



## **WIRE-CUT EDM SYSTEMS**

**MV2400R**

**MACHINING CHARACTERISTICS DATA BOOK**

BQN-W-70766—G

**(Version 9.0)**

# Mitsubishi Electric Wire-cut EDM Systems

## MV2400R Machining Characteristics Data

### Notice

- ☐ An effort has been made to follow revisions in software and hardware for the details described in this Instruction Manual. However, there may be some cases that do not match.
- ☐ An effort has been made to make the details of this Instruction Manual complete. If any errors or points of notice are found, please contact Mitsubishi.
- ☐ This machining data has been created based on Mitsubishi-designated tests. The machining results may differ according to the various conditions such as electrode and workpiece material and shape, etc., being used. Performing test machining is recommended if further optimum machining is required.

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## 5. Machining Characteristics Data

### 5-1 $\phi 0.20$ wire Machining characteristics data

| Wire dia.<br>(mm) | Workpiece material      | Applicable mode                    | Classification<br>No. | Machining conditions<br>Material thickness (mm) |
|-------------------|-------------------------|------------------------------------|-----------------------|---|
| $\phi 0.20$       | STEEL                   | Standard Punch(STDP1)              | 1                     | 5 to 100  |
|                   |                         | Standard Die(STDD1)                | 2                     | 5 to 100  |
|                   |                         | Nozzle Away Standard Punch(STDPO2) | 3                     | 5 to 60   |
|                   |                         | Nozzle Away Standard Die(STDDO2)   | 4                     | 5 to 60   |
|                   |                         | Accuracy Priority Punch(ACUP)      | 5                     | 5 to 100  |
|                   |                         | Accuracy Priority Die(ACUD)        | 6                     | 5 to 100  |
|                   |                         | Speed Priority(SPB)                | 7                     | 5 to 100  |
|                   | Tungsten Carbide(WC-Co) | Standard(STD)                      | 8                     | 5 to 100  |
|                   |                         | Minimum Step Punch(MSPP)           | 9                     | 10 to 60  |
|                   |                         | Minimum Step Punch(MSPD)           | 10                    | 10 to 30  |
|                   | Copper(Cu)              | Standard(STD)                      | 11                    | 5 to 100  |
|                   | Aluminum(Al)            |                                    | 12                    | 5 to 100  |
|                   | Graphite(Gr)            |                                    | 13                    | 10 to 100                                       |

\* 1

### 5-2 $\phi 0.25$ Wire Machining characteristics data

| Wire dia.<br>(mm) | Workpiece material      | Applicable mode              | Classification<br>No. | Machining conditions<br>Material thickness (mm) |
|-------------------|-------------------------|------------------------------|-----------------------|---|
| $\phi 0.25$       | STEEL                   | Standard-Punch(STDP1)        | 14                    | 5 to 100  |
|                   |                         | Standard-Die(STDD1)          | 15                    | 5 to 100  |
|                   |                         | Nozzle Away Standard(STDPO1) | 16                    | 5 to 150  |
|                   |                         | Accuracy Priority(ACU)       | 17                    | 5 to 300  |
|                   |                         | Speed Priority(SPB)          | 18                    | 5 to 100  |
|                   | Tungsten Carbide(WC-Co) | Standard(STD)                | 19                    | 5 to 100  |
|                   | Copper(Cu)              |                              | 20                    | 5 to 100  |
|                   | Aluminum(Al)            |                              | 21                    | 5 to 150  |
|                   | Graphite(Gr)            |                              | 22                    | 10 to 100                                       |

\* 1

### 5-3 $\phi 0.30$ Wire Machining characteristics data

| Wire dia.<br>(mm) | Workpiece material | Applicable mode              | Classification<br>No. | Machining conditions<br>Material thickness (mm) |
|-------------------|--------------------|------------------------------|-----------------------|---|
| $\phi 0.30$       | STEEL              | Standard(STD)                | 23                    | 5 to 300  |
|                   |                    | Nozzle Away Standard(STDPO1) | 24                    | 20 to 100                                       |
|                   | Aluminum(Al)       | Standard(STD)                | 25                    | 20 to 250                                       |
|                   | Copper(Cu)         |                              | 26                    | 20 to 100                                       |

### 5-4 $\phi 0.10$ Wire Machining characteristics data

| Wire dia.<br>(mm) | Workpiece material      | Applicable mode              | Classification<br>No. | Machining conditions<br>Material thickness (mm) |
|-------------------|-------------------------|------------------------------|-----------------------|---|
| $\phi 0.10$       | STEEL                   | Standard(STD)                | 27                    | 5 to 40   |
|                   |                         | Nozzle Away Standard(STDPO1) | 28                    | 5 to 10   |
|                   | Tungsten Carbide(WC-Co) | Standard(STD)                | 29                    | 5 to 40   |
|                   |                         | Nozzle Away Standard(STDPO1) | 30                    | 5 to 10   |
|                   | Copper(Cu)              | Standard(STD)                | 31                    | 5 to 20   |

### 5-5 $\phi 0.15$ Wire Machining characteristics data

| Wire dia.<br>(mm) | Workpiece material      | Applicable mode              | Classification<br>No. | Machining conditions<br>Material thickness (mm) |
|-------------------|-------------------------|------------------------------|-----------------------|---|
| $\phi 0.15$       | STEEL                   | Standard(STD)                | 32                    | 5 to 40   |
|                   |                         | Nozzle Away Standard(STDPO1) | 33                    | 5 to 10   |
|                   | Tungsten Carbide(WC-Co) | Standard(STD)                | 34                    | 5 to 40   |
|                   |                         | Nozzle Away Standard(STDPO1) | 35                    | 5 to 10   |

#### 5-6 Land Machining characteristics data

| Wire dia.<br>(mm) | Workpiece material      | Applicable mode | Classification<br>No. | Machining conditions<br>Material thickness (mm) |
|-------------------|-------------------------|-----------------|-----------------------|---|
| φ0.20             | STEEL                   | Land(LND)       | 36                    | 1 to 5  |
|                   | Tungsten Carbide(WC-Co) |                 | 37                    | 1 to 5  |
| φ0.25             | STEEL                   |                 | 38                    | 1 to 5  |
|                   | Tungsten Carbide(WC-Co) |                 | 39                    | 1 to 5  |

#### 5-7 PCD·CBN Machining characteristics data

| Wire dia.<br>(mm) | Workpiece material | Applicable mode | Classification<br>No. | Machining conditions<br>Material thickness (mm) |     |
|-------------------|--------------------|-----------------|-----------------------|---|-----|
| φ0.20             | PCD                | Standard(STD)   | 40                    | 2 to 2  | * 2 |
|                   | CBN                |                 | 41                    | 2 to 2  | * 3 |
| φ0.25             | PCD                | Standard(STD)   | 42                    | 2 to 2  | * 2 |
|                   | CBN                |                 | 43                    | 2 to 2  | * 3 |

#### 5-8 SL Machining characteristics data

| Wire dia.<br>(mm) | Workpiece material | Applicable mode  | Classification<br>No. | Machining conditions<br>Material thickness (mm) |
|-------------------|--------------------|------------------|-----------------------|---|
| φ0.20             | STEEL              | SL Machining(SL) | 44                    | 5 to 100  |
| φ0.25             | STEEL              |                  | 45                    | 5 to 100  |

#### 5-9 Anglemaster Wide Angle Taper Specification (option.)

| Wire dia.<br>(mm) | Workpiece material | Applicable mode | Classification<br>No. | Machining conditions<br>Material thickness (mm) |
|-------------------|--------------------|-----------------|-----------------------|---|
| φ0.20             | STEEL              | Standard(STD)   | 46                    | 20 to 40  |
| φ0.25             | STEEL              |                 | 47                    | 20 to 40  |

#### 5-10 φ0.07 Wire Machining characteristics data( option.)

| Wire dia.<br>(mm) | Workpiece material      | Applicable mode | Classification<br>No. | Machining conditions<br>Material thickness (mm) |
|-------------------|-------------------------|-----------------|-----------------------|---|
| φ0.07             | STEEL                   | Standard(STD)   | 48                    | 5 to 20   |
|                   | Tungsten Carbide(WC-Co) | Standard(STD)   | 49                    | 5 to 20   |

#### 5-11 φ0.05 Wire Machining characteristics data(option.)

| Wire dia.<br>(mm) | Workpiece material      | Applicable mode | Classification<br>No. | Machining conditions<br>Material thickness (mm) |
|-------------------|-------------------------|-----------------|-----------------------|---|
| φ0.05             | STEEL                   | Standard(STD)   | 50                    | 5 to 20   |
|                   | Tungsten Carbide(WC-Co) | Standard(STD)   | 51                    | 5 to 20   |

#### 5-12 Digital-FS Machining characteristics data(option.)

| Wire dia.<br>(mm) | Workpiece material      | Applicable mode | Classification<br>No. | Machining conditions<br>Material thickness (mm) |
|-------------------|-------------------------|-----------------|-----------------------|---|
| φ0.20             | STEEL                   | Digital-FS(DFS) | 52                    | 5 to 80   |
|                   | Tungsten Carbide(WC-Co) |                 | 53                    | 5 to 80   |
| φ0.10             | STEEL                   |                 | 54                    | 5 to 40   |
|                   | Tungsten Carbide(WC-Co) |                 | 55                    | 5 to 40   |
| φ0.25             | STEEL                   |                 | 56                    | 5 to 100  |
|                   | Tungsten Carbide(WC-Co) |                 | 57                    | 5 to 100  |
| φ0.15             | STEEL                   |                 | 58                    | 5 to 40   |
|                   | Tungsten Carbide(WC-Co) |                 | 59                    | 5 to 40   |
| φ0.07             | STEEL                   |                 | 60                    | 5 to 20   |
|                   | Tungsten Carbide(WC-Co) |                 | 61                    | 5 to 20   |
| φ0.05             | STEEL                   |                 | 62                    | 5 to 20   |
|                   | Tungsten Carbide(WC-Co) |                 | 63                    | 5 to 20   |

#### 5-13 φ0.20 wire Machining characteristics data

| Wire dia.<br>(mm) | Workpiece material | Applicable mode          | Classification<br>No. | Machining conditions<br>Material thickness (mm) |
|-------------------|--------------------|--------------------------|-----------------------|---|
| φ0.20             | STEEL              | Minimum Step Punch(MSPP) | 64                    | 10 to 100                                       |

\*1: Graphite type 1 is a stabilizing condition.

Graphite type 2 and 3 are machining conditions which pursue machining speed.  
(Machining conditions are searched for type 1 only.)

\*2: For PCD, machining conditions are searched for type 1 (particle diameter 2 μm) only.  
For other particle diameter conditions, see the machining conditions table.

\*3: For CBN, machining conditions are searched for type 1 (particle diameter 10 μm) only.  
For other particle diameter conditions, see the machining conditions table.

\*4: Optional. See the machining conditions table.

