5 | | | 6~8 | | 6~8 | | 4~6 | |
| Spark lump  state |  | | |  | | |  | | | Non  - | | Non  - | | Non  - | |  |  |  |  |
| 12 | | | 12 | | | 12 | | |
| Surface(micron) | 10 | | | 7 | | | 5 | | | 1.8 | | 1 | | 0.8 | |  |  |  |  |
| 01: E No. | E1436 | | | E1437 | | | E1438 | | | E1439 | | E1440 | | E9\*\*\* | |  |  |  |  |
| 02:WIRE DIA. | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | 0.250 | | 0.250 | |  |  |  |  |
| 03:MATERIAL | 3 | | | 3 | | | 3 | | | 3 | | 3 | | 3 | |  |  |  |  |
| 04:THICKNESS | 5.0 | | | 5.0 | | | 5.0 | | | 5.0 | | 5.0 | | 5.0 | |  |  |  |  |
| 05:MODE | 0 | | | 1 | | | 1 | | | 3 | | 4 | | 4 | |  |  |  |  |
| 06:ONA | 30 | | | 6 | | | 1 | | | 2 | | 2 | | 1 | |  |  |  |  |
| 07:ONB | 50 | | | 6 | | | 1 | | | 2 | | 2 | | 1 | |  |  |  |  |
| 08:ONC | 10 | | | 6 | | | 1 | | | 1 | | 1 | | 1 | |  |  |  |  |
| 09:OND | 15 | | | 6 | | | 1 | | | 1 | | 1 | | 1 | |  |  |  |  |
| 10:OFF | 100 | | | 80 | | | 200 | | | 10 | | 4 | | 4 | |  |  |  |  |
| 11:TS | 10 | | | 10 | | | 8 | | | 5 | | 5 | | 5 | |  |  |  |  |
| 12:SCT | 100 | | | 100 | | | 100 | | | 100 | | 200 | | 200 | |  |  |  |  |
| 13:RCT | 100 | | | 100 | | | 100 | | | 100 | | 200 | | 200 | |  |  |  |  |
| 14:DCHG-S | 10 | | | 10 | | | 10 | | | 12 | | 12 | | 6 | |  |  |  |  |
| 15:DCHG-R | 10 | | | 10 | | | 10 | | | 12 | | 12 | | 6 | |  |  |  |  |
| 16:SV | 8 | | | 8 | | | 9 | | | 12 | | 12 | | 6 | |  |  |  |  |
| 17:RV | 8 | | | 8 | | | 9 | | | 12 | | 12 | | 6 | |  |  |  |  |
| 18:IPM | 20 | | | 15 | | | 10 | | | 12 | | 12 | | 6 | |  |  |  |  |
| 19:IPS | 7 | | | 7 | | | 7 | | | 1 | | 6 | | 7 | |  |  |  |  |
| 20:SV.MODE | 00H | | | 11H | | | 11H | | | 31H | | 31H | | 31H | |  |  |  |  |
| 21:SV. | 00H | | | 04H | | | 04H | | | 0EH | | 0EH | | 0EH | |  |  |  |  |
| 22:SV.ADJ | 200 | | | 250 | | | 150 | | | 0 | | 0 | | 0 | |  |  |  |  |
| 23:SPEED | 5.2 | | | 12.0 | | | 10.0 | | | 10.0 | | 3.0 | | 3.0 | |  |  |  |  |
| 24:SM-REF | 33H | | | 33H | | | 33H | | | 12H | | 12H | | 11H | |  |  |  |  |
| 25:PRG-ON | 04 | | | 01H | | | 01H | | | 01H | | 01 | | 01 | |  |  |  |  |
| 26:PRG0-1 | 0000H | | | 0C3FH | | | 0C3FH | | | 0C3FH | | 0C3DH | | 0C3DH | |  |  |  |  |
| 27:PRG0-2 | 00H | | | 33 | | | 33 | | | 33 | | 33 | | 33 | |  |  |  |  |
| 28:PRG0-3 | 00H | | | A8H | | | A8H | | | A8H | | A8H | | A8H | |  |  |  |  |
| 29:PRG0-4 | 00H | | | BAH | | | BAH | | | BAH | | BAH | | BAH | |  |  |  |  |
| 30:PRG1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | | 00H | |  |  |  |  |
| 31:PRG2-1 | 35 | | | 0 | | | 0 | | | 0 | | 0 | | 0 | |  |  |  |  |
| 32:PRG2-2 | 40 | | | 0 | | | 0 | | | 0 | | 0 | | 0 | |  |  |  |  |
| 33:ADC-ON | 05H | | | 05H | | | 01H | | | 01H | | 01H | | 01H | |  |  |  |  |
| 34:ADC0-1 | 0BH | | | 0BH | | | 0BH | | | 0BH | | 0BH | | 0BH | |  |  |  |  |
| 35:ADC0-2 | 1 | | | 1 | | | 1 | | | 1 | | 1 | | 1 | |  |  |  |  |
| 36:ADC1-1 | 00H | | | 00H | | | 00H | | | 00H | | 00H | | 00H | |  |  |  |  |
| 37:ADC1-2 | 00H | | | 00H | | | 00H | | | 00H | | 00H | | 00H | |  |  |  |  |
| 38:ADC2-1 | 55H | | | 46H | | | 00H | | | 00H | | 00H | | 00H | |  |  |  |  |
| 39:ADC2-2 | 25H | | | 55H | | | 00H | | | 00H | | 00H | | 00H | |  |  |  |  |
| 40:FLUSHING | 6 | | | 8 | | | 8 | | | 8 | | 8 | | 8 | |  |  |  |  |
| 41:OVERRIDE U | 140 | | | 125 | | | 125 | | | 125 | | 125 | | 125 | |  |  |  |  |
| 42:OVERRIDE L | 140 | | | 125 | | | 125 | | | 125 | | 125 | | 125 | |  |  |  |  |
| 43:WIRE FEED | 16 | | | 14 | | | 14 | | | 14 | | 14 | | 14 | |  |  |  |  |
| 44:TENSION | 9 | | | 10 | | | 10 | | | 10 | | 10 | | 10 | |  |  |  |  |
| 45:COND. | 30 | | | 30 | | | 30 | | | 30 | | 30 | | 30 | |  |  |  |  |
| 46:EST.SPEED | 5.1 | | | 7.5 | | | 8.0 | | | 10.0 | | 3.0 | | 3.0 | |  |  |  |  |

- 328 -

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | WC | Both Away | Roughing~ finish 0.8 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 10 | | | | | | | | | | | | | | | | |  | | | |
| MODEL No. | 0703040514 | | | | | | | | | | | | | | | | |  | | | |
| PROCESS | 1st | | 2nd | | | 3rd | | | 4th | | | 5th | | | 6th | | |  |  |  |  |
| E No. | E1446 | | E1447 | | | E1448 | | | E1449 | | | E1450 | | | E9\*\*\* | | |  |  |  |  |
| H Value | V-corner | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Offset roughing | 0.160 | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| 2nd | 0.186 | | 0.131 | | | - | | | - | | | - | | | - | | |  |  |  |  |
| finish 5 | 0.192 | | 0.137 | | | 0.131 | | | - | | | - | | | - | | |  |  |  |  |
| finish 2 | 0.197 | | 0.142 | | | 0.136 | | | 0.131 | | | - | | | - | | |  |  |  |  |
| finish 1 | 0.198 | | 0.143 | | | 0.137 | | | 0.132 | | | 0.130 | | | - | | |  |  |  |  |
| finish 0.8 | 0.198 | | 0.143 | | | 0.137 | | | 0.132 | | | 0.130 | | | 0.130 | | |  |  |  |  |
|  | - | | - | | | - | | | - | | | - | | | - | | |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |  |  |  |  |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |  |  |  |  |
| Pressure Up.(Mpa) | - | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Low(Mpa | - | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Removal rate  (mm/min) | 3.4  ~3.2 | | 6.0  ~4.0 | | | 6.0  ~4.5 | | | 6.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 3~6 | | 6~8 | | | 1~3 | | | 7~9 | | | 7~9 | | | 7~9 | | |
| Spark lump  state |  | |  | | |  | | | Non  - | | | Non  - | | | Non  - | | |  |  |  |  |
| 12 | | 12 | | | 12 | | |
| Surface(micron) | 10 | | 7 | | | 5 | | | 1.8 | | | 1 | | | 0.8 | | |  |  |  |  |
| 01: E No. | E1446 | | E1447 | | | E1448 | | | E1449 | | | E1450 | | | E9\*\*\* | | |  |  |  |  |
| 02:WIRE DIA. | 0.250 | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | |  |  |  |  |
| 03:MATERIAL | 3 | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | |  |  |  |  |
| 04:THICKNESS | 10.0 | | 10.0 | | | 10.0 | | | 10.0 | | | 10.0 | | | 10.0 | | |  |  |  |  |
| 05:MODE | 0 | | 1 | | | 1 | | | 3 | | | 4 | | | 4 | | |  |  |  |  |
| 06:ONA | 30 | | 7 | | | 1 | | | 2 | | | 2 | | | 1 | | |  |  |  |  |
| 07:ONB | 50 | | 7 | | | 1 | | | 2 | | | 2 | | | 1 | | |  |  |  |  |
| 08:ONC | 10 | | 7 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 09:OND | 15 | | 7 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 10:OFF | 100 | | 80 | | | 200 | | | 10 | | | 4 | | | 4 | | |  |  |  |  |
| 11:TS | 10 | | 10 | | | 8 | | | 5 | | | 5 | | | 5 | | |  |  |  |  |
| 12:SCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 200 | | |  |  |  |  |
| 13:RCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 200 | | |  |  |  |  |
| 14:DCHG-S | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 15:DCHG-R | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 16:SV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 17:RV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 18:IPM | 20 | | 15 | | | 10 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 19:IPS | 7 | | 7 | | | 7 | | | 1 | | | 6 | | | 7 | | |  |  |  |  |
| 20:SV.MODE | 00H | | 11H | | | 11H | | | 31H | | | 31H | | | 31H | | |  |  |  |  |
| 21:SV. | 00H | | 04H | | | 04H | | | 0EH | | | 0EH | | | 0EH | | |  |  |  |  |
| 22:SV.ADJ | 150 | | 200 | | | 100 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 23:SPEED | 3.6 | | 10.0 | | | 6.0 | | | 6.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |
| 24:SM-REF | 33H | | 33H | | | 33H | | | 11 | | | 11 | | | 10H | | |  |  |  |  |
| 25:PRG-ON | 04 | | 01H | | | 01H | | | 01H | | | 01 | | | 01 | | |  |  |  |  |
| 26:PRG0-1 | 0000H | | 0C3FH | | | 0C3FH | | | 0C3FH | | | 0C3DH | | | 0C3DH | | |  |  |  |  |
| 27:PRG0-2 | 00H | | 33 | | | 33 | | | 33 | | | 33 | | | 33 | | |  |  |  |  |
| 28:PRG0-3 | 00H | | A8H | | | A8H | | | A8H | | | A8H | | | A8H | | |  |  |  |  |
| 29:PRG0-4 | 00H | | BAH | | | BAH | | | BAH | | | BAH | | | BAH | | |  |  |  |  |
| 30:PRG1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 31:PRG2-1 | 40 | | 0 | | | 0 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 32:PRG2-2 | 50 | | 0 | | | 0 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 33:ADC-ON | 05H | | 05H | | | 01H | | | 01H | | | 01H | | | 01H | | |  |  |  |  |
| 34:ADC0-1 | 0BH | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | |  |  |  |  |
| 35:ADC0-2 | 1 | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 36:ADC1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 37:ADC1-2 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 38:ADC2-1 | 55H | | 46H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 39:ADC2-2 | 25H | | 55H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 40:FLUSHING | 6 | | 8 | | | 8 | | | 8 | | | 8 | | | 8 | | |  |  |  |  |
| 41:OVERRIDE U | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 125 | | |  |  |  |  |
| 42:OVERRIDE L | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 125 | | |  |  |  |  |
| 43:WIRE FEED | 16 | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | |  |  |  |  |
| 44:TENSION | 9 | | 10 | | | 10 | | | 10 | | | 10 | | | 10 | | |  |  |  |  |
| 45:COND. | 30 | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | |  |  |  |  |
| 46:EST.SPEED | 3.3 | | 5.0 | | | 5.25 | | | 5.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |

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| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | WC | Both Away | Roughing~ finish 0.8 |

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 15 | | | | | | | | | | | | | | | | |  | | | |
| MODEL No. | 0703050514 | | | | | | | | | | | | | | | | |  | | | |
| PROCESS | 1st | | 2nd | | | 3rd | | | 4th | | | 5th | | | 6th | | |  |  |  |  |
| E No. | E1456 | | E1457 | | | E1458 | | | E1459 | | | E1460 | | | E9\*\*\* | | |  |  |  |  |
| H Value | V-corner | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Offset roughing | 0.162 | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| 2nd | 0.189 | | 0.131 | | | - | | | - | | | - | | | - | | |  |  |  |  |
| finish 5 | 0.194 | | 0.137 | | | 0.131 | | | - | | | - | | | - | | |  |  |  |  |
| finish 2 | 0.199 | | 0.142 | | | 0.136 | | | 0.131 | | | - | | | - | | |  |  |  |  |
| finish 1 | 0.200 | | 0.143 | | | 0.137 | | | 0.132 | | | 0.130 | | | - | | |  |  |  |  |
| finish 0.8 | 0.200 | | 0.143 | | | 0.137 | | | 0.132 | | | 0.130 | | | 0.130 | | |  |  |  |  |
|  | - | | - | | | - | | | - | | | - | | | - | | |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |  |  |  |  |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |  |  |  |  |
| Pressure Up.(Mpa) | - | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Low(Mpa | - | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Removal rate  (mm/min) | 3.3  ~3.0 | | 4.5  ~3.1 | | | 5.0  ~3.8 | | | 5.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 3~5 | | 6~8 | | | 1~3 | | | 5~7 | | | 5~7 | | | 3~6 | | |
| Spark lump  state |  | |  | | |  | | | Non  - | | | Non  - | | | Non  - | | |  |  |  |  |
| 12 | | 12 | | | 12 | | |
| Surface(micron) | 10 | | 7 | | | 5 | | | 1.8 | | | 1 | | | 0.8 | | |  |  |  |  |
| 01: E No. | E1456 | | E1457 | | | E1458 | | | E1459 | | | E1460 | | | E9\*\*\* | | |  |  |  |  |
| 02:WIRE DIA. | 0.250 | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | |  |  |  |  |
| 03:MATERIAL | 3 | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | |  |  |  |  |
| 04:THICKNESS | 15.0 | | 15.0 | | | 15.0 | | | 15.0 | | | 15.0 | | | 15.0 | | |  |  |  |  |
| 05:MODE | 0 | | 1 | | | 1 | | | 3 | | | 4 | | | 4 | | |  |  |  |  |
| 06:ONA | 30 | | 7 | | | 1 | | | 2 | | | 2 | | | 1 | | |  |  |  |  |
| 07:ONB | 50 | | 7 | | | 1 | | | 2 | | | 2 | | | 1 | | |  |  |  |  |
| 08:ONC | 15 | | 7 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 09:OND | 20 | | 7 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 10:OFF | 70 | | 60 | | | 180 | | | 10 | | | 4 | | | 4 | | |  |  |  |  |
| 11:TS | 10 | | 10 | | | 8 | | | 5 | | | 5 | | | 5 | | |  |  |  |  |
| 12:SCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 200 | | |  |  |  |  |
| 13:RCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 200 | | |  |  |  |  |
| 14:DCHG-S | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 15:DCHG-R | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 16:SV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 17:RV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 18:IPM | 20 | | 15 | | | 10 | | | 12 | | | 12 | | | 6 | | |  |  |  |  |
| 19:IPS | 7 | | 7 | | | 7 | | | 1 | | | 6 | | | 7 | | |  |  |  |  |
| 20:SV.MODE | 00H | | 11H | | | 11H | | | 31H | | | 31H | | | 31H | | |  |  |  |  |
| 21:SV. | 00H | | 04H | | | 04H | | | 0EH | | | 0EH | | | 0EH | | |  |  |  |  |
| 22:SV.ADJ | 70 | | 180 | | | 70 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 23:SPEED | 3.5 | | 9.0 | | | 5.0 | | | 5.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |
| 24:SM-REF | 33H | | 33H | | | 33H | | | 11 | | | 11 | | | 10H | | |  |  |  |  |
| 25:PRG-ON | 04 | | 01H | | | 01H | | | 01H | | | 01 | | | 01 | | |  |  |  |  |
| 26:PRG0-1 | 0000H | | 0C3FH | | | 0C3FH | | | 0C3FH | | | 0C3DH | | | 0C3DH | | |  |  |  |  |
| 27:PRG0-2 | 00H | | 33 | | | 33 | | | 33 | | | 33 | | | 33 | | |  |  |  |  |
| 28:PRG0-3 | 00H | | A8H | | | A8H | | | A8H | | | A8H | | | A8H | | |  |  |  |  |
| 29:PRG0-4 | 00H | | BAH | | | BAH | | | BAH | | | BAH | | | BAH | | |  |  |  |  |
| 30:PRG1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 31:PRG2-1 | 50 | | 0 | | | 0 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 32:PRG2-2 | 55 | | 0 | | | 0 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 33:ADC-ON | 05H | | 05H | | | 01H | | | 01H | | | 01H | | | 01H | | |  |  |  |  |
| 34:ADC0-1 | 0BH | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | |  |  |  |  |
| 35:ADC0-2 | 1 | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 36:ADC1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 37:ADC1-2 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 38:ADC2-1 | 55H | | 46H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 39:ADC2-2 | 25H | | 55H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 40:FLUSHING | 6 | | 8 | | | 8 | | | 8 | | | 8 | | | 8 | | |  |  |  |  |
| 41:OVERRIDE U | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 125 | | |  |  |  |  |
| 42:OVERRIDE L | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 125 | | |  |  |  |  |
| 43:WIRE FEED | 16 | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | |  |  |  |  |
| 44:TENSION | 9 | | 10 | | | 10 | | | 10 | | | 10 | | | 10 | | |  |  |  |  |
| 45:COND. | 30 | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | |  |  |  |  |
| 46:EST.SPEED | 3.2 | | 4.0 | | | 4.5 | | | 5.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |

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| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | WC | Both Away | Roughing~ finish 0.8 |