# 1. Configuration of Machining Conditions Table

## 1-1 Configuration of Machining Conditions Table

|                  |                                    | Wire diameter |         |         |         |           |           |           |
|------------------|------------------------------------|---------------|---------|---------|---------|-----------|-----------|-----------|
|                  |                                    | φ0.05         | φ0.07   | φ0.10   | φ0.15   | φ0.20     | φ0.25     | φ0.30     |
| STEEL            | Standard Punch(STDP1)              | 5 to 20       | 5 to 20 | -       | -       | 5 to 100  | 5 to 100  | -         |
|                  | Standard Die(STDD1)                | -             | -       | -       | -       | 5 to 100  | 5 to 100  | -         |
|                  | Standard(STD)                      | -             | -       | -       | 5 to 40 | -         | -         | 5 to 300  |
|                  | Nozzle Away Standard Punch(STDPO2) | -             | -       | -       | -       | 5 to 60   | -         | -         |
|                  | Nozzle Away Standard Die(STDDO2)   | -             | -       | -       | -       | 5 to 60   | -         | -         |
|                  | Nozzle Away Standard (STDP01)      | -             | -       | 5 to 10 | 5 to 10 | -         | 5 to 150  | 20 to 100 |
|                  | Accuracy Priority Punch(ACUP)      | -             | -       | -       | -       | 5 to 100  | -         | -         |
|                  | Accuracy Priority Die(ACUD)        | -             | -       | -       | -       | 5 to 100  | -         | -         |
|                  | Accuracy Priority (ACU)            | -             | -       | -       | -       | -         | 5 to 300  | -         |
|                  | Speed Priority (SPB)               | -             | -       | -       | -       | 5 to 100  | 5 to 100  | -         |
|                  | Minimum Step Punch(MSPP)           | -             | -       | -       | -       | 10 to 100 | -         | -         |
|                  | Land Machining(LND)                | -             | -       | -       | -       | 1 to 5    | 1 to 5    | -         |
|                  | SL Machining(SL)                   | -             | -       | -       | -       | 5 to 100  | 5 to 100  | -         |
|                  | Anglemaster*1                      | -             | -       | -       | -       | 20 to 40  | 20 to 40  | -         |
|                  | Digital-FS(DFS)*2                  | 5 to 20       | 5 to 20 | 5 to 40 | 5 to 40 | 5 to 100  | 5 to 100  | -         |
| Tungsten Carbide | Standard (STD)                     | 5 to 20       | 5 to 20 | 5 to 40 | 5 to 40 | 5 to 100  | 5 to 100  | -         |
|                  | Minimum Step Punch(MSPP)           | -             | -       | -       | -       | 10 to 60  | -         | -         |
|                  | Minimum Step Die(MSPD)             | -             | -       | -       | -       | 10 to 30  | -         | -         |
|                  | Nozzle Away Standard (STDP01)      | -             | -       | 5 to 10 | 5 to 10 | -         | -         | -         |
|                  | Digital-FS(DFS)*2                  | 5 to 20       | 5 to 20 | 5 to 40 | -       | 5 to 80   | -         | -         |
| Copper           | Standard (STD)                     | -             | -       | 5 to 20 | -       | 5 to 100  | 5 to 100  | 20 to 100 |
| Aluminum         | Standard (STD)                     | -             | -       | -       | -       | 5 to 100  | 5 to 150  | 20 to 250 |
| Graphite         | Standard (STD)                     | -             | -       | -       | -       | 10 to 100 | 10 to 100 | -         |
| PCD              | Standard (STD)                     | -             | -       | -       | -       | 2 to 2    | 2 to 2    | -         |
| CBN              | Standard (STD)                     | -             | -       | -       | -       | 2 to 2    | 2 to 2    | -         |

\* The values in the table indicate the applicable plate thickness.

\* When selecting the conditions on the Automatic 2nd cut screen, each condition will appear as shown below.

- Standard-Punch.....STDP1
- Standard-Die.....STDD1
- Standard.....STD
- Nozzle Away Standard-Punch.....STDPO2
- Nozzle Away Standard-Die.....STDDO2
- Nozzle Away Standard.....STDP01
- Accuracy Priority-Punch.....ACUP
- Accuracy Priority-Die.....ACUD
- Accuracy Priority.....ACU
- Speed Priority.....SPB
- Land machining.....LND
- SL machining.....SL
- PCD.....PCD
- CBN.....CBN
- Minimum Step Punch.....MSPP
- Minimum Step Die.....MSPD
- Digital-FS.....DFS

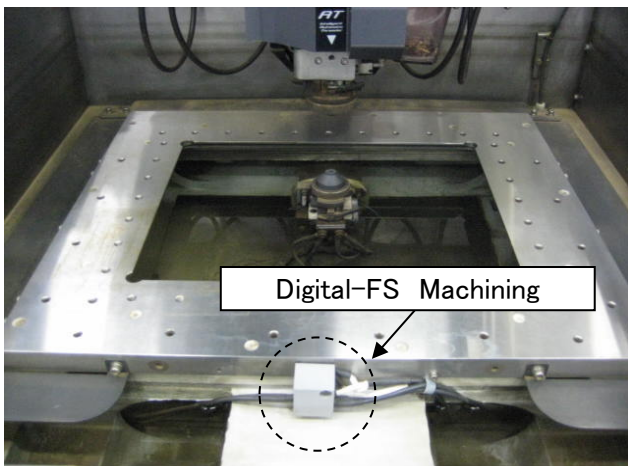
\*1 Angle Taper is an option.

(Machining conditions cannot be searched. See the machining conditions table.)

\*2 Digital-FS is an option.(It is possible machining condition search ,but only applicabl for DFS option.)

## **1-2 Machining conditions**

- Standard conditions (STD•STDP1【Punch】•STDD1【Die】)  
These are the four to seven cut 3  $\mu\text{mRz}$  machining conditions.  
The 2nd and 3rd cut maintain the accuracy, and ultimately improve the surface roughness.
- Accuracy Priority Conditions (ACU•ACUP【Punch】•ACUD【Die】)  
These are the five or six cut 2  $\mu\text{mRz}$  machining conditions which prioritize shape accuracy and the effect of stress.  
Use these conditions when machining shapes with small corners or continuous corners, or when machining shapes which easily become distorted.
- Speed Priority Conditions (SPB)  
These machining conditions prioritize the machining speed. However, due to the susceptibility to the effects of stress, we recommend it for machining simple forms for small items.
- Nozzle Away Standard conditions (STDPO1•STDPO2【Punch】•STDDO2【Die】)  
These are the four cut 3  $\mu\text{mRz}$  machining conditions in Nozzle Away.  
The 2nd and 3rd cut maintain the accuracy, and ultimately improve the surface roughness.
- SL step conditions(SL)  
These machining conditions are used when machining a stepped workpiece.
- Land machining (LND)  
These are the Land machining conditions.
- Minimum Step(MSPP【Punch】•MSPD【Die】)  
These are the four cut 3  $\mu\text{mRz}$  machining conditions.  
The 2nd and 3rd cut maintain the accuracy, and ultimately improve the surface
- Digital-FS conditions (DFS)  
Use this when a fine surface roughness is required when using Digital-FS.



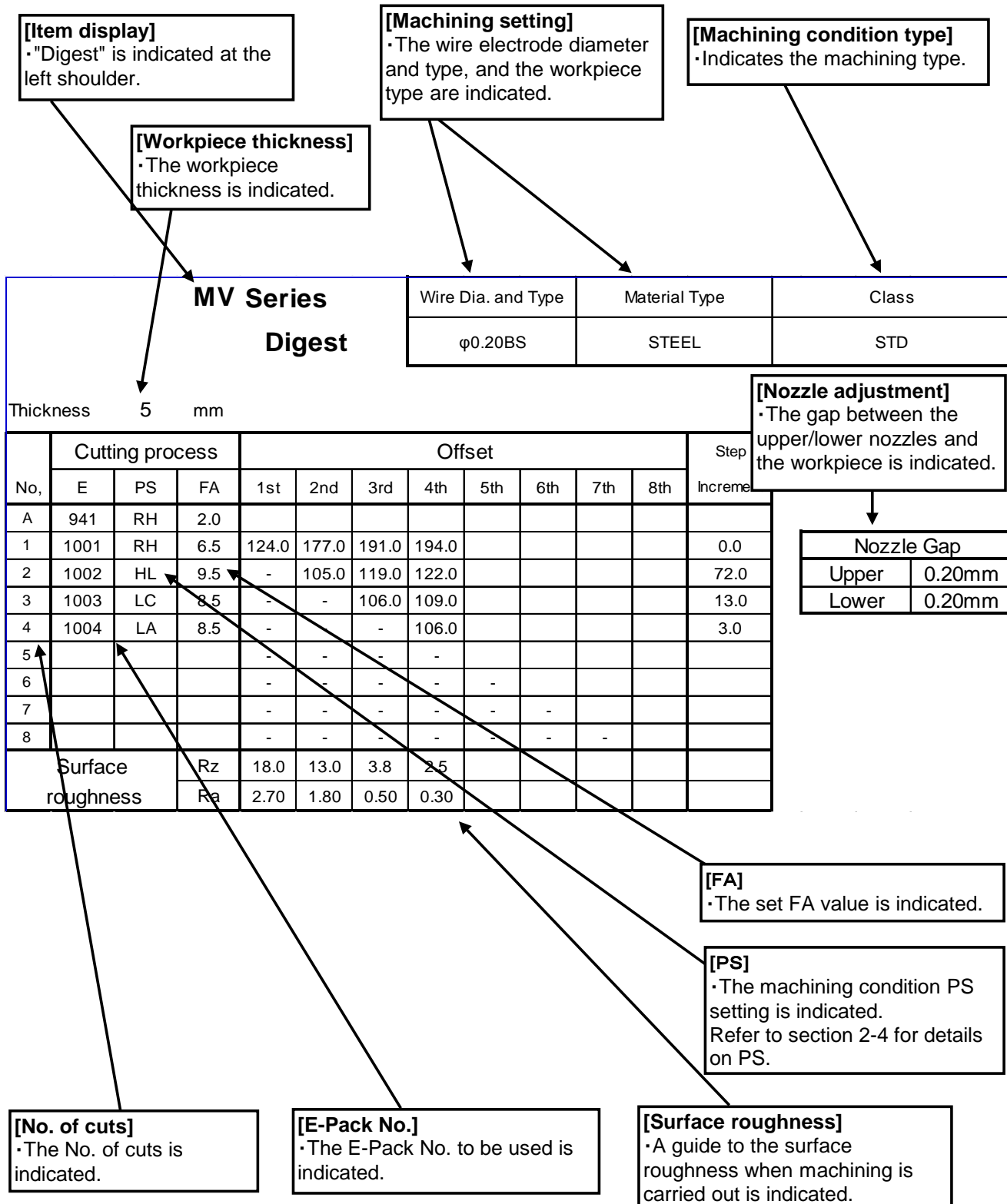
## 2. How to Read the Machining Characteristics Data Table

The machining characteristics data tables include the machining condition digest and machining conditions table.

The basic information required for machining, such as the E-Pack No. and FA, are written in the machining condition digest.

The detailed machining conditions are written in the machining conditions table.

### 2-1 How to Read the Machining Characteristics Data Table (Machining Condition Digest)



## 2-2 How to Read the Machining Characteristics Data Table (Machining Conditions Table)

### [Machining setting]

• The wire electrode diameter and type, workpiece type and thickness are indicated.

### [Item display]

• "Machining Data Sheet" is indicated at the centre.

### [Machining condition type]

• Indicates the machining type.

## MV Series Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

### [Nozzle Gap]

• The gap between the upper/lower nozzles and the workpiece is indicated.