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 20 | | | | | | | | | | | | | | | | |  | | | |
| MODEL No. | 0703060514 | | | | | | | | | | | | | | | | |  | | | |
| PROCESS | 1st | | 2nd | | | 3rd | | | 4th | | | 5th | | | 6th | | |  |  |  |  |
| E No. | E1466 | | E1467 | | | E1468 | | | E1469 | | | E1470 | | | E9\*\*\* | | |  |  |  |  |
| H Value | V-corner | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Offset roughing | 0.165 | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| 2nd | 0.192 | | 0.132 | | | - | | | - | | | - | | | - | | |  |  |  |  |
| finish 5 | 0.198 | | 0.138 | | | 0.132 | | | - | | | - | | | - | | |  |  |  |  |
| finish 2 | 0.203 | | 0.143 | | | 0.136 | | | 0.131 | | | - | | | - | | |  |  |  |  |
| finish 1 | 0.204 | | 0.144 | | | 0.137 | | | 0.132 | | | 0.130 | | | - | | |  |  |  |  |
| finish 0.8 | 0.204 | | 0.144 | | | 0.137 | | | 0.132 | | | 0.130 | | | 0.130 | | |  |  |  |  |
|  | - | | - | | | - | | | - | | | - | | | - | | |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |  |  |  |  |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |  |  |  |  |
| Pressure Up.(Mpa) | - | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Low(Mpa | - | | - | | | - | | | - | | | - | | | - | | |  |  |  |  |
| Removal rate  (mm/min) | 2.8  ~2.5 | | 3.5  ~2.0 | | | 4.8  ~3.0 | | | 5.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 3~5 | | 6~8 | | | 0~2 | | | 4~6 | | | 3~5 | | | 2~5 | | |
| Spark lump  state |  | |  | | |  | | | Non  - | | | Non  - | | | Non  - | | |  |  |  |  |
| 12 | | 12 | | | 12 | | |
| Surface(micron) | 10 | | 7 | | | 5 | | | 1.8 | | | 1 | | | 0.8 | | |  |  |  |  |
| 01: E No. | E1466 | | E1467 | | | E1468 | | | E1469 | | | E1470 | | | E9\*\*\* | | |  |  |  |  |
| 02:WIRE DIA. | 0.250 | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | |  |  |  |  |
| 03:MATERIAL | 3 | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | |  |  |  |  |
| 04:THICKNESS | 20.0 | | 20.0 | | | 20.0 | | | 20.0 | | | 20.0 | | | 20.0 | | |  |  |  |  |
| 05:MODE | 0 | | 1 | | | 1 | | | 3 | | | 4 | | | 4 | | |  |  |  |  |
| 06:ONA | 30 | | 7 | | | 1 | | | 2 | | | 2 | | | 1 | | |  |  |  |  |
| 07:ONB | 50 | | 7 | | | 1 | | | 2 | | | 2 | | | 1 | | |  |  |  |  |
| 08:ONC | 15 | | 7 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 09:OND | 20 | | 7 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 10:OFF | 60 | | 60 | | | 160 | | | 10 | | | 4 | | | 4 | | |  |  |  |  |
| 11:TS | 10 | | 10 | | | 8 | | | 5 | | | 5 | | | 5 | | |  |  |  |  |
| 12:SCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 200 | | |  |  |  |  |
| 13:RCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 200 | | |  |  |  |  |
| 14:DCHG-S | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 8 | | |  |  |  |  |
| 15:DCHG-R | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 8 | | |  |  |  |  |
| 16:SV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 8 | | |  |  |  |  |
| 17:RV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 8 | | |  |  |  |  |
| 18:IPM | 21 | | 15 | | | 10 | | | 12 | | | 12 | | | 8 | | |  |  |  |  |
| 19:IPS | 7 | | 7 | | | 7 | | | 1 | | | 6 | | | 7 | | |  |  |  |  |
| 20:SV.MODE | 00H | | 11H | | | 11H | | | 31H | | | 31H | | | 31H | | |  |  |  |  |
| 21:SV. | 00H | | 04H | | | 04H | | | 0EH | | | 0EH | | | 0EH | | |  |  |  |  |
| 22:SV.ADJ | 60 | | 175 | | | 60 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 23:SPEED | 3.5 | | 7.0 | | | 5.0 | | | 5.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |
| 24:SM-REF | 33H | | 33H | | | 33H | | | 11 | | | 11 | | | 10H | | |  |  |  |  |
| 25:PRG-ON | 04 | | 01H | | | 01H | | | 01H | | | 01 | | | 01 | | |  |  |  |  |
| 26:PRG0-1 | 0000H | | 0D3FH | | | 0D3FH | | | 0D3FH | | | 0D3DH | | | 0D3DH | | |  |  |  |  |
| 27:PRG0-2 | 00H | | 33 | | | 33 | | | 33 | | | 33 | | | 33 | | |  |  |  |  |
| 28:PRG0-3 | 00H | | A8H | | | A8H | | | A8H | | | A8H | | | A8H | | |  |  |  |  |
| 29:PRG0-4 | 00H | | BAH | | | BAH | | | BAH | | | BAH | | | BAH | | |  |  |  |  |
| 30:PRG1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 31:PRG2-1 | 50 | | 0 | | | 0 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 32:PRG2-2 | 55 | | 0 | | | 0 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |
| 33:ADC-ON | 05H | | 05H | | | 01H | | | 01H | | | 01H | | | 01H | | |  |  |  |  |
| 34:ADC0-1 | 0BH | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | |  |  |  |  |
| 35:ADC0-2 | 1 | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |
| 36:ADC1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 37:ADC1-2 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 38:ADC2-1 | 55H | | 46H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 39:ADC2-2 | 25H | | 55H | | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |
| 40:FLUSHING | 6 | | 8 | | | 8 | | | 8 | | | 8 | | | 8 | | |  |  |  |  |
| 41:OVERRIDE U | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 125 | | |  |  |  |  |
| 42:OVERRIDE L | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 125 | | |  |  |  |  |
| 43:WIRE FEED | 16 | | 14 | | | 14 | | | 14 | | | 14 | | | 14 | | |  |  |  |  |
| 44:TENSION | 9 | | 10 | | | 10 | | | 10 | | | 10 | | | 10 | | |  |  |  |  |
| 45:COND. | 30 | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | |  |  |  |  |
| 46:EST.SPEED | 2.65 | | 3.0 | | | 4.0 | | | 5.0 | | | 3.0 | | | 3.0 | | |  |  |  |  |

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| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | WC | Both Away | Roughing~ finish 1 |

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| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 25 | | | | | | | | | | | | | | 30 | | | | | | | | | | | | | | |
| MODEL No. | 0703070514 | | | | | | | | | | | | | | 0703080514 | | | | | | | | | | | | | | |
| PROCESS | 1st | | 2nd | | | 3rd | | | 4th | | | 5th | | | 1st | | | 2nd | | | 3rd | | | 4th | | | 5th | | |
| E No. | E1476 | | E1477 | | | E1478 | | | E1479 | | | E1480 | | | E1486 | | | E1487 | | | E1488 | | | E1489 | | | E1490 | | |
| H Value | V-corner | | - | | | - | | | - | | | - | | | V-corner | | | - | | | - | | | - | | | - | | |
| Offset roughing | 0.170 | | - | | | - | | | - | | | - | | | 0.172 | | | - | | | - | | | - | | | - | | |
| 2nd | 0.198 | | 0.133 | | | - | | | - | | | - | | | 0.202 | | | 0.135 | | | - | | | - | | | - | | |
| finish 5 | 0.205 | | 0.140 | | | 0.132 | | | - | | | - | | | 0.209 | | | 0.142 | | | 0.132 | | | - | | | - | | |
| finish 2 | 0.209 | | 0.144 | | | 0.136 | | | 0.131 | | | - | | | 0.213 | | | 0.146 | | | 0.136 | | | 0.131 | | | - | | |
| finish 1 | 0.210 | | 0.145 | | | 0.137 | | | 0.132 | | | 0.130 | | | 0.214 | | | 0.147 | | | 0.137 | | | 0.132 | | | 0.130 | | |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |
|  |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |
|  | -  - | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | | -  - | | |
| Pressure Up.(Mpa) | - | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | |
| Low(Mpa | - | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | |
| Removal rate  (mm/min) | 2.2  ~1.9 | | 3.0  ~1.5 | | | 4.0  ~3.0 | | | 4.0 | | | 3.0 | | | 1.9  ~1.6 | | | 2.5  ~1.2 | | | 3.5  ~2.4 | | | 4.0 | | | 3.0 | | |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 3~5 | | 6~8 | | | 0~2 | | | 3~5 | | | 3~5 | | | 3~5 | | | 6~8 | | | 0~2 | | | 3~5 | | | 2~4 | | |
| Spark lump  state |  | |  | | |  | | | Non  - | | | Non  - | | |  | | |  | | |  | | | Non  - | | | Non  - | | |
| 12 | | 12 | | | 12 | | | 12 | | | 12 | | | 12 | | |
| Surface(micron) | 10 | | 7 | | | 5 | | | 1.8 | | | 1 | | | 10 | | | 7 | | | 5 | | | 1.8 | | | 1 | | |
| 01: E No. | E1476 | | E1477 | | | E1478 | | | E1479 | | | E1480 | | | E1486 | | | E1487 | | | E1488 | | | E1489 | | | E1490 | | |
| 02:WIRE DIA. | 0.250 | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | |
| 03:MATERIAL | 3 | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | |
| 04:THICKNESS | 25.0 | | 25.0 | | | 25.0 | | | 25.0 | | | 25.0 | | | 30.0 | | | 30.0 | | | 30.0 | | | 30.0 | | | 30.0 | | |
| 05:MODE | 0 | | 1 | | | 1 | | | 3 | | | 4 | | | 0 | | | 1 | | | 1 | | | 3 | | | 4 | | |
| 06:ONA | 30 | | 7 | | | 1 | | | 2 | | | 2 | | | 30 | | | 7 | | | 1 | | | 2 | | | 2 | | |
| 07:ONB | 50 | | 7 | | | 1 | | | 2 | | | 2 | | | 50 | | | 7 | | | 1 | | | 2 | | | 2 | | |
| 08:ONC | 15 | | 7 | | | 1 | | | 1 | | | 1 | | | 15 | | | 7 | | | 1 | | | 1 | | | 1 | | |
| 09:OND | 20 | | 7 | | | 1 | | | 1 | | | 1 | | | 20 | | | 7 | | | 1 | | | 1 | | | 1 | | |
| 10:OFF | 60 | | 60 | | | 150 | | | 10 | | | 4 | | | 60 | | | 60 | | | 140 | | | 10 | | | 4 | | |
| 11:TS | 10 | | 10 | | | 8 | | | 5 | | | 5 | | | 10 | | | 10 | | | 8 | | | 5 | | | 5 | | |
| 12:SCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 100 | | | 100 | | | 100 | | | 100 | | | 200 | | |
| 13:RCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 100 | | | 100 | | | 100 | | | 100 | | | 200 | | |
| 14:DCHG-S | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 10 | | | 10 | | | 10 | | | 12 | | | 12 | | |
| 15:DCHG-R | 10 | | 10 | | | 10 | | | 12 | | | 12 | | | 10 | | | 10 | | | 10 | | | 12 | | | 12 | | |
| 16:SV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 8 | | | 8 | | | 9 | | | 12 | | | 12 | | |
| 17:RV | 8 | | 8 | | | 9 | | | 12 | | | 12 | | | 8 | | | 8 | | | 9 | | | 12 | | | 12 | | |
| 18:IPM | 21 | | 15 | | | 10 | | | 12 | | | 12 | | | 21 | | | 15 | | | 10 | | | 12 | | | 12 | | |
| 19:IPS | 7 | | 7 | | | 7 | | | 1 | | | 6 | | | 7 | | | 7 | | | 7 | | | 1 | | | 6 | | |
| 20:SV.MODE | 00H | | 11H | | | 11H | | | 31H | | | 31H | | | 00H | | | 11H | | | 11H | | | 31H | | | 31H | | |
| 21:SV. | 00H | | 04H | | | 04H | | | 0EH | | | 0EH | | | 00H | | | 04H | | | 04H | | | 0EH | | | 0EH | | |
| 22:SV.ADJ | 60 | | 170 | | | 55 | | | 0 | | | 0 | | | 60 | | | 170 | | | 55 | | | 0 | | | 0 | | |
| 23:SPEED | 2.4 | | 6.0 | | | 4.5 | | | 4.0 | | | 3.0 | | | 2.2 | | | 5.0 | | | 4.0 | | | 4.0 | | | 3.0 | | |
| 24:SM-REF | 33H | | 33H | | | 33H | | | 11 | | | 11 | | | 33H | | | 33H | | | 33H | | | 11 | | | 11 | | |
| 25:PRG-ON | 04 | | 01H | | | 01H | | | 01H | | | 01 | | | 04 | | | 01H | | | 01H | | | 01H | | | 01 | | |
| 26:PRG0-1 | 0000H | | 0D3FH | | | 0D3FH | | | 0D3FH | | | 0D3DH | | | 0000H | | | 0D3FH | | | 0D3FH | | | 0D3FH | | | 0D3DH | | |
| 27:PRG0-2 | 00H | | 33 | | | 33 | | | 33 | | | 33 | | | 00H | | | 33 | | | 33 | | | 33 | | | 33 | | |
| 28:PRG0-3 | 00H | | A8H | | | A8H | | | A8H | | | A8H | | | 00H | | | A8H | | | A8H | | | A8H | | | A8H | | |
| 29:PRG0-4 | 00H | | BAH | | | BAH | | | BAH | | | BAH | | | 00H | | | BAH | | | BAH | | | BAH | | | BAH | | |
| 30:PRG1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 31:PRG2-1 | 55 | | 0 | | | 0 | | | 0 | | | 0 | | | 60 | | | 0 | | | 0 | | | 0 | | | 0 | | |
| 32:PRG2-2 | 60 | | 0 | | | 0 | | | 0 | | | 0 | | | 60 | | | 0 | | | 0 | | | 0 | | | 0 | | |
| 33:ADC-ON | 05H | | 05H | | | 01H | | | 01H | | | 01H | | | 05H | | | 05H | | | 01H | | | 01H | | | 01H | | |
| 34:ADC0-1 | 0BH | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | |
| 35:ADC0-2 | 1 | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | |
| 36:ADC1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 37:ADC1-2 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 38:ADC2-1 | 55H | | 46H | | | 00H | | | 00H | | | 00H | | | 55H | | | 46H | | | 00H | | | 00H | | | 00H | | |
| 39:ADC2-2 | 25H | | 55H | | | 00H | | | 00H | | | 00H | | | 25H | | | 55H | | | 00H | | | 00H | | | 00H | | |
| 40:FLUSHING | 6 | | 8 | | | 8 | | | 8 | | | 8 | | | 6 | | | 8 | | | 8 | | | 8 | | | 8 | | |
| 41:OVERRIDE U | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 140 | | | 150 | | | 150 | | | 150 | | | 150 | | |
| 42:OVERRIDE L | 140 | | 125 | | | 125 | | | 125 | | | 125 | | | 140 | | | 150 | | | 150 | | | 150 | | | 150 | | |
| 43:WIRE FEED | 16 | | 14 | | | 14 | | | 14 | | | 14 | | | 16 | | | 14 | | | 14 | | | 14 | | | 14 | | |
| 44:TENSION | 9 | | 10 | | | 10 | | | 10 | | | 10 | | | 9 | | | 10 | | | 10 | | | 10 | | | 10 | | |
| 45:COND. | 30 | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | |
| 46:EST.SPEED | 2.1 | | 2.5 | | | 3.5 | | | 4.0 | | | 3.0 | | | 1.8 | | | 2.0 | | | 3.0 | | | 4.0 | | | 3.0 | | |