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                    | Skim5 | Skim6 | Skim7 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|
| E-pack Number      | Eno      | 941                   | 1001                  | 1002                  | 1003                     | 1004                     |       |       |       |
| Power Supply       | PS       | RH                    | RH                    | HL                    | LC                       | LA                       |       |       |       |
| Servo              | SV       | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |
| Voltage Open       | Vo       | 7                     | 7                     | 14                    | 12                       | 10                       |       |       |       |
| Power Setting      | IP       | 6.0                   | 7.0                   | 13.0                  | 2.5                      | 2.0                      |       |       |       |
| IP adjust          | ΔIP      | 11                    | 10                    | 12                    |                          |                          |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 8                     | 1                        | 1                        |       |       |       |
| Stabilizer A       | SA       | 3                     | 5                     | 1                     | 1                        | 1                        |       |       |       |
| Stabilizer B       | SB       | 8                     | 8                     | 8                     | 1                        | 1                        |       |       |       |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 4                        | 4                        |       |       |       |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                        | 1                        |       |       |       |
| Voltage Gap        | VG       | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 60.0<br>(58.0 ~ 62.0) | 150.0<br>(148.0 ~ 152.0) | 115.0<br>(113.0 ~ 117.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |
| Digital AE         | DAE      | OFF                   | OFF                   | OFF                   | OFF                      | OFF                      |       |       |       |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 10                       | 10                       |       |       |       |
| Wire Tension       | WT       | 6                     | 8                     | 10                    | 10                       | 10                       |       |       |       |
| WT Adjust          | DWT      |                       |                       |                       |                          |                          |       |       |       |
| (Tension[g])       |          | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                       | 14                       |       |       |       |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                        | 4                        |       |       |       |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |
| Straightness cmp.  | CC       | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |
| Feedrate Address   | FA       | 2.0                   | 6.5                   | 9.5                   | 8.5                      | 8.5                      |       |       |       |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |

### [Machining condition setting notch]

Refer to sections 2-3 and 2-4 for details.

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 124.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 177.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 191.0 | 119.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 194.0 | 122.0 | 109.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 72.0  | 13.0  | 3.0   |       |       |       |       |

### [Display Speed]

• Indicates the machining speed used as a guide during machining.  
• The average machining voltage is adjusted to near this value.

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 9.0 ~ 11.0  | 18.2 ~ 22.2 | 7.7 ~ 8.6   | 7.7 ~ 8.6   |  |  |  |
| Average Voltage Gap  | V   |  | 47 ~ 59     | 92 ~ 105    | 154 ~ 166   | 121 ~ 132   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 600.0       | 401.3       | 220.4       | 151.9       |  |  |  |
| Surface Finish(u m)  | Ry  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 2.97 | 1.62 ~ 1.96 | 0.45 ~ 0.55 | 0.27 ~ 0.33 |  |  |  |

### [Average Machining Voltage]

• Indicates the machining voltage used as a guide during machining.

### [Surface Roughness]

• Indicates a guide to the surface roughness when machining is executed.

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

Version1.1

1- 1

### [Machining conditions table version]

• The machining conditions table version is indicated.



## 2-3 Names of Machining Conditions Setting Notches

|   |            |  |
|---|------------|--|
| E-Pack Number                             | <b>Eno</b> |  |
| Power Selection                           | <b>PS</b>  | .... This switch sets the power supply mode.   |
| Servo                                     | <b>SV</b>  | .... This switch sets the servo mode.  |
| Voltage Open                              | <b>Vo</b>  | .... This switch sets the height of the gap voltage during no-load.  |
| Power Setting                             | <b>IP</b>  | .... This switch sets the size of the peak current that flows the gap.                                       |
| IP Adjustment                             | <b>ΔIP</b> | .... This switch finely adjusts the size of the peak current that flows the gap.                             |
| Off Time                                  | <b>OFF</b> | .... This switch sets the time from when the discharge is completed to when the voltage is applied again.    |
| Stabilizer A                              | <b>SA</b>  | .... This switch determines the machining stability, and is used to finely adjust the current.               |
| Stabilizer B                              | <b>SB</b>  | .... This switch determines the machining stability, and is used to finely adjust the off time.              |
| Stabilizer C                              | <b>SC</b>  | .... This switch is used to stabilize machining during rough machining.                                      |
| Stabilizer E                              | <b>SE</b>  | .... This switch sets the machining stability, and is used particularly for 1st cut machining.               |
| Voltage Gap<br>(Voltage adjustment width) | <b>VG</b>  | .... This switch sets the average machining voltage used as a target value when machining with optimum feed. |
| Fine Machining                            | <b>FM</b>  | .... This switch sets the fine machining mode to ON or OFF.  |
| Digital-AE                                | <b>DAE</b> | .... This switch sets the fine DAE mode to ON or OFF.  |
| Wire Speed                                | <b>WS</b>  | .... This switch sets the wire feedrate.   |
| Wire Tension                              | <b>WT</b>  | .... This switch sets the wire tension.  |
| Pre-Tension                               | <b>PT</b>  | .... This switch sets the wire pretension.   |
| Flow Balance                              | <b>FB</b>  | .... This switch sets the flow balance of the dielectric fluid.  |
| Liquid Quantity                           | <b>LQ</b>  | .... This switch sets the dielectric fluid flow rate.  |
| Liquid Resistivity                        | <b>LR</b>  | .... This switch sets the specific resistivity of the dielectric fluid.                                      |
| Straightness Compensation                 | <b>CC</b>  | .... This switch sets the straightness compensation.   |
| Feedrate Address                          | <b>FA</b>  | .... The setting machining speed required for machining.   |
| Flow Rate (Upper side)                    |            | .... Reference value of dielectric fluid flow rate from upper nozzle.  |
| Flow Rate (Lower side)                    |            | .... Reference value of dielectric fluid flow rate from lower nozzle.  |

|                |   |
|----------------|---|
| Step Increment | .... Offset stepping increment for 1st to 2nd, 2nd to 3rd, etc. |
|----------------|---|

|                           |            |  |
|---------------------------|------------|--|
| Feedrate Cutting (mm/min) | <b>FC</b>  | .... Reference value of the actual machining speed during machining.                                     |
| Average Voltage Gap       | <b>V</b>   | .... Reference value of the actual machining voltage during machining.                                   |
| Average machining speed   | <b>ALF</b> | .... This is a guide to the machining speed for estimating the machining. (Machining distance per hour.) |
| Surface Roughness (μm)    | <b>Rz</b>  | .... Reference value of the machining surface roughness. Unit: μmRz                                      |
|                           | <b>Ra</b>  | .... Reference value of the machining surface roughness. Unit: μmRa                                      |

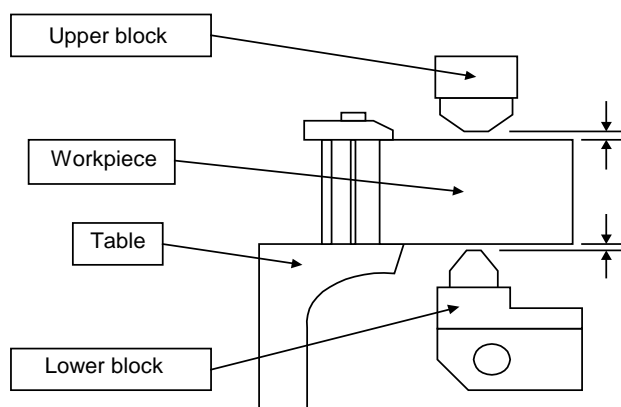
## 2-4 Notch Settings

|                      |  |
|----------------------|--|
| PS : Power Selection | <p>This switch is used to set the power supply mode. There are 9 types, RH,RL,KH,KL,MP,HL,LA,LB,LC.</p> <p>RH, RL, KH, and KL are the rough machining and medium finish machining power supply modes, and are valid at the IP4 to 16 notches. MP and HL are the rough machining and medium finish machining power supply modes, and are valid at the IP4 to 29 notches.</p> <p>LA,LB and LC are the finish machining power supply mode, and is valid at the IP1 to 3 notches.</p>  |
| SV : Servo           | <p>There are three types of switches, NM,SL , used to set the servo mode.</p> <p>NM is mainly used for the rough machining or medium finish machining, and SL are used for finish machining.</p>   |
| Vo : Voltage Open    | <p>Switch to set the height of the gap voltage when no load is applied. Notch has 16 stages (1 to 16). Voltage increases for larger notch number.</p> <p>Use ▲ or ▼ to increase or decrease notch level.</p>   |
| IP : Power Setting   | <p>Switch to set the size of the peak current that flows the gap. Notch has 16 stages (1 to 16). Notches 1 to 3 are for finishing circuit. The range that can be set differs according to the power selection (PS). Refer to the section on PS for details.</p> <p>Current is larger for larger notch numbers and machining speed increases proportionately. Conversely, surface roughness, clearance, etc. increase. Wire breakage occurs frequently if power setting is very high. Power must be set to commensurate with workpiece materials and wire electrode.</p> <p>Use ▲ or ▼ to increase or decrease notch level.</p> |
| ΔIP : IP Adjustment  | <p>Switch to finely adjust the size of the peak current that flows the gap. Notch has 16 stages (1 to 16).</p> <p>The adjusted current will increase when a larger notch number is set, so the machining speed will increase. Conversely, the surface roughness and clearance, etc., will increase. If the power setting is too large, the wire will break easily. This must be set according to the workpiece materials and wire electrode.</p> <p>Use ▲ or ▼ to increase or decrease notch level.</p>  |
| OFF : Off Time       | <p>Switch to set time between end of discharge and application of voltage. When power mode is KH or KL, notch has 1 or 2 notches, and when RH or RL has 20 stages (1 to 20) and LC has 16 stages (1 to 16). The off time shortens when a smaller notch is set, and the machining speed increases in proportion. However, the machining will be unstable, resulting in wire breakage or short-circuits.</p> <p>Use ▲ or ▼ to increase or decrease notch level.</p>  |
| SA : Stabilizer A    | <p>Switch to stabilize the machining state. Notch has 10 stages (1 to 10). The higher the value is, the faster the machining speed will be. However, if too high, wire breakage will occur. Thus, set this according to the wire diameter. The smaller the diameter is, the smaller the setting must be.</p> <p>Use ▲ or ▼ to increase or decrease notch level.</p>  |
| SB : Stabilizer B    | <p>Switch to make the machining more stable. Notch has 20 stages (1 to 20). The higher the value is, the slower the machining speed will be. This must be set according to the material of the workpiece.</p> <p>Use ▲ or ▼ to increase or decrease notch level.</p>   |
| SC : Stabilizer C    | <p>Switch to stabilize machining for finishing circuit. Notch has 7 stages (1 to 7).</p> <p>Use ▲ or ▼ to increase or decrease notch level.</p>  |
| SE : Stabilizer E    | <p>Switch used particularly for 1st cut machining. Notch has 5 stages (1 to 5). Notch 1 is OFF, and notches 2 to 5 are ON. As the value increases (2 → 3 → 4 → 5), the machining speed become slower, but wire will not break as easily.</p> <p>Use ▲ or ▼ to increase or decrease notch level.</p>  |

|                         |   |
|-------------------------|---|
| VG : Voltage Gap        | Switch to set average machining voltage used as a target value to machine with optimum feed. The setting range is 1 to 400.<br>Use ▲ or ▼ to increase or decrease notch level.  |
| FM : Fine Machining     | Switch to set fine machining mode ON or OFF. Switch includes the ON and OFF setting. Set this to ON to attain a minute surface roughness using the PF circuit, and set to OFF when not using this function.<br>This switch can be set to ON when the power selection (PS) is LC.  |
| DAE : Digital AE        | Switch to set the Digital-AE mode ON or OFF. Switch includes the ON and OFF setting. Set this to ON to use the Digital-AE power supply, and OFF when not using this function.   |
| WS : Wire Speed         | Switch to set the wire feedrate. Notch has 18 stages (1 to 18). The higher the value is, the faster the wire feedrate will be.<br>When the machining with the wire processing unit(Optional), please use 9 or more than 9 for WS notch. In case of lower setting than 8, it may cause the wire jamming.                   |
| WT : Wire Tension       | Switch to set the wire tension. Notch has 16 stages (1 to 16). The higher the value is, the stronger the tension will be.<br>Please use WT1~2 only on fine wire specification machine.<br>Use ▲ or ▼ to increase or decrease notch level.   |
| PT : Pre-Tension        | Switch to set the wire pretension. Notch has 16 stages (1 to 16). The higher the value is, the stronger the tension will be.<br>Use ▲ or ▼ to increase or decrease notch level.   |
| FB : Flow Balance       | This switch is used to set the balance of the dielectric fluid discharged from the upper and lower dielectric fluid nozzles. NM, U or L can be selected.<br>Normally, NM is used. Select U to lower the upper nozzle flow rate, L to lower the lower nozzle flow rate.  |
| LQ : Liquid Quantity    | Switch to set dielectric fluid flow rate. Notch has 16 states (1 to 16). The dielectric fluid flow rate will increase as the No. increases. Using the "strong" and "weak" switches on the machine operation panel will set "strong" to notch 14 and "weak" to notch 4.<br>Use ▲ or ▼ to increase or decrease notch level. |
| LR : Liquid Resistivity | Switch to set specific resistivity of dielectric fluid. Notch has 10 stages (1 to 10). The higher the value is, the lower the specific resistivity will be. 1 indicates that the pump is always ON.<br>Use ▲ or ▼ to increase or decrease notch level.  |

## 2-5 Setting the Nozzle and Dielectric Fluid Flow Rate

### 2-5-1 Installing the workpiece

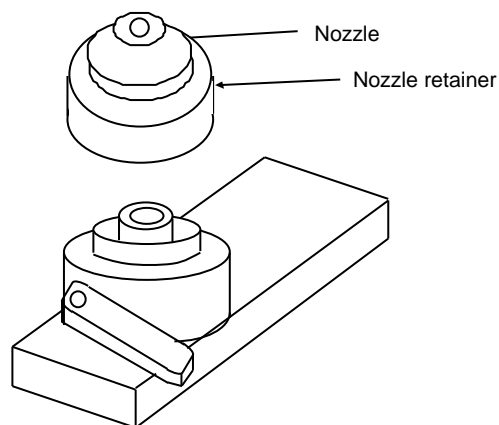


#### Upper clearance setting

Set as follows:  
Standard Accuracy and Accuracy Priority  
conditions: 0.20 mm

#### Lower clearance setting

Set 0.20 mm.



### 2-5-2 Checking the dielectric fluid flow rate

The reference dielectric fluid flow rates for each LQ notch setting are shown below.

(When using  $\varnothing 4.0$  nozzle cap)

Check with water filled up to the upper nozzle with no workpiece set. (Carry out with Z set to 40mm.)

Check the dielectric fluid flow rate with the dielectric fluid flow meter displayed on the MONITOR screen. (See following drawing.)

If the flow rate greatly differs from the values below, contact the service personnel and have the level readjusted.

| LQ notch | Flow rate (L/min) |           |
|----------|-------------------|-----------|
| 1        | 0.0               |           |
| 2        | 0.4               | $\pm 0.3$ |
| 3        | 1.0               | $\pm 0.5$ |
| 4        | 1.4               | $\pm 0.5$ |
| 5        | 1.8               | $\pm 0.5$ |
| 6        | 2.6               | $\pm 0.5$ |
| 7        | 3.4               | $\pm 1.0$ |
| 8        | 4.4               | $\pm 1.0$ |
| 9        | 5.0               | $\pm 1.0$ |
| 10       | 5.8               | $\pm 1.0$ |
| 11       | 7.5               | $\pm 1.0$ |
| 12       | 9.4               | $\pm 1.0$ |
| 13       | 10.0              | or more   |
| 14       | 10.0              | or more   |
| 15       | 10.0              | or more   |
| 16       | 10.0              | or more   |

### **3. Adaptive Control**

Adaptive control is a technology that significantly combines the optimum processes for various machining patterns including complex shape workpiece machining, nozzle separated machining and corner machining.

Adaptive control is configured of the following functions.

**(1) PM control**

Function that prevents wire breakage and controls the machining energy to the optimum state during rough machining.

**(2) CM control**

Function that prevents "corner sagging" and "gouging" that occur at the corner section.

**(3) EM control**

Function that reduces extremely small cavities (often called "dimples") that form at the point (approach point) where machined die shape connects to the approach machining path from the machining start hole.

**(4) OM control**

Function that reduces the shape dimension error at the arc section and linear section.

**(5) BM control**

This function prevents the "notches" and "cracks" that form when machining CBN or PCD material, etc.

**(6) RM control**

"RM" (rough master) is a control function that attempts to prevent corner breakages occurring in rough machining.

**\*The RM switch is constantly kept ON.**

#### **3-1 Machining with PM Control**

##### **3-1-1 What is PM control?**

This is an adaptive control function that prevents wire breakage and controls the machining energy to be optimal during rough machining (during first cut).

**(1) Automatic setting of machining conditions**

The machining conditions are automatically generated when the diameter and material of the wire to be used, the workpiece material and the PM mode are selected. Thus, operations such as selection of the E-Pack conditions per plate thickness and setting of the approach machining conditions are not required.

**(2) Setting of mode to match machining pattern**

The nozzle release, nozzle contact, thin plate and 3D-PM machining modes are prepared to be used according to the machining pattern such as the workpiece shape and setup environment.

**(3) Automatic plate thickness detection (When using nozzle release and thin plate modes)**

The workpiece plate thickness is automatically detected and the machining energy is optimally controlled for each plate thickness. Complicated programming to change the machining conditions according to the changes in the plate thickness is no longer required.

**(4) Wire breakage prevention function**

Breakage of the wire is prevented even during approach machining or stepped machining, and the machining energy is optimally controlled.

**(5) 3D-PM**

Changes in the shape caused by the progress of machining are predicted with an NC program and 3D model using the 1st conditions to provide special control corresponding to the shape. Refer to Chapter 3 of this Instruction Manual for details.

##### **3-1-2 Setting PM control**

PM control is automatically set to the optimum conditions by setting [WORKPIECE THICKNESS CHANGE AMOUNT] on the Automatic 2nd cut screen. This can also be set manually on the "Adaptive Control" screen under the Automatic 2nd cut screen or "Monitor" screen. (The automatically set items can also be confirmed on this screen.)

Refer to "NC OPERATION DISPLAY SCREEN" in the Instruction Manual for details on automatic setting.

### 3-1-3 Applicable ranges of PM control

(1) Wire type and workpiece material

Use the following wire types and workpiece materials during PM control.

Wire types : BS wire ( $\phi 0.2$  to  $\phi 0.3$ )

\* Always use the Mitsubishi-recommended wire.

Workpiece materials : Steel, Tungsten Carbide, Copper, Aluminum

\* 3D-PM is compatible only with steel.

(2) Workpiece plate thickness and taper angle

Always use PM control within the following ranges.

|                |                 | $\phi 0.20$ | $\phi 0.25$                | $\phi 0.30$                |
|----------------|-----------------|-------------|----------------------------|----------------------------|
| Nozzle release | Plate thickness | 5 to 100 mm | 5 to 250 mm                | 20 to 250 mm               |
|                | Taper angle     | 0 to 15°    | 0 to 15°<br>(Up to 100 mm) | 0 to 15°<br>(Up to 100 mm) |
| Nozzle contact | Plate thickness | 5 to 100 mm | 5 to 250 mm                | 20 to 250 mm               |
|                | Taper angle     | 0 to 15°    | 0 to 15°<br>(Up to 100 mm) | 0 to 15°<br>(Up to 100 mm) |
| Thin plate     | Plate thickness | 1 to 25 mm  | 1 to 25mm                  |                            |
|                | Taper angle     | 0 to 15°    | 0 to 15°                   |                            |
| 3D-PM          | Plate thickness | 1 to 100 mm | 1 to 150 mm                |                            |
|                | Taper angle     |             |                            |                            |

### 3-1-4 PM control with wide angle taper specifications (option)

When using PM control with the wide angle taper specifications nozzle, the fluid pressure supplied between the machining pieces will drop compared to when machining with the standard nozzle. Thus, even when the nozzle and workpiece contact, only the same fluid pressure as the nozzle release state will be achieved, so use the nozzle release mode in addition to inputting the maximum taper angle.

**NOTE**

☐ If PM control is used for machining only for machining the taper angle 0 degree, the fluid pressure supplied between the machining pieces will drop, so do not use the wide angle taper specifications.

**NOTE**

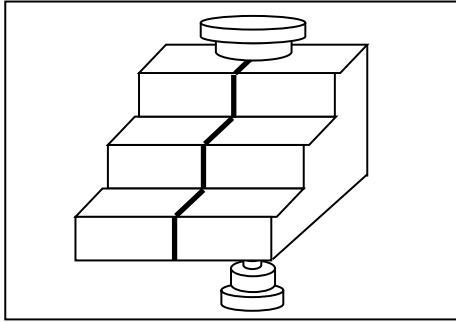
- (1) The application range above may be expanded in the future. When expanded, the application range will be listed in the "Supplement" for the system software, so please refer to that document.
- (2) The above applicable ranges are for submerged machining. When carrying out non-submerged machining with the <Submersible machine>, the effect of PM control will drop, so always use this control with submerged machining.
- (3) PM control is applicable only to the 1st cut conditions.  
PM control turns OFF automatically when the E command in the program is the for the 2nd and following cut. (The PM mode will not change.) However, the PM control will not turn OFF even if the E-Pack for the 2nd or following cut is selected from the screen.
- (4) PM control cannot be used with the cost save mode.
- (5) The workpiece thickness and taper angle that can be machined are limited by the UV axis stroke.  
(The maximum taper angle is 15° for a thickness of 100 mm.)
- (6) When machining from the edge, etc., the fluid supplied to the machining member could drop and the wire could break as compared to when machining inside the workpiece. In this case, adjust the machining speed to the minus side until the machining stabilizes, or lengthen the approach machining distance. Refer to "NC Operation Display Screen" for details.

### 3-1-5 PM mode

#### (1) PM mode selection

Select the PM control machining mode according to the workpiece shape or setup environment.