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| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | WC | Both Away | Roughing~ finish 1.5 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 40 | | | | | | | | | | | | | | 50 | | | | | | | | | | | | | | |
| MODEL No. | 0703090514 | | | | | | | | | | | | | | 0703100514 | | | | | | | | | | | | | | |
| PROCESS | 1st | | 2nd | | | 3rd | | | 4th | | | 5th | | | 1st | | | 2nd | | | 3rd | | | 4th | | | 5th | | |
| E No. | E1496 | | E1497 | | | E1498 | | | E1499 | | | E1500 | | | E1506 | | | E1507 | | | E1508 | | | E1509 | | | E1510 | | |
| H Value | V-corner | | - | | | - | | | - | | | - | | | V-corner | | | - | | | - | | | - | | | - | | |
| Offset roughing | 0.174 | | - | | | - | | | - | | | - | | | 0.175 | | |  | | |  | | |  | | |  | | |
| 2nd | 0.204 | | 0.135 | | | - | | | - | | | - | | | 0.203 | | | 0.133 | | |  | | |  | | |  | | |
| finish 5 | 0.211 | | 0.142 | | | 0.132 | | | - | | | - | | | 0.210 | | | 0.140 | | | 0.132 | | |  | | |  | | |
| finish 2 | 0.215 | | 0.146 | | | 0.136 | | | 0.131 | | | - | | | 0.213 | | | 0.143 | | | 0.135 | | | 0.131 | | |  | | |
| finish 1.5 | 0.216 | | 0.147 | | | 0.137 | | | 0.132 | | | 0.130 | | | 0.215 | | | 0.145 | | | 0.137 | | | 0.133 | | | 0.131 | | |
| +1finish 5 | 0.231  - | | 0.162  0.142 | | | -  0.132 | | | -  - | | | -  - | | | 0.230  - | | | 0.160  0.140 | | | -  0.132 | | | -  - | | | -  - | | |
| +1finish 2 | 0.235  - | | 0.166  0.146 | | | -  0.136 | | | -  0.131 | | | -  - | | | 0.233  - | | | 0.163  0.143 | | | -  0.135 | | | -  0.131 | | | -  - | | |
| +1finish 1.5 | 0.236  - | | 0.167  0.147 | | | -  0.137 | | | -  0.132 | | | -  0.130 | | | 0.235  - | | | 0.165  0.145 | | | -  0.137 | | | -  0.133 | | | -  0.131 | | |
| Pressure Up.(Mpa) | - | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | |
| Low(Mpa | - | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | | - | | |
| Removal rate  (mm/min) | 1.4  ~1.2 | | 1.8  ~1.0 | | | 2.5  ~1.5 | | | 4.0 | | | 3.0 | | | 1.1  ~0.85 | | | 1.6  ~0.8 | | | 2.2  ~1.0 | | | 4.0 | | | 3.0 | | |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 2~4 | | 6~8 | | | 1~3 | | | 1~3 | | | 1~3 | | | 2~4 | | | 7~9 | | | 0~2 | | | 1~2 | | | 4~6 | | |
| Spark lump  state |  | |  | | |  | | | Non  - | | | Non  - | | |  | | |  | | |  | | | Non  - | | | Non  - | | |
| 12 | | 12 | | | 12 | | | 12 | | | 12 | | | 12 | | |
| Surface(micron) | 10 | | 7 | | | 5 | | | 2.5 | | | 1.2 | | | 10 | | | 7 | | | 5 | | | 2.5 | | | 1.5 | | |
| 01: E No. | E1496 | | E1497 | | | E1498 | | | E1499 | | | E1500 | | | E1506 | | | E1507 | | | E1508 | | | E1509 | | | E1510 | | |
| 02:WIRE DIA. | 0.250 | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | |
| 03:MATERIAL | 3 | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | | 3 | | |
| 04:THICKNESS | 40.0 | | 40.0 | | | 40.0 | | | 40.0 | | | 40.0 | | | 50.0 | | | 50.0 | | | 50.0 | | | 50.0 | | | 50.0 | | |
| 05:MODE | 0 | | 1 | | | 1 | | | 3 | | | 4 | | | 0 | | | 1 | | | 1 | | | 3 | | | 4 | | |
| 06:ONA | 30 | | 9 | | | 1 | | | 10 | | | 2 | | | 30 | | | 9 | | | 1 | | | 10 | | | 2 | | |
| 07:ONB | 50 | | 9 | | | 1 | | | 10 | | | 2 | | | 50 | | | 9 | | | 1 | | | 10 | | | 2 | | |
| 08:ONC | 15 | | 8 | | | 1 | | | 1 | | | 1 | | | 15 | | | 8 | | | 1 | | | 1 | | | 1 | | |
| 09:OND | 20 | | 8 | | | 1 | | | 1 | | | 1 | | | 20 | | | 8 | | | 1 | | | 1 | | | 1 | | |
| 10:OFF | 70 | | 60 | | | 135 | | | 100 | | | 4 | | | 75 | | | 60 | | | 130 | | | 100 | | | 4 | | |
| 11:TS | 10 | | 10 | | | 8 | | | 5 | | | 5 | | | 10 | | | 10 | | | 8 | | | 5 | | | 5 | | |
| 12:SCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 100 | | | 100 | | | 100 | | | 100 | | | 200 | | |
| 13:RCT | 100 | | 100 | | | 100 | | | 100 | | | 200 | | | 100 | | | 100 | | | 100 | | | 100 | | | 200 | | |
| 14:DCHG-S | 10 | | 10 | | | 10 | | | 15 | | | 12 | | | 10 | | | 10 | | | 10 | | | 15 | | | 12 | | |
| 15:DCHG-R | 10 | | 10 | | | 10 | | | 15 | | | 12 | | | 10 | | | 10 | | | 10 | | | 15 | | | 12 | | |
| 16:SV | 8 | | 8 | | | 9 | | | 14 | | | 12 | | | 8 | | | 8 | | | 9 | | | 14 | | | 12 | | |
| 17:RV | 8 | | 8 | | | 9 | | | 14 | | | 12 | | | 8 | | | 8 | | | 9 | | | 14 | | | 12 | | |
| 18:IPM | 21 | | 15 | | | 10 | | | 14 | | | 12 | | | 21 | | | 15 | | | 10 | | | 14 | | | 12 | | |
| 19:IPS | 7 | | 7 | | | 7 | | | 1 | | | 6 | | | 7 | | | 7 | | | 7 | | | 1 | | | 6 | | |
| 20:SV.MODE | 00H | | 11H | | | 11H | | | 31H | | | 31H | | | 00H | | | 11H | | | 11H | | | 31H | | | 31H | | |
| 21:SV. | 00H | | 04H | | | 04H | | | 0EH | | | 0EH | | | 00H | | | 04H | | | 04H | | | 0EH | | | 0EH | | |
| 22:SV.ADJ | 60 | | 160 | | | 50 | | | 0 | | | 0 | | | 60 | | | 150 | | | 50 | | | 0 | | | 0 | | |
| 23:SPEED | 1.6 | | 4.0 | | | 3.5 | | | 4.0 | | | 3.0 | | | 1.2 | | | 3.0 | | | 3.0 | | | 4.0 | | | 3.0 | | |
| 24:SM-REF | 33H | | 33H | | | 33H | | | 10 | | | 11 | | | 33H | | | 33H | | | 33H | | | 10H | | | 10H | | |
| 25:PRG-ON | 04 | | 01H | | | 01H | | | 01H | | | 01 | | | 04 | | | 01H | | | 01H | | | 01H | | | 01 | | |
| 26:PRG0-1 | 0000H | | 0D3FH | | | 0D3FH | | | 0D3FH | | | 0D3DH | | | 0000H | | | 0D3FH | | | 0D3FH | | | 0D3FH | | | 0D3DH | | |
| 27:PRG0-2 | 00H | | 33 | | | 33 | | | 33 | | | 33 | | | 00H | | | 44H | | | 44H | | | 44H | | | 44H | | |
| 28:PRG0-3 | 00H | | A8H | | | A8H | | | A8H | | | A8H | | | 00H | | | A8H | | | A8H | | | A8H | | | A8H | | |
| 29:PRG0-4 | 00H | | BAH | | | BAH | | | BAH | | | BAH | | | 00H | | | BAH | | | BAH | | | BAH | | | BAH | | |
| 30:PRG1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 31:PRG2-1 | 60 | | 0 | | | 0 | | | 0 | | | 0 | | | 65 | | | 0 | | | 0 | | | 0 | | | 0 | | |
| 32:PRG2-2 | 65 | | 0 | | | 0 | | | 0 | | | 0 | | | 65 | | | 0 | | | 0 | | | 0 | | | 0 | | |
| 33:ADC-ON | 05H | | 05H | | | 01H | | | 01H | | | 01H | | | 05H | | | 05H | | | 01H | | | 01H | | | 01H | | |
| 34:ADC0-1 | 0BH | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | | 0BH | | |
| 35:ADC0-2 | 1 | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | | 1 | | |
| 36:ADC1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 37:ADC1-2 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | | 00H | | |
| 38:ADC2-1 | 55H | | 46H | | | 00H | | | 00H | | | 00H | | | 55H | | | 46H | | | 00H | | | 00H | | | 00H | | |
| 39:ADC2-2 | 25H | | 55H | | | 00H | | | 00H | | | 00H | | | 25H | | | 55H | | | 00H | | | 00H | | | 00H | | |
| 40:FLUSHING | 6 | | 8 | | | 8 | | | 8 | | | 8 | | | 6 | | | 8 | | | 8 | | | 8 | | | 8 | | |
| 41:OVERRIDE U | 140 | | 150 | | | 150 | | | 150 | | | 150 | | | 140 | | | 200 | | | 150 | | | 150 | | | 150 | | |
| 42:OVERRIDE L | 140 | | 150 | | | 150 | | | 150 | | | 150 | | | 140 | | | 200 | | | 150 | | | 150 | | | 150 | | |
| 43:WIRE FEED | 16 | | 14 | | | 14 | | | 14 | | | 14 | | | 16 | | | 14 | | | 14 | | | 14 | | | 14 | | |
| 44:TENSION | 9 | | 10 | | | 10 | | | 10 | | | 10 | | | 9 | | | 10 | | | 10 | | | 10 | | | 10 | | |
| 45:COND. | 30 | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | | 30 | | |
| 46:EST.SPEED | 1.3 | | 1.4 | | | 2.3 | | | 4.0 | | | 3.0 | | | 1.0 | | | 1.3 | | | 1.6 | | | 4.0 | | | 3.0 | | |

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| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | WC | Both Away | Roughing~ finish 1.5 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 60 | | | | | | | | | | | | | |  | | | | |
| MODEL No. | 0703110514 | | | | | | | | | | | | | |  | | | | |
| PROCESS | 1st | | 2nd | | | 3rd | | | 4th | | | 5th | | |  |  |  |  |  |
| E No. | E1516 | | E1517 | | | E1518 | | | E1519 | | | E1520 | | |  |  |  |  |  |
| H Value | V-corner | | - | | | - | | | - | | | - | | |  |  |  |  |  |
| Offset roughing | 0.180 | |  | | |  | | |  | | |  | | |  |  |  |  |  |
| 2nd | 0.203 | | 0.133 | | |  | | |  | | |  | | |  |  |  |  |  |
| finish 5 | 0.210 | | 0.140 | | | 0.132 | | |  | | |  | | |  |  |  |  |  |
| finish 2 | 0.213 | | 0.143 | | | 0.135 | | | 0.131 | | |  | | |  |  |  |  |  |
| finish 1.5 | 0.214 | | 0.144 | | | 0.136 | | | 0.132 | | | 0.130 | | |  |  |  |  |  |
| +1finish 5 | 0.232  - | | 0.162  0.142 | | | -  0.132 | | | -  - | | | -  - | | |  |  |  |  |  |
| +1finish 2 | 0.235  - | | 0.165  0.145 | | | -  0.135 | | | -  0.131 | | | -  - | | |  |  |  |  |  |
| +1finish 1.5 | 0.236  - | | 0.166  0.146 | | | -  0.136 | | | -  0.132 | | | -  0.130 | | |  |  |  |  |  |
| Pressure Up.(Mpa) | - | | - | | | - | | | - | | | - | | |  |  |  |  |  |
| Low(Mpa | - | | - | | | - | | | - | | | - | | |  |  |  |  |  |
| Removal rate  (mm/min) | 0.8  ~0.6 | | 1.5  ~0.8 | | | 2.0  ~0.8 | | | 3.0 | | | 3.0 | | |  |  |  |  |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 2~4 | | 6~9 | | | 0~2 | | | 1~2 | | | 4~7 | | |
| Spark lump  state |  | |  | | |  | | | Non  - | | | Non  - | | |  |  |  |  |  |
| 12 | | 12 | | | 12 | | |
| Surface(micron) | 10 | | 7 | | | 5 | | | 2.5 | | | 1.5 | | |  |  |  |  |  |
| 01: E No. | E1516 | | E1517 | | | E1518 | | | E1519 | | | E1520 | | |  |  |  |  |  |
| 02:WIRE DIA. | 0.250 | | 0.250 | | | 0.250 | | | 0.250 | | | 0.250 | | |  |  |  |  |  |
| 03:MATERIAL | 3 | | 3 | | | 3 | | | 3 | | | 3 | | |  |  |  |  |  |
| 04:THICKNESS | 60.0 | | 60.0 | | | 60.0 | | | 60.0 | | | 60.0 | | |  |  |  |  |  |
| 05:MODE | 0 | | 1 | | | 1 | | | 3 | | | 4 | | |  |  |  |  |  |
| 06:ONA | 30 | | 9 | | | 1 | | | 10 | | | 3 | | |  |  |  |  |  |
| 07:ONB | 50 | | 9 | | | 1 | | | 10 | | | 3 | | |  |  |  |  |  |
| 08:ONC | 15 | | 8 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |  |
| 09:OND | 20 | | 8 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |  |
| 10:OFF | 80 | | 60 | | | 125 | | | 100 | | | 4 | | |  |  |  |  |  |
| 11:TS | 10 | | 10 | | | 8 | | | 5 | | | 5 | | |  |  |  |  |  |
| 12:SCT | 100 | | 100 | | | 100 | | | 100 | | | 100 | | |  |  |  |  |  |
| 13:RCT | 100 | | 100 | | | 100 | | | 100 | | | 100 | | |  |  |  |  |  |
| 14:DCHG-S | 10 | | 10 | | | 10 | | | 15 | | | 12 | | |  |  |  |  |  |
| 15:DCHG-R | 10 | | 10 | | | 10 | | | 15 | | | 12 | | |  |  |  |  |  |
| 16:SV | 8 | | 8 | | | 9 | | | 14 | | | 12 | | |  |  |  |  |  |
| 17:RV | 8 | | 8 | | | 9 | | | 14 | | | 12 | | |  |  |  |  |  |
| 18:IPM | 21 | | 15 | | | 10 | | | 14 | | | 12 | | |  |  |  |  |  |
| 19:IPS | 7 | | 7 | | | 7 | | | 1 | | | 5 | | |  |  |  |  |  |
| 20:SV.MODE | 00H | | 11H | | | 11H | | | 31H | | | 31H | | |  |  |  |  |  |
| 21:SV. | 00H | | 04H | | | 04H | | | 0EH | | | 0EH | | |  |  |  |  |  |
| 22:SV.ADJ | 60 | | 140 | | | 40 | | | 0 | | | 0 | | |  |  |  |  |  |
| 23:SPEED | 1.0 | | 2.5 | | | 2.5 | | | 3.0 | | | 3.0 | | |  |  |  |  |  |
| 24:SM-REF | 33H | | 33H | | | 33H | | | 10H | | | 10H | | |  |  |  |  |  |
| 25:PRG-ON | 04 | | 01H | | | 01H | | | 01H | | | 01 | | |  |  |  |  |  |
| 26:PRG0-1 | 0000H | | 0D3FH | | | 0D3FH | | | 0D3FH | | | 0D3DH | | |  |  |  |  |  |
| 27:PRG0-2 | 00H | | 44H | | | 44H | | | 44H | | | 44H | | |  |  |  |  |  |
| 28:PRG0-3 | 00H | | A8H | | | A8H | | | A8H | | | A8H | | |  |  |  |  |  |
| 29:PRG0-4 | 00H | | BAH | | | BAH | | | BAH | | | BAH | | |  |  |  |  |  |
| 30:PRG1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |  |
| 31:PRG2-1 | 70 | | 0 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |  |
| 32:PRG2-2 | 70 | | 0 | | | 0 | | | 0 | | | 0 | | |  |  |  |  |  |
| 33:ADC-ON | 05H | | 05H | | | 01H | | | 01H | | | 01H | | |  |  |  |  |  |
| 34:ADC0-1 | 0BH | | 0BH | | | 0BH | | | 0BH | | | 0BH | | |  |  |  |  |  |
| 35:ADC0-2 | 1 | | 1 | | | 1 | | | 1 | | | 1 | | |  |  |  |  |  |
| 36:ADC1-1 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |  |
| 37:ADC1-2 | 00H | | 00H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |  |
| 38:ADC2-1 | 55H | | 46H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |  |
| 39:ADC2-2 | 28 | | 55H | | | 00H | | | 00H | | | 00H | | |  |  |  |  |  |
| 40:FLUSHING | 6 | | 8 | | | 8 | | | 8 | | | 8 | | |  |  |  |  |  |
| 41:OVERRIDE U | 140 | | 200 | | | 150 | | | 150 | | | 150 | | |  |  |  |  |  |
| 42:OVERRIDE L | 140 | | 200 | | | 150 | | | 150 | | | 150 | | |  |  |  |  |  |
| 43:WIRE FEED | 16 | | 14 | | | 14 | | | 14 | | | 14 | | |  |  |  |  |  |
| 44:TENSION | 9 | | 10 | | | 10 | | | 10 | | | 10 | | |  |  |  |  |  |
| 45:COND. | 30 | | 30 | | | 30 | | | 30 | | | 30 | | |  |  |  |  |  |
| 46:EST.SPEED | 0.7 | | 1.2 | | | 1.5 | | | 3.0 | | | 3.0 | | |  |  |  |  |  |