##### a) Nozzle release mode

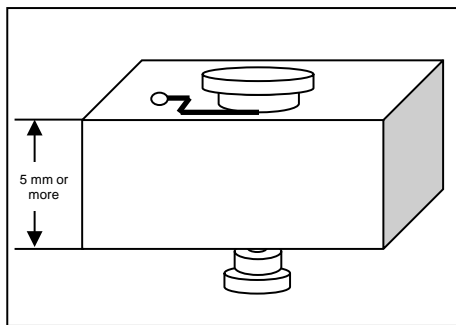


This mode is used when machining workpieces that have changes in the plate thickness (minimum plate thickness is 5 mm or more \*1), such as hollow shapes like pipes or stepped workpieces. This mode is effective when the state of the dielectric fluid is poor such as when biting from the workpiece edges occurs.

In the nozzle release mode, the workpiece plate thickness is automatically detected and the machining conditions are optimally controlled. In places where application of the dielectric fluid is poor, the machining energy is accurately controlled to prevent wire breakage.

\*1: Minimum plate thickness 20 mm or more for  $\phi 0.30$  wire diameter

##### b) Nozzle contact mode



This mode is used when machining plate-shaped workpieces that have no change in the plate thickness and are 5mm or more thicker (\*1).

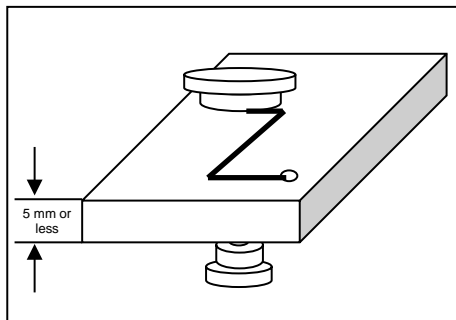
In the nozzle contact mode, contact the dielectric fluid nozzle against the workpiece. (\*2)

\*1: Minimum plate thickness 20 mm or more for  $\phi 0.30$  wire diameter

\*2: Nozzle is 0.15 mm or less from the workpiece.

\*3: If the nozzle contact mode is selected, the workpiece plate thickness must be set in addition to the wire type and workpiece material.

##### c) Thin plate mode

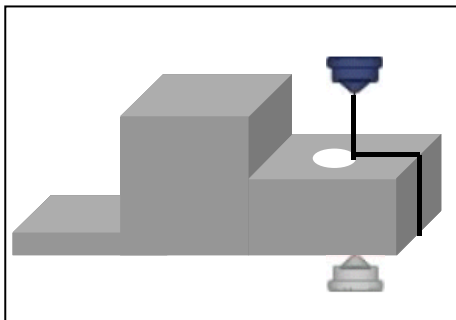


This mode is used when machining thin workpieces that have changes in the plate thickness of 5mm or less (\*1), or when the state of the dielectric fluid is poor such as when the dielectric fluid nozzle cannot be contacted against the workpiece.

The workpiece plate thickness is automatically detected and the machining conditions are optimally controlled even in the thin plate mode.

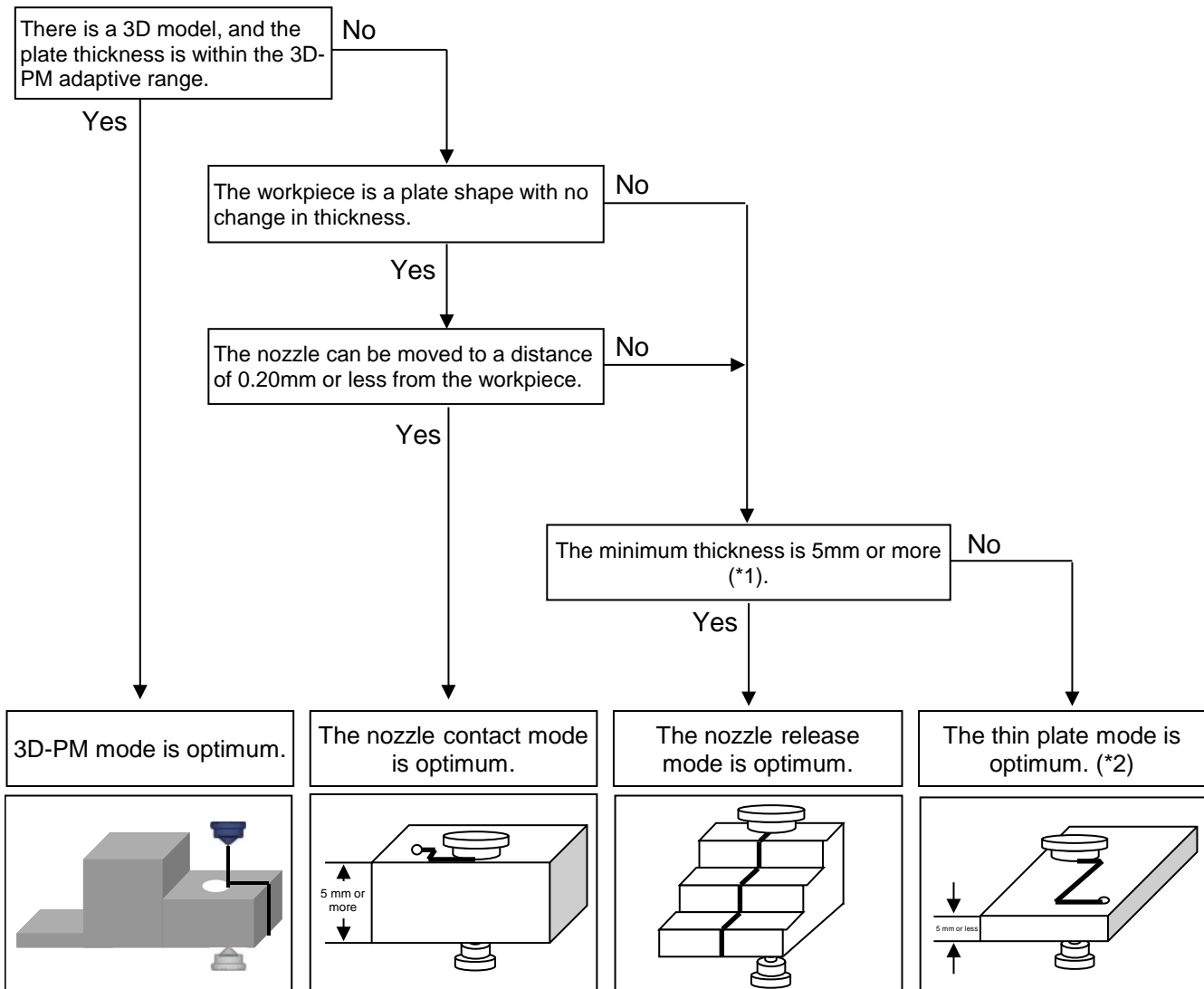
\*1: The thin plate mode cannot be used when using a  $\phi 0.30$  wire.

##### d) 3D-PM mode



This mode is used when there is a 3D model. This mode is effective when machining a workpiece with tap holes or large steps in the path and in which short circuits or wire breakages occur frequently.

## (2) PM mode selection



\*1: Minimum plate thickness 20 mm or more for  $\varnothing 0.30$  wire diameter

\*2: The thin plate mode cannot be used when using a  $\varnothing 0.30$  wire.

\*3: Refer to Chapter 3 of this Instruction Manual for details.



## 3-2 Machining with CM control

CM control is a function that prevents "corner drooping" and "gouging". The "CM-R (corner master R)" used for the first cut, and "CM-S (corner master S)" used for the 2nd and following cuts settings are available.

The MV Series machining conditions are configured on the premise that corner control will be used. Always use corner control particularly when machining small corners. We recommend using it with CM-R ON, and CM-S ON.

### (1) Setting CM-R

CM-R is corner control for rough machining.

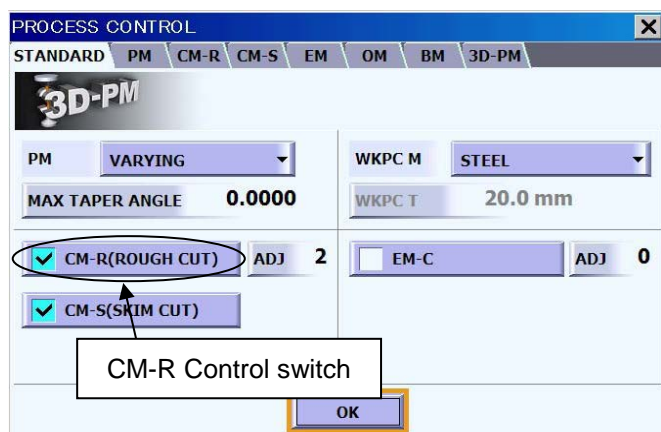
"CM-R" is a function that prevents corner drooping during the 1st cut. This control can be used only in the following cases.

- When the "CM-R (Rough cut)" switch is ON, this function is effective only for the 1st cut conditions in the standard E-Pack supplied from Mitsubishi.
- This function can be used only in the offset mode.

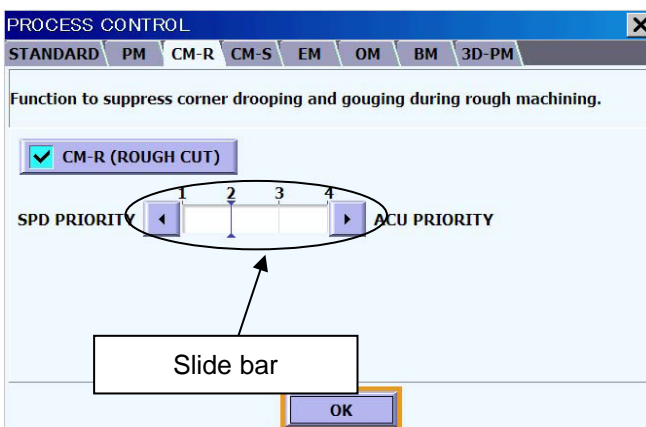
### [Usage Methods]

The control is turned ON and OFF with the switches on the "Process Control" screen. Use the slide bar (see following drawing) on the Process Control screen to adjust the degree of the control. The corner control intensifies when the bar is set to the right, but the machining speed at the corner section will drop. The left end is the 1 notch, and the right end is the 4 notch.

Process Control (Standard screen)



Process Control (Detail screen)

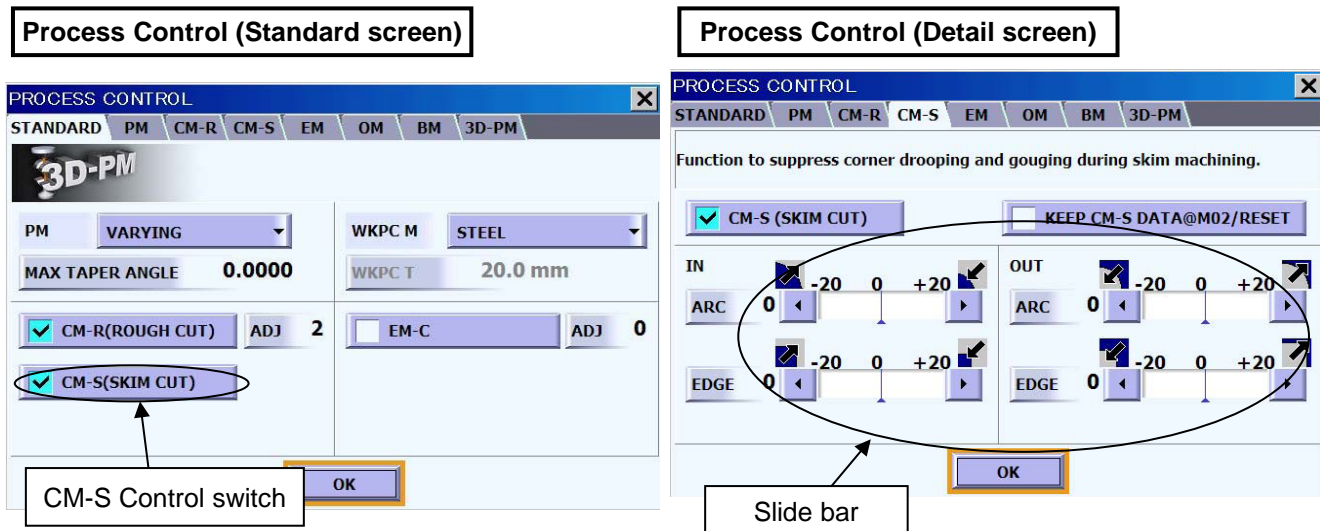


## (2)Setting CM-S

"CM-S" is a function that prevents corner drooping and gouging during the 2nd and following cuts. The speed corresponding to each corner is set automatically.

### [Usage methods (Standard)]

The control is turned ON and OFF with the switches on the "Process Control" screen.  
The degree of the control is set with the slide bar on the Detail screen.



### [Adjusting the slide bar]

#### ■ [CM-S IN ARC]

Set this to improve the accuracy at the arc corner of an in corner.

To the "-" side if the machining amount at the arc corner section of an in corner is "insufficient"

To the "+" side if the machining amount at the arc corner section of an in corner section is "excessive"

#### ■ [CM-S IN EDGE]

Set this to improve the accuracy at the linear corner of an in corner.

To the "-" side if the machining amount at the linear corner section of an in corner is "insufficient"

To the "+" side if the machining amount at the linear corner section of an in corner section is "excessive"

#### ■ [CM-S OUT ARC]

Set this to improve the accuracy at the arc corner of an out corner.

To the "-" side if the machining amount at the arc corner section of an out corner is "insufficient"

To the "+" side if the machining amount at the arc corner section of an out corner section is "excessive"

#### ■ [CM-S OUT EDGE]

Set this to improve the accuracy at the linear corner of an out corner.

To the "-" side if the machining amount at the linear corner section of an out corner is "insufficient"

To the "+" side if the machining amount at the linear corner section of an out corner section is "excessive"

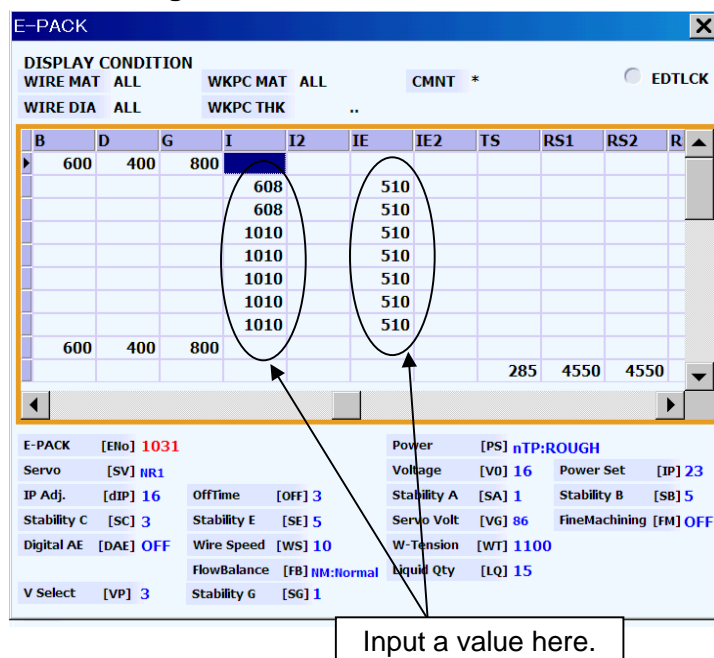
## [Usage methods (Applied) CM-S2]

The degree of the control can be individually adjusted for each E-Pack using the infometer "I" and "IE" in the E-Pack.

I : Parameter which adjusts corner shape.

IE: Parameter which adjusts shape of sharp edge.

### Screen listing E-Pack



Operating points of "I" and "IE" of CM-S"

|    | Control corner R value |          |
|----|------------------------|----------|
|    | In R                   | Out R    |
| I  | 0.0001mm               | 0.0001mm |
| I2 | 1mm                    | 1mm      |

|     | Control open angle value |          |
|-----|--------------------------|----------|
|     | In Edge                  | Out Edge |
| IE  | 90°                      | 90°      |
| IE2 | 165°                     | 165°     |

Four digits are input. The first two digits are the setting coefficient for the in corner, and the last two digits are the setting coefficient for the outer corner.

The setting coefficient can be input in the range of 1 to 99.

The basic value is "1010".

\*1: If no data is input, control will be applied with "1010".

\*2: If IE is not input, IE is controlled with I value.

Infometer "I" ... 00 00

↑ Out corner  
↑  
In corner

Relation of setting coefficient and speed

|            | 1          | Setting coefficient | 99         |
|------------|------------|---------------------|------------|
| In corner  | Speed slow | ←→                  | Speed fast |
| Out corner | Speed slow | ←→                  | Speed fast |

In respect to the in corner, the speed should be slow to avoid contact and to correct the shape. Thus, generally a small value is set. It is also common to set a small value in the same manner when the corner R is small.

In respect to the out corner, the speed should be increased to correct the shape. Thus, a large value is generally set. If the corner R is small, the value may be set smaller in some cases.

## [Usage methods (Applied) CM-S3]

The degree of the control can be individually adjusted for each E-Pack using the infometer "RS1~6" and "ES1~6" in the E-Pack. CM-S3 control range can be adjusted in more detail than CM-2 control.

\*1: This is the E-Pack for finish machining which 42~59 values are input in "Classification C" (Machining class).

"RS1~6" are parameters that adjust the corner shape. The tilt can be adjusted in the intervals that are set by RS 1~6.

"ES1~6" are parameters that adjust the shape at edge corner. ES1~6S setting can be adjusted in the intervals that are set by ES1~6S.

## Screen listing E-Pack

The screenshot shows the E-Pack control interface with the following parameters and values:

| IE2 | TS  | RS1  | RS2  | RS3  | RS4  | RS5  | RS6  | ES1  | ES2 | ES3 | ES4 | ES5 | ES6 |
|-----|-----|------|------|------|------|------|------|------|-----|-----|-----|-----|-----|
|     | 285 | 4550 | 4550 | 4550 | 4550 | 5050 | 5050 | 4040 |     |     |     |     |     |
|     | 90  | 3550 | 4050 | 4550 | 4550 | 5050 | 5050 | 4040 |     |     |     |     |     |
|     | 75  | 3550 | 4550 | 4550 | 4550 | 5050 | 5050 | 5040 |     |     |     |     |     |
|     | 50  | 4550 | 4550 | 4550 | 4550 | 5050 | 5050 | 5040 |     |     |     |     |     |
|     | 30  | 4550 | 4550 | 4550 | 4550 | 5050 | 5050 | 5040 |     |     |     |     |     |
|     | 30  | 5050 | 5050 | 5050 | 5050 | 5050 | 5050 | 5040 |     |     |     |     |     |
|     | 20  | 5050 | 5050 | 5050 | 5050 | 5050 | 5050 | 5040 |     |     |     |     |     |
|     | 285 | 4550 | 4550 | 4550 | 4550 | 5050 | 5050 | 4040 |     |     |     |     |     |

Below the table, there are various control parameters and their values:

- E-PACK [Elo] 1041
- Servo [SV] NR1
- IP Adj. [dIP] 16
- Stability C [SC] 3
- Digital AE [DAE] OFF
- V Select [VP] 3
- OffTime [OFF] 3
- Stability E [SE] 5
- Wire Speed [WS] 10
- FlowBalance [FB] 1
- Stability G [SG] 1
- Power [PS] nTP:ROUGH
- Voltage [V0] 16
- Stability A [SA] 1
- Servo Volt [VG] 86
- W-Tension [WT] 1100
- Power Set [IP] 23
- Stability B [SB] 5
- FineMachining [FM] OFF

An arrow points to the "Input a value here." text box.

Operating points of "RS" and "ES" of CM-S3

|     | Control corner R value |          |
|-----|------------------------|----------|
|     | In R                   | Out R    |
| RS1 | 0.0001mm               | 0.0001mm |
| RS2 | 0.03mm                 | 0.1mm    |
| RS3 | 0.06mm                 | 0.2mm    |
| RS4 | 0.15mm                 | 0.4mm    |
| RS5 | 0.5mm                  | 0.6mm    |
| RS6 | 1mm                    | 1mm      |

|     | Control open angle value |          |
|-----|--------------------------|----------|
|     | In Edge                  | Out Edge |
| ES1 | 90°                      | 90°      |
| ES2 | 105°                     | 105°     |
| ES3 | 120°                     | 120°     |
| ES4 | 135°                     | 135°     |
| ES5 | 150°                     | 150°     |
| ES6 | 165°                     | 165°     |

Four digits are input. The first two digits are the setting coefficient for the in corner, and the last two digits are the setting coefficient for the outer corner.

The setting coefficient can be input in the range of 1 to 99.

The basic value is "5050".

\*2: If no data is input, control will be applied with "5050". (When TS value is input)

\*3: If the values in "RS1" and "ES1" are input, and RS2~6 and ES2~6 are blank, the control will be

applied with the value of "RS1" and "ES1".

\*4: The control is applied with the values which are set in the interval for blank items. The all items should

↑ In corner    ↑ Out corner  
Relation of setting coefficient and speed

|            | 1          | Setting coefficient | 99         |
|------------|------------|---------------------|------------|
| In corner  | Speed slow | ←→                  | Speed fast |
| Out corner | Speed slow | ←→                  | Speed fast |

In respect to the in corner, the speed should be slow to avoid contact and to correct the shape. Thus, generally a small value is set. It is also common to set a small value in the same manner

5°~1°

In respect to the out corner, the speed should be increased to correct the shape. Thus, a large value is generally set. If the corner R is small, the value may be set smaller in some cases.