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BS 0.25mm

Finish

Cu

Both Away



|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
|  | |  |  | |  |  |
|  | B | TH AW | AY |  |  | |
|  | |  |  | |  |  |

|  |  |  |  |
| --- | --- | --- | --- |
|  |  |  |  |
|  | |  |
|  | |

Used V-corner for roughing

(No use G44 or G44H0)

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | Cu | Both Away | Roughing ~ +1 finish 4 |

|  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 5 | | | | | 10 | | | | |
| MODEL No. | 0702030511 | | | | | 0702040511 | | | | |
| PROCESS | 1st | 2nd | 3rd |  |  | 1st | 2nd | 3rd |  |  |
| E No. | E1634 | E1635 | E1636 |  |  | E1644 | E1645 | E1646 |  |  |
| H Value | V-corner |  |  |  |  | V-corner |  |  |  |  |
| Offset roughing | 0.165 | - | - |  |  | 0.173 | - | - |  |  |
| 2nd | 0.186 | 0.132 | - |  |  | 0.191 | 0.133 | - |  |  |
| finish 4 | 0.192 | 0.138 | 0.131 |  |  | 0.195 | 0.137 | 0.129 |  |  |
|  |  |  |  |  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |  |  |  |  |
| +1 finish 4 | 0.212 | 0.158  0.138 | -  0.131 |  |  | 0.215 | 0.157  0.137 | -  0.129 |  |  |
|  |  |  |  |  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |  |  |  |  |
| Pressure Up.(Mpa) | - | - | - |  |  | - | - | - |  |  |
| Low(Mpa | - | - | - |  |  | - | - | - |  |  |
| Removal rate  (mm/min) | 11.5  ~9.5 | 20.0  ~16.7 | 20.0 |  |  | 9.7  ~7.9 | 20.0  ~17.7 | 20.0 |  |  |
| Servo lump  state |  |  |  |  |  |  |  |  |  |  |
|  |  |  |  |  |  |
| 6~8 | 8~9 | 9~10 | 6~8 | 9~10 | 7 |
| Spark lump  state |  |  | NON  - |  |  |  |  | NON  - |  |  |
|  |  |  |  |
| 12 | 12 | 12 | 12 |
| Surface(micron) | 18 | 10 | 3 |  |  | 18 | 10 | 3 |  |  |
| 01: E No. | E1634 | E1635 | E1636 |  |  | E1644 | E1645 | E1646 |  |  |
| 02:WIRE DIA. | 0.250 | 0.250 | 0.250 |  |  | 0.250 | 0.250 | 0.250 |  |  |
| 03:MATERIAL | 2 | 2 | 2 |  |  | 2 | 2 | 2 |  |  |
| 04:THICKNESS | 5.0 | 5.0 | 5.0 |  |  | 10.0 | 10.0 | 10.0 |  |  |
| 05:MODE | 0 | 1 | 3 |  |  | 0 | 1 | 3 |  |  |
| 06:ONA | 20 | 2 | 3 |  |  | 23 | 3 | 3 |  |  |
| 07:ONB | 20 | 2 | 3 |  |  | 23 | 3 | 3 |  |  |
| 08:ONC | 20 | 1 | 1 |  |  | 23 | 1 | 1 |  |  |
| 09:OND | 20 | 1 | 1 |  |  | 23 | 1 | 1 |  |  |
| 10:OFF | 70 | 60 | 6 |  |  | 55 | 35 | 6 |  |  |
| 11:TS | 10 | 10 | 5 |  |  | 10 | 10 | 5 |  |  |
| 12:SCT | 100 | 100 | 200 |  |  | 100 | 100 | 200 |  |  |
| 13:RCT | 100 | 100 | 200 |  |  | 100 | 100 | 200 |  |  |
| 14:DCHG-S | 10 | 10 | 10 |  |  | 10 | 10 | 10 |  |  |
| 15:DCHG-R | 10 | 10 | 10 |  |  | 10 | 10 | 10 |  |  |
| 16:SV | 8 | 8 | 13 |  |  | 8 | 8 | 13 |  |  |
| 17:RV | 8 | 8 | 13 |  |  | 8 | 8 | 13 |  |  |
| 18:IPM | 24 | 18 | 13 |  |  | 26 | 18 | 13 |  |  |
| 19:IPS | 7 | 7 | 1 |  |  | 7 | 7 | 1 |  |  |
| 20:SV.MODE | 62H | 10H | 30H |  |  | 62H | 10H | 30H |  |  |
| 21:SV. | 5 H | 04H | 00H |  |  | 5 H | 04H | 00H |  |  |
| 22:SV.ADJ | 130 | 160 | 0 |  |  | 130 | 160 | 0 |  |  |
| 23:SPEED | 50.0 | 20.0 | 20.0 |  |  | 50.0 | 20.0 | 20.0 |  |  |
| 24:SM-REF | 33H | 33H | 12H |  |  | 33H | 33H | 12H |  |  |
| 25:PRG-ON | 04H | 01H | 01H |  |  | 04H | 01H | 01H |  |  |
| 26:PRG0-1 | 0000H | 0D3FH | 0D3DH |  |  | 0000H | 0D3FH | 0D3DH |  |  |
| 27:PRG0-2 | 00H | 55H | 55H |  |  | 00H | 55H | 55H |  |  |
| 28:PRG0-3 | 00H | AAH | AAH |  |  | 00H | AAH | AAH |  |  |
| 29:PRG0-4 | 00H | BAH | BBH |  |  | 00H | BAH | BBH |  |  |
| 30:PRG1-1 | 00H | 00H | 00H |  |  | 00H | 00H | 00H |  |  |
| 31:PRG2-1 | 20 | 0 | 0 |  |  | 40 | 0 | 0 |  |  |
| 32:PRG2-2 | 20 | 0 | 0 |  |  | 20 | 0 | 0 |  |  |
| 33:ADC-ON | 07H | 01H | 01H |  |  | 07H | 01H | 01H |  |  |
| 34:ADC0-1 | 0BH | 0BH | 0BH |  |  | 0BH | 0BH | 0BH |  |  |
| 35:ADC0-2 | 1 | 1 | 1 |  |  | 1 | 1 | 1 |  |  |
| 36:ADC1-1 | 85H | 00H | 00H |  |  | 85H | 00H | 00H |  |  |
| 37:ADC1-2 | 26H | 00H | 00H |  |  | 26H | 00H | 00H |  |  |
| 38:ADC2-1 | 6 H | 00H | 00H |  |  | 6 H | 00H | 00H |  |  |
| 39:ADC2-2 | 33H | 00H | 00H |  |  | 33H | 00H | 00H |  |  |
| 40:FLUSHING | 6 | 7 | 7 |  |  | 6 | 7 | 7 |  |  |
| 41:OVERRIDE U | 100 | 100 | 100 |  |  | 100 | 100 | 100 |  |  |
| 42:OVERRIDE L | 100 | 100 | 100 |  |  | 100 | 100 | 100 |  |  |
| 43:WIRE FEED | 12 | 14 | 14 |  |  | 12 | 14 | 14 |  |  |
| 44:TENSION | 9 | 10 | 10 |  |  | 9 | 10 | 10 |  |  |
| 45:COND. | 30 | 30 | 30 |  |  | 30 | 30 | 30 |  |  |
| 46:EST.SPEED | 10.5 | 18.5 | 20.0 |  |  | 8.8 | 19.7 | 20.0 |  |  |