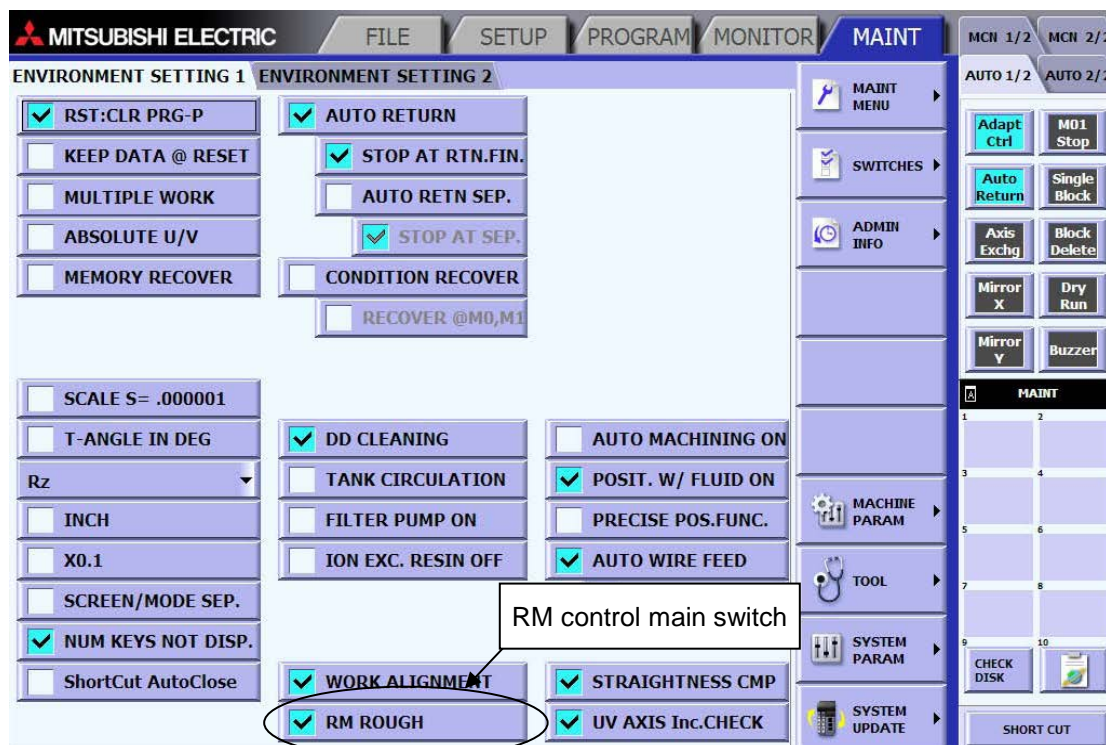
### 3-3 Machining with RM control

"RM" (rough master) is a control function that attempts to prevent corner breakages occurring in rough machining.

\*The RM switch is constantly kept ON.

#### [Usage Methods]

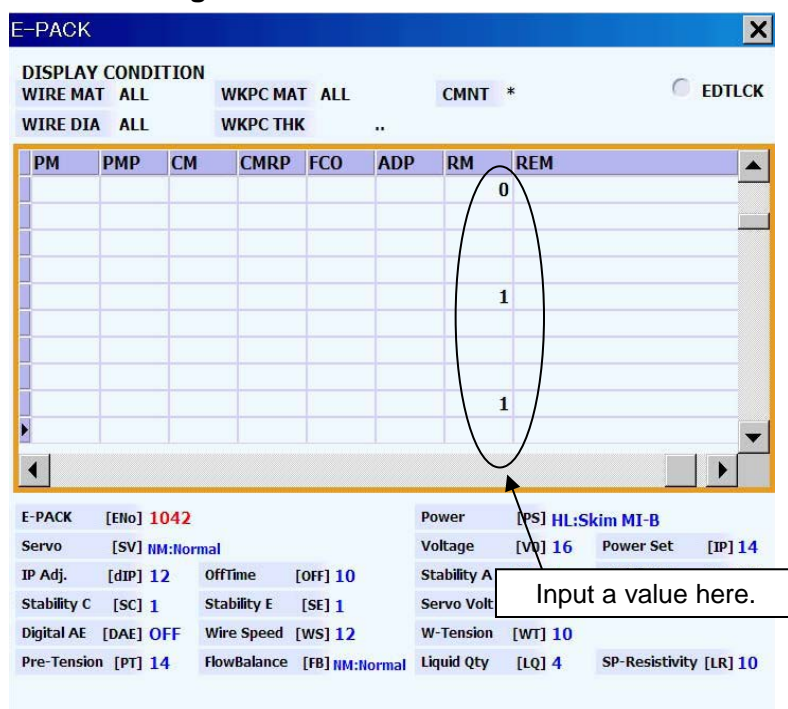
#### Maintenance Screen



ON/OFF can be set for the infometer "RM" in the E-Pack. (Default setting is set to ON.)

**Caution:** If the switch is OFF on the maintenance screen, the function will not work even if the switch is set to ON inside the E-Pack.

#### Screen listing E-Pack



Rough master OFF: 0 (will switch to OFF if left blank or a number 2 or above is entered)

Rough master ON: 1



### 3-4 Machining with EM Control

The EM function reduces the minute concave ("dimple") that occurs at the point (approach point) that connects the machining start hole and approach machining path during die shape machining.

#### (1) Types of EM functions

The EM function includes the EM-condition control and EM-path control. With the EM-condition control, the machining energy is controlled near the approach point. This function can be turned ON/OFF during machining. With EM-path control, the wire electrode path is changed near the approach point. This function must be turned ON or OFF before machining is started. Normally use the EM-condition control.

#### (2) EM setting methods

##### 1) To use EM-condition control

Open the "Process Control" screen from the "Automatic 2nd cut" screen or "MONITOR" screen, and turn the EM-condition control switch ON. This setting cannot be changed during machining, so always set it before starting. Normally, the EM adjustment bar should be set to 0.

##### 2) To use EM-path control

Open the "Process Control" screen from the "Automatic 2nd cut" screen or "MONITOR" screen, and turn the EM-condition control switch ON. Also set the path variation amount. This setting cannot be changed during machining and must be set before starting.

#### (3) Finely adjusting the approach point shape

The machining shape at the approach point can be finely adjusted with the following method.

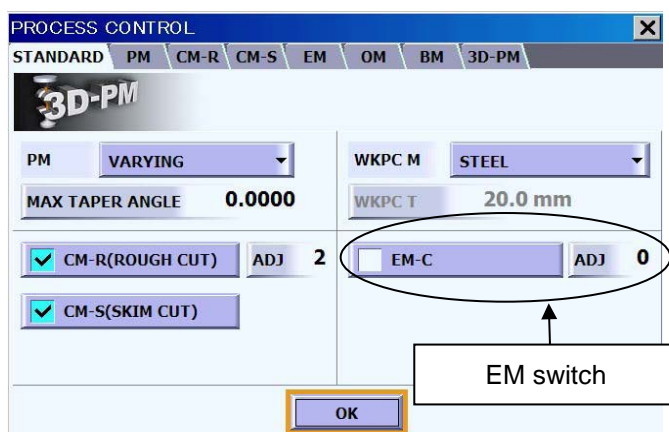
##### 1) To use EM-condition control

When the EM adjustment bar on the "Process Control" screen is set to the + side, the shape will become more convex, and when set to the - side, the shape will become more concave.

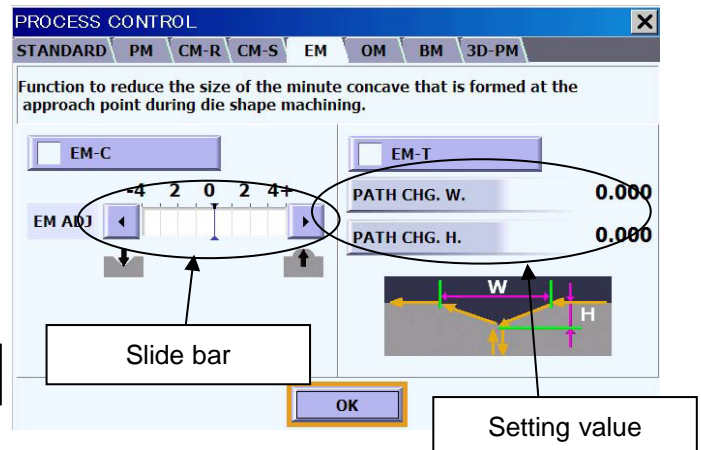
##### 2) To use EM-path control

Of the path variation amounts set on the "Process Control" screen, if the width is set larger, the control will be applied on a wide range. If the height is set larger, a stronger control will be applied. Refer to "Chapter 6 Program EM-Orbit control" in the Instruction Manual for details.

**Process Control (Standard screen)**



**Process Control (Detail screen)**



#### NOTE

- 1) When machining a shape other than a die shape, such as a punch shape or automatic coreless machining, set the EM-condition control switch and EM-path control switch OFF.
- 2) The EM-condition control is applied in the finishing conditions.
- 3) The EM function is applied only during the offset mode.

### 3-5 Machining with OM control

OM control reduces the shape dimension error at the arc section and linear section by controlling the machining amount when machining an arc.

#### (1) Setting OM

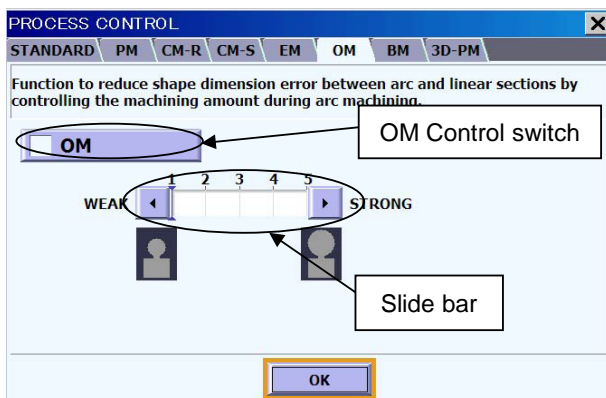
Open the "Process Control" screen from the "Automatic 2nd cut" screen or "MONITOR" screen, and turn the OM switch ON.

#### (2) Finely adjusting the OM control

OM control can be finely adjusted with the following method.

When the OM adjustment bar on the "Process Control" screen is set to a larger value (1 to 5), the machining amount during arc machining will decrease. When set to a smaller value, the machining amount during arc machining will increase.

#### Process Control (Detail screen)



### 3-6 Machining with BM control

BM control is a function that suppresses the "notches" and "cracks" that form when machining "CBN" or "PCD" material, etc. Control is applied on all movement blocks based on the parameters set on the BM CONTROL CONDITION SETTING screen. This control is applied only in the following cases.

- When the "BM CONTROL" switch is ON
- When the ADAPTIVE CONTROL SYSTEM (\*1) switch is OFF
- In the Automatic 2nd cut mode (\*2) with the condition search "INCOMPLETE"

\*1 Adaptive control refers to PM, CM-R, CM-S, EM and OM.

\*2 To cancel the Automatic 2nd cut mode, search for a program other than L9000 on the MONITOR screen.

\*3 Does not function when offset is applied.

#### (1) Setting BM control

BM control is set by opening the "PARAMETER SETTINGS" on the "Automatic 2nd cut" screen or "MONITOR" screen.

Refer to the "NC Operation and Display Screen Section" for details on setting the BM control condition settings.

- 1) Turn ON the "BM Control" switch on the "PROCESS CONTROL" screen.
- 2) Set the machining condition (Ea) used at the head of one block, and the distance (La) for using that condition.
- 3) Set the machining condition (Eb) used at the end of one block, and the distance (Lb) for using that condition.  
(On the Automatic 2nd cut screen, these setting areas are located below the "BM Control")
- 4) Confirm that the adaptive control system switch, for PM, CM-R, etc., is OFF.
- 5) When the program is started, BM control will be applied on all movement blocks.