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|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | Cu | Both Away | Roughing ~ +1 finish 4 |

THICKNESS(mm) 15 20

MODEL No. 0702050511 0702060511

PROCESS 1st 2nd 3rd 1st 2nd 3rd

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| E No. | | E1654 | E1655 | E1656 | E1664 | E1665 | E1666 |
| H Value |  | V-corner |  |  | V-corner |  |  |
| Offset | roughing | 0.178 | - | - | 0.178 | - | - |
|  | 2nd | 0.196 | 0.133 | - | 0.194 | 0.133 | - |
|  | finish 4 | 0.201 | 0.138 | 0.130 | 0.200 | 0.139 | 0.130 |

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| +1 finish 4 | 0.221 | 0.158 | - | 0.220 | 0.159 | - |
|  |  | 0.138 | 0.130 |  | 0.139 | 0.130 |

Pressure Up.(Mpa) - - - - - - Low(Mpa - - - - - -

Removal rate 6.9 14.6 5.9 13.2

(mm/min) ~5.7 ~12.0 20.0 ~4.9 ~10.8 15.0

Servo lump

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| state | 6~8 | 9~10 | 6 |  | 5~7 | 9~10 | 5 |
| Spark lump |  |  | NON |  |  |  | NON |
| state | 12 | 12 | - |  | 12 | 12 | - |
| Surface(micron) 20 12 4 20 12 4 | | | | | | | |

01: E No. E1654 E1655 E1656 E1664 E1665 E1666

02:WIRE DIA. 0.250 0.250 0.250 0.250 0.250 0.250

03:MATERIAL 1 1 1 1 1 1

04:THICKNESS 15.0 15.0 15.0 20.0 20.0 20.0

05:MODE 0 1 3 0 1 3

06:ONA 23 3 3 23 3 3

07:ONB 23 3 3 23 3 3

08:ONC 23 1 1 23 1 1

09:OND 23 1 1 23 1 1

10:OFF 55 35 6 50 30 6

11:TS 10 10 5 10 10 5



12:SCT 100 100 200 100 100 200

13:RCT 100 100 200 100 100 200

14:DCHG-S 10 10 10 10 10 10

15:DCHG-R 10 10 10 10 10 10

16:SV 8 8 13 8 8 13

17:RV 8 8 13 8 8 13

18:IPM 26 18 13 26 18 13

19:IPS 7 7 1 7 7 1

20:SV.MODE 62H 10H 30H 62H 10H 30H

21:SV. 5 H 04H 00H 5 H 04H 00H

22:SV.ADJ 130 160 0 120 150 0

23:SPEED 50.0 17.0 20.0 50.0 14.0 15.0

24:SM-REF 33H 33H 12H 33H 33H 12H

25:PRG-ON 04H 01H 01H 04H 01H 01H

26:PRG0-1 0000H 0D3FH 0D3DH 0000H 0D3FH 0D3DH

27:PRG0-2 00H 55H 55H 00H 55H 55H

28:PRG0-3 00H AAH AAH 00H AAH AAH

29:PRG0-4 00H BAH BBH 00H BAH BBH

30:PRG1-1 00H 00H 00H 00H 00H 00H

31:PRG2-1 40 0 0 40 0 0

32:PRG2-2 20 0 0 40 0 0

33:ADC-ON 07H 01H 01H 07H 01H 01H

34:ADC0-1 0BH 0BH 0BH 0BH 0BH 0BH

35:ADC0-2 1 1 1 1 1 1

36:ADC1-1 85H 00H 00H 85H 00H 00H

37:ADC1-2 26H 00H 00H 26H 00H 00H

38:ADC2-1 6 H 00H 00H 6 H 00H 00H

39:ADC2-2 33H 00H 00H 33H 00H 00H

40:FLUSHING 6 7 7 6 7 7

41:OVERRIDE U 100 100 100 140 100 100

42:OVERRIDE L 100 100 100 140 100 100

43:WIRE FEED 12 14 14 12 14 14

44:TENSION 9 10 10 9 10 10

45:COND. 30 30 30 30 30 30

46:EST.SPEED 6.3 13.3 20.0 5.4 12.0 15.0

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | Cu | Both Away | Roughing ~ +1 finish 4 |

THICKNESS(mm) 25 30

MODEL No. 0702070511 0702080511

PROCESS 1st 2nd 3rd 1st 2nd 3rd

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| E No. | | E1674 | E1675 | E1676 | E1684 | E1685 | E1686 |
| H Value |  | V-corner |  |  | V-corner |  |  |
| Offset | roughing | 0.183 | - | - | 0.186 | - | - |
|  | 2nd | 0.199 | 0.133 | - | 0.204 | 0.135 | - |
|  | finish 4 | 0.205 | 0.139 | 0.131 | 0.210 | 0.141 | 0.131 |

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| +1 finish 4 | 0.225 | 0.159 | - | 0.230 | 0.161 | - |
|  |  | 0.139 | 0.131 |  | 0.141 | 0.131 |

Pressure Up.(Mpa) - - - - - - Low(Mpa - - - - - -

Removal rate 4.6 9.6 4.0 7.0

(mm/min) ~3.8 ~7.8 15.0 ~3.2 ~5.8 10.0

Servo lump

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| state | 6~7 | 9~10 | 4 |  | 6~7 | 9~10 | 4 |
| Spark lump |  |  | NON |  |  |  | NON |
| state | 12 | 12 | - |  | 12 | 12 | - |
| Surface(micron) 20 12 4 20 12 4 | | | | | | | |

01: E No. E1674 E1675 E1676 E1684 E1685 E1686

02:WIRE DIA. 0.250 0.250 0.250 0.250 0.250 0.250

03:MATERIAL 2 2 2 2 2 2

04:THICKNESS 25.0 25.0 25.0 30.0 30.0 30.0

05:MODE 0 1 3 0 1 3

06:ONA 23 3 3 23 3 3

07:ONB 23 3 3 23 3 3

08:ONC 23 1 1 23 1 1

09:OND 23 1 1 23 1 1

10:OFF 50 30 6 50 30 6

11:TS 10 10 5 10 10 5



12:SCT 100 100 200 100 100 200

13:RCT 100 100 200 100 100 200

14:DCHG-S 10 10 10 10 10 10

15:DCHG-R 10 10 10 10 10 10

16:SV 8 8 13 8 8 13

17:RV 8 8 13 8 8 13

18:IPM 26 18 13 26 18 13

19:IPS 7 7 1 7 7 1

20:SV.MODE 62H 10H 30H 62H 10H 30H

21:SV. 5 H 04H 00H 5 H 04H 00H

22:SV.ADJ 120 130 0 120 130 0

23:SPEED 50.0 10.0 15.0 50.0 7.0 10.0

24:SM-REF 33H 33H 12H 33H 33H 12H

25:PRG-ON 04H 01H 01H 04H 01H 01H

26:PRG0-1 0000H 0D3FH 0D3DH 0000H 0D3FH 0D3DH

27:PRG0-2 00H 55H 55H 00H 55H 55H

28:PRG0-3 00H AAH AAH 00H AAH AAH

29:PRG0-4 00H BAH BBH 00H BAH BBH

30:PRG1-1 00H 00H 00H 00H 00H 00H

31:PRG2-1 40 0 0 40 0 0

32:PRG2-2 40 0 0 40 0 0

33:ADC-ON 07H 01H 01H 07H 01H 01H

34:ADC0-1 0BH 0BH 0BH 0BH 0BH 0BH

35:ADC0-2 1 1 1 1 1 1

36:ADC1-1 85H 00H 00H 85H 00H 00H

37:ADC1-2 26H 00H 00H 26H 00H 00H

38:ADC2-1 6 H 00H 00H 6 H 00H 00H

39:ADC2-2 33H 00H 00H 33H 00H 00H

40:FLUSHING 6 7 7 6 7 7

41:OVERRIDE U 140 100 100 140 100 100

42:OVERRIDE L 140 100 100 140 100 100

43:WIRE FEED 12 14 14 12 14 14

44:TENSION 9 10 10 9 10 10

45:COND. 30 30 30 30 30 30

46:EST.SPEED 4.2 8.7 15.0 3.6 6.5 10.0

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | Cu | Both Away | Roughing ~ +1 finish 4 |

THICKNESS(mm) 40 50

MODEL No. 0702090511 0702100511

PROCESS 1st 2nd 3rd 1st 2nd 3rd

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| E No. | | E1694 | E1695 | E1696 | E1704 | E1705 | E1706 |
| H Value |  | V-corner |  |  | V-corner |  |  |
| Offset | roughing | 0.191 | - | - | 0.194 | - | - |
|  | 2nd | 0.210 | 0.137 | - | 0.214 | 0.139 | - |
|  | finish 4 | 0.215 | 0.142 | 0.131 | 0.219 | 0.144 | 0.132 |

|  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- |
| +1 finish 4 | 0.235 | 0.162 | - | 0.239 | 0.164 | - |
|  |  | 0.142 | 0.131 |  | 0.144 | 0.132 |

Pressure Up.(Mpa) - - - - - - Low(Mpa - - - - - -

Removal rate 2.9 5.5 2.2 4.2

(mm/min) ~2.3 ~4.5 10.0 ~1.8 ~3.4 10.0

Servo lump

|  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- |
| state | 5~7 | 9~10 | 3 |  | 6~7 | 9~10 | 4 |
| Spark lump |  |  | NON |  |  |  | NON |
| state | 12 | 12 | - |  | 12 | 12 | - |
| Surface(micron) 20 12 4 20 12 4 | | | | | | | |

01: E No. E1694 E1695 E1696 E1704 E1705 E1706

02:WIRE DIA. 0.250 0.250 0.250 0.250 0.250 0.250

03:MATERIAL 2 2 2 2 2 2

04:THICKNESS 40.0 40.0 40.0 50.0 50.0 50.0

05:MODE 0 1 3 0 1 3

06:ONA 23 3 3 23 4 3

07:ONB 23 3 3 23 4 3

08:ONC 23 1 1 23 1 1

09:OND 23 1 1 23 1 1

10:OFF 50 30 6 50 30 6

11:TS 10 10 5 10 10 5



12:SCT 100 100 200 100 100 200

13:RCT 100 100 200 100 100 200

14:DCHG-S 10 10 10 10 10 13

15:DCHG-R 10 10 10 10 10 13

16:SV 8 8 13 8 8 16

17:RV 8 8 13 8 8 16

18:IPM 26 18 13 26 18 13

19:IPS 7 7 1 7 7 1

20:SV.MODE 62H 10H 30H 62H 10H 30H

21:SV. 5 H 04H 00H 5 H 04H 00H

22:SV.ADJ 120 130 0 120 130 0

23:SPEED 50.0 6.5 10.0 50.0 6.0 10.0

24:SM-REF 33H 33H 12H 33H 33H 12H

25:PRG-ON 04H 01H 01H 04H 01H 01H

26:PRG0-1 0000H 0D3FH 0D3DH 0000H 0D3FH 0D3DH

27:PRG0-2 00H 55H 55H 00H 55H 55H

28:PRG0-3 00H AAH AAH 00H AAH AAH

29:PRG0-4 00H BAH BBH 00H BAH BBH

30:PRG1-1 00H 00H 00H 00H 00H 00H

31:PRG2-1 40 0 0 50 0 0

32:PRG2-2 40 0 0 40 0 0

33:ADC-ON 07H 01H 01H 07H 01H 01H

34:ADC0-1 0BH 0BH 0BH 0BH 0BH 0BH

35:ADC0-2 1 1 1 1 1 1

36:ADC1-1 85H 00H 00H 85H 00H 00H

37:ADC1-2 26H 00H 00H 26H 00H 00H

38:ADC2-1 6 H 00H 00H 6 H 00H 00H

39:ADC2-2 33H 00H 00H 33H 00H 00H

40:FLUSHING 6 7 7 6 7 7

41:OVERRIDE U 140 100 100 140 100 150

42:OVERRIDE L 140 100 100 140 100 150

43:WIRE FEED 12 14 14 12 14 14

44:TENSION 9 10 10 9 10 10

45:COND. 30 30 30 30 30 30

46:EST.SPEED 2.6 5.0 10.0 2.0 3.8 10.0

|  |  |  |  |
| --- | --- | --- | --- |
| WIRE DIAMETER | WORKPIECE | MC METHOD | FINISH |
| BS 0.25mm | Cu | Both Away | Roughing ~ +1 finish 4 |

|  |  |  |  |  |  |  |  |  |  |  |  |  |
| --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- | --- |
| THICKNESS(mm) | 60 | | | | | | |  | | | | |
| MODEL No. | 0702110511 | | | | | | |  | | | | |
| PROCESS | 1st | | 2nd | | 3rd |  |  | | | |  |  |
| E No. | E1714 | | E1715 | | E1716 |  |  |  |  |  |  |  |
| H Value | V-corner | |  | |  |  |  |  |  |  |  |  |
| Offset roughing | 0.199 | | - | | - |  |  |  |  |  |  |  |
| 2nd | 0.218 | | 0.139 | | - |  |  |  |  |  |  |  |
| finish 4 | 0.223 | | 0.144 | | 0.131 |  |  |  |  |  |  |  |
|  |  | |  | |  |  |  |  |  |  |  |  |
|  |  | |  | |  |  |  |  |  |  |  |  |
| +1 finish 4 | 0.243 | | 0.164  0.144 | | -  0.131 |  |  |  |  |  |  |  |
|  |  | |  | |  |  |  |  |  |  |  |  |
|  |  | |  | |  |  |  |  |  |  |  |  |
| Pressure Up.(Mpa) | - | | - | | - |  |  |  |  |  |  |  |
| Low(Mpa | - | | - | | - |  |  |  |  |  |  |  |
| Removal rate  (mm/min) | 1.8  ~1.4 | | 3.3  ~2.7 | | 10.0 |  |  |  |  |  |  |  |
| Servo lump  state |  | |  | |  |  |  |  |  |  |  |  |
|  |  |  |  |  |
| 5~7 | | 9~10 | | 3 |
| Spark lump  state |  | |  | | NON |  |  |  |  |  |  |  |
| 12 | | 12 | | - |
| Surface(micron) | 20 | | 12 | | 4 |  |  |  |  |  |  |  |
| 01: E No. | E1714 | | E1715 | | E1716 |  |  |  |  |  |  |  |
| 02:WIRE DIA. | 0.250 | | 0.250 | | 0.250 |  |  |  |  |  |  |  |
| 03:MATERIAL | 2 | | 2 | | 2 |  |  |  |  |  |  |  |
| 04:THICKNESS | 60.0 | | 60.0 | | 60.0 |  |  |  |  |  |  |  |
| 05:MODE | 0 | | 1 | | 3 |  |  |  |  |  |  |  |
| 06:ONA | 23 | | 4 | | 3 |  |  |  |  |  |  |  |
| 07:ONB | 23 | | 4 | | 3 |  |  |  |  |  |  |  |
| 08:ONC | 23 | | 1 | | 1 |  |  |  |  |  |  |  |
| 09:OND | 23 | | 1 | | 1 |  |  |  |  |  |  |  |
| 10:OFF | 50 | | 30 | | 6 |  |  |  |  |  |  |  |
| 11:TS | 10 | | 10 | | 5 |  |  |  |  |  |  |  |
| 12:SCT | 100 | | 100 | | 200 |  |  |  |  |  |  |  |
| 13:RCT | 100 | | 100 | | 200 |  |  |  |  |  |  |  |
| 14:DCHG-S | 10 | | 10 | | 13 |  |  |  |  |  |  |  |
| 15:DCHG-R | 10 | | 10 | | 13 |  |  |  |  |  |  |  |
| 16:SV | 8 | | 8 | | 16 |  |  |  |  |  |  |  |
| 17:RV | 8 | | 8 | | 16 |  |  |  |  |  |  |  |
| 18:IPM | 26 | | 18 | | 13 |  |  |  |  |  |  |  |
| 19:IPS | 7 | | 7 | | 1 |  |  |  |  |  |  |  |
| 20:SV.MODE | 62H | | 10H | | 30H |  |  |  |  |  |  |  |
| 21:SV. | 5 H | | 04H | | 00H |  |  |  |  |  |  |  |
| 22:SV.ADJ | 120 | | 120 | | 0 |  |  |  |  |  |  |  |
| 23:SPEED | 50.0 | | 6.0 | | 10.0 |  |  |  |  |  |  |  |
| 24:SM-REF | 33H | | 33H | | 12H |  |  |  |  |  |  |  |
| 25:PRG-ON | 04H | | 01H | | 01H |  |  |  |  |  |  |  |
| 26:PRG0-1 | 0000H | | 0D3FH | | 0D3DH |  |  |  |  |  |  |  |
| 27:PRG0-2 | 00H | | 55H | | 55H |  |  |  |  |  |  |  |
| 28:PRG0-3 | 00H | | AAH | | AAH |  |  |  |  |  |  |  |
| 29:PRG0-4 | 00H | | BAH | | BBH |  |  |  |  |  |  |  |
| 30:PRG1-1 | 00H | | 00H | | 00H |  |  |  |  |  |  |  |
| 31:PRG2-1 | 60 | | 0 | | 0 |  |  |  |  |  |  |  |
| 32:PRG2-2 | 40 | | 0 | | 0 |  |  |  |  |  |  |  |
| 33:ADC-ON | 07H | | 01H | | 01H |  |  |  |  |  |  |  |
| 34:ADC0-1 | 0BH | | 0BH | | 0BH |  |  |  |  |  |  |  |
| 35:ADC0-2 | 1 | | 1 | | 1 |  |  |  |  |  |  |  |
| 36:ADC1-1 | 85H | | 00H | | 00H |  |  |  |  |  |  |  |
| 37:ADC1-2 | 26H | | 00H | | 00H |  |  |  |  |  |  |  |
| 38:ADC2-1 | 6 H | | 00H | | 00H |  |  |  |  |  |  |  |
| 39:ADC2-2 | 33H | | 00H | | 00H |  |  |  |  |  |  |  |
| 40:FLUSHING | 6 | | 7 | | 7 |  |  |  |  |  |  |  |
| 41:OVERRIDE U | 140 | | 100 | | 150 |  |  |  |  |  |  |  |
| 42:OVERRIDE L | 140 | | 100 | | 150 |  |  |  |  |  |  |  |
| 43:WIRE FEED | 12 | | 14 | | 14 |  |  |  |  |  |  |  |
| 44:TENSION | 9 | | 10 | | 10 |  |  |  |  |  |  |  |
| 45:COND. | 30 | | 30 | | 30 |  |  |  |  |  |  |  |
| 46:EST.SPEED | 1.6 | | 3.0 | | 10.0 |  |  |  |  |  |  |  |

- 350 -