#### Process Control (Detail screen)

The screenshot shows the "PROCESS CONTROL" window with tabs for STANDARD, PM, CM-R, CM-S, EM, OM, BM, and 3D-PM. The BM tab is selected. Below the tabs, a text box explains the function: "Function to suppress 'chips' and 'cracks' that appear while machining 'CBN', 'PCD', or other material." A "BM CONTROL" switch is shown, which is currently off. A diagram illustrates the "1 BLOCK" machining process, divided into "PRE SECTION" and "POST SECTION". Below the diagram, there are input fields for "Pre:LENGTH" (0.000), "Post:LENGTH" (0.000), "Pre:E No." (0), and "Post:E No." (0). An "OK" button is at the bottom.

| Pre:LENGTH | 0.000 | Post:LENGTH | 0.000 |
|------------|-------|-------------|-------|
| Pre:E No.  | 0     | Post:E No.  | 0     |



## NOTE

- \*1 The "BM Control" switch and BM control conditions cannot be changed while the program is running.
- \*2 When the BM control switch is turned ON, "BM unavailable" will appear if there are settings which cannot be set with BM control (refer to "3-4-6 (1) What is BM Control?".)
- BM unavailable**
- \*3 When machining with BM control, do not turn the ADAPTIVE CONTROL SYSTEM switch ON with the screen or NC program while the program is running.
- \*4 Conditions (distance, machining conditions) that do not form "notches" or "cracks" differ according to the workpiece material and shape. Create the appropriate values and machining conditions, and set them on the BM CONDITION SETTING screen.
- \*5 For Ea and Eb, input the machining condition NO. registered in the control unit. BM control will not function if an unregistered number is set.
- \*6 If an E No. is designated when using machining ON control during return to wire break point, The E conditions designated with the machining ON control will be applied while returning to the wire break point. BM control is applied after returning to the wire break point.
- \*7 The following operations will take place if an axis magnification or figure magnification is set.

|                      | Setting example                | Operation example   |
|----------------------|--------------------------------|---|
| Each axis scale      | When 2.000 is input for X axis | BM control will be applied with a double distance for the X axis at the pre-interval and post-interval.                             |
| Figure magnification | When 2.000 is input            | BM control is applied with the set value for the pre-interval and post-interval without being affected by the figure magnification. |

- \*8 The BM control estimate cannot be viewed on the ESTIMATE RESULTS screen.
- \*9 Changing the machining condition No. or notch from MONITOR screen during BM control  
The changed conditions are valid only in the changed interval. The conditions set on the BM CONTROL screen are applied when the movement shifts to the next interval or next block. To change the conditions in each interval, change the current conditions as well as the corresponding machining condition notch on the MACHINING CONDITION screen.

## 4. Optimizing Machining Conditions

### 4-1 1st Cut Machining Section

(Problem)

(Countermeasures)

Frequent wire breakage during 1st cut

- 1) Lower IP by 1 notch.
- 2) Raise VG by 3 to 5 notches.
- 3) Raise SB by 1 to 3 notches.

Frequent short circuit during 1st cut

- 1) Raise VG by 2 to 8 notches.
- 2) Raise SE by 1 notch.

Machining speed is slow during 1st cut

- 1) Lower SB by 1 to 3 notches.
- 2) Lower VG by 2 to 5 notches.
- 3) Raise IP by 1 notch.

Wire breaks in collection pipe

- 1) Lower WT by 1 to 2 notches.
- 2) Confirm that the lower roller rotates smoothly.

Changing of 1st cut conditions according to machining material and setup conditions

When machining SKD-11, 40t with  $\phi 0.2$  wire

Note) This table is a guideline.

| Machining material         | Quenched SKD-11 | Raw SKD-11 | NAK/HPM | SK-3/S45C | Stainless steel | Aluminum | Copper | Copper tungsten | Graphite |
|----------------------------|-----------------|------------|---------|-----------|-----------------|----------|--------|-----------------|----------|
| Voltage open Vo (Notch)    | 7               |            |         |           |                 |          |        |                 | +4       |
| Power setting IP (Notch)   | 9               |            |         | -1        |                 | -1       | -1     | -1              | -2       |
| Off time OFF (Notch)       | 3               |            |         |           |                 |          |        |                 |          |
| Stabilizer A SA (Notch)    | 5               |            |         |           |                 |          |        | -1              | -2       |
| Stabilizer B SB (Notch)    | 4               | +2         | +2      | +2        | +2              | +2       |        |                 | +4       |
| Stabilizer E SE (Notch)    | 4               |            |         |           |                 |          |        |                 |          |
| Wire tension WT (Notch)    | 8               |            |         |           |                 |          |        |                 | -1       |
| Voltage gap VG (V)         | 50              |            |         |           | +2              | +5       | +10    |                 | +15      |
| Actual machining speed (%) | 100             | 90         | 90      | 85        | 85              | 200      | 85     | 50              | 40       |

| Setup conditions           | Standard | Upper nozzle separated | Lower nozzle separated | Both nozzles separated | Stepped workpiece | 3 deg. Taper | 5 deg. Taper | 10 deg. Taper | 15 deg. Taper |
|----------------------------|----------|------------------------|------------------------|------------------------|-------------------|--------------|--------------|---------------|---------------|
| Voltage open Vo (Notch)    | 7        |                        |                        |                        |                   |              |              |               |               |
| Power setting IP (Notch)   | 9        | -1                     | -1                     | -1                     | -2                |              |              | -2            | -2            |
| Off time OFF (Notch)       | 3        |                        |                        |                        |                   |              |              |               |               |
| Stabilizer A SA (Notch)    | 5        |                        |                        | -1                     | -1                |              |              |               | -1            |
| Stabilizer B SB (Notch)    | 4        | +2                     | +2                     | +2                     | +2                | +2           | +2           | +3            | +3            |
| Stabilizer E SE (Notch)    | 4        |                        |                        |                        |                   |              |              |               |               |
| Wire tension WT (Notch)    | 8        |                        |                        |                        |                   | -1           | -1           | -2            | -3            |
| Voltage gap VG (V)         | 50       |                        |                        |                        | +4                |              | +5           | +5            | +10           |
| Actual machining speed (%) | 100      | 80                     | 80                     | 60                     | 60                | 90           | 85           | 70            | 50            |

Note) Wire breakage can be reduced by raising the SE notch from 1 → 2 → 3 → 4 → 5.

## 4-2 Finish Machining Section

### Improvement of machining accuracy (For punch shape)

#### (Problem)

Center is concave



- 1) Raise 2nd machining speed

#### (Countermeasures)

[When SV notch is set to NM]

- Lower 2nd VG by 2 to 5 notches
- Lower 2nd SB by 1 to 2 notches

[When SV notch is set to SL]

- Raise FA by 0.5 to 1.0

Shape is concave and  
there is a difference in  
upper/lower dimensions



- 1) Raise 2nd machining speed
- 2) Raise wire feedrate

- Same as above
- Raise WS by 2 to 4 notches

There is a difference in  
upper/lower dimensions



- 1) Raise wire feedrate
- 2) Increase step increment between  
1st and 2nd

- Raise WS by 2 to 4 notches
- Increase the approach amount  
by 2 to 7  $\mu\text{m}$

Bullet shaped and  
there is a difference in  
upper/lower  
dimensions



- 1) Decrease step increment between  
1st and 2nd

- Decrease the approach amount  
by 2 to 10  $\mu\text{m}$

Center is swollen



- 1) Lower 2nd machining speed

[When SV notch is set to NM]

- Raise 2nd VG by 2 to 5 notches
- Raise 2nd SB by 1 to 2 notches

[When SV notch is set to SL]

- Lower FA by 0.5 to 1.0

### When lines are formed on machining surface

#### When short circuit occurs

- (1) Decrease step increment between IP: 4 and IP:3 by 1 to 5  $\mu\text{m}$
- (2) Raise IP: 4 VG by 1 to 5 notches
- (3) Raise IP: 3 Vo by 2 to 6 notches

When the SV notch is set to NM, raise VG by 10 to 20 V.

When the SV notch is set to SL, lower FA by 1.0 to 2.0.

- During thick plate (60mm or more) machining with the upper/lower nozzles separated, increase LQ for the 2nd and following cuts by 1 to 2 notches.  
(To prevent short circuits and speed drops at IP: 3 or less.)

### **4-3 Nozzle Separated Machining Section**

When sampling the machining conditions, the upper and lower nozzle gap is set with the values given in the machining conditions table. If the nozzle is separated by more than those values, refer to the following countermeasure and change the conditions.

#### **For 1st cut**

If the nozzle is separated from the workpiece during 1st cut, the dielectric fluid will not be applied suitably resulting in wire breakages or short circuits. Thus, PM should be used when the nozzle is separated. Change the conditions as shown below when using the standard conditions.

| (Problem)                                | (Countermeasures)  |
|--|--|
| 1) Wire breaks frequently during 1st cut | 1) Lower IP by 1 notch<br>2) Increase VG by 3 to 5 notches<br>3) Increase SB by 1 to 3 notches |
| 2) Short-circuits occur during 1st cut   | 1) Increase VG by 2 to 8 notches<br>2) Increase SE by 1 notch                                  |

#### **For finish machining**

During finish machining, if the nozzle is separated, the reactionary force of the electrical discharge will cause the wire to separate from the workpiece easily and cause the machining speed to increase. When this occurs, the finish dimensions could increase, the shape bulge at the middle, and a short-circuit could occur when finishing.

| (Problem)   | (Countermeasures)  |
|---|--|
| 1) The finish dimension is large                  | 1) Shift the offset by the error amount on one side  |
| 2) The shape is bulging or a short-circuit occurs | 1) Adjust VG so that the machining speed is the same as the speed given in the machining conditions table (Increase VG by 2 to 10 notches) |

## 4-4 Correcting the Upper/lower Dimension Difference

If the upper/lower dimension difference cannot be corrected with the method explained in section 4-2, correct by using the straightness compensation function.

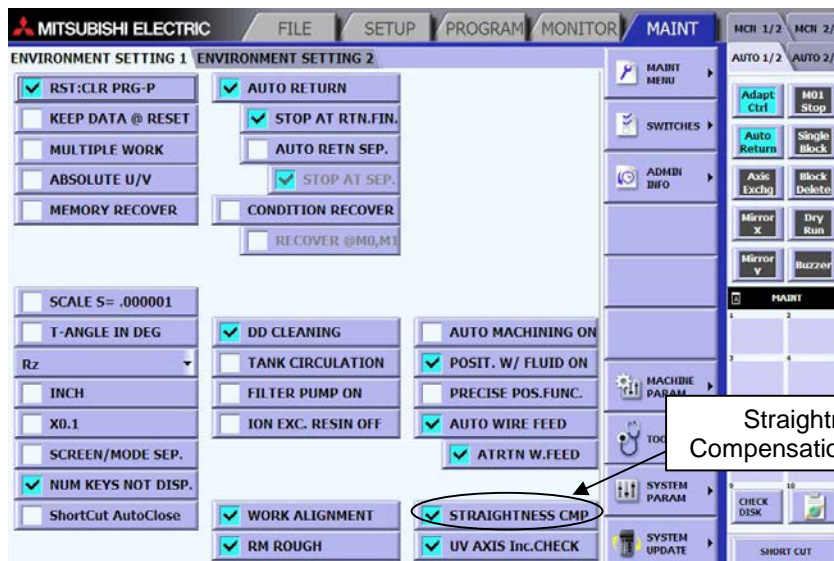
The straightness compensation function automatically carries out a small amount of taper machining using simple settings.

\* **Straightness compensation is usually ON.**

### **CAUTION!!**

1) The straightness compensation will not function during taper machining or upper/lower random shape machining.

### Maintenance screen



### 4-4-1 Executing the straightness compensation function

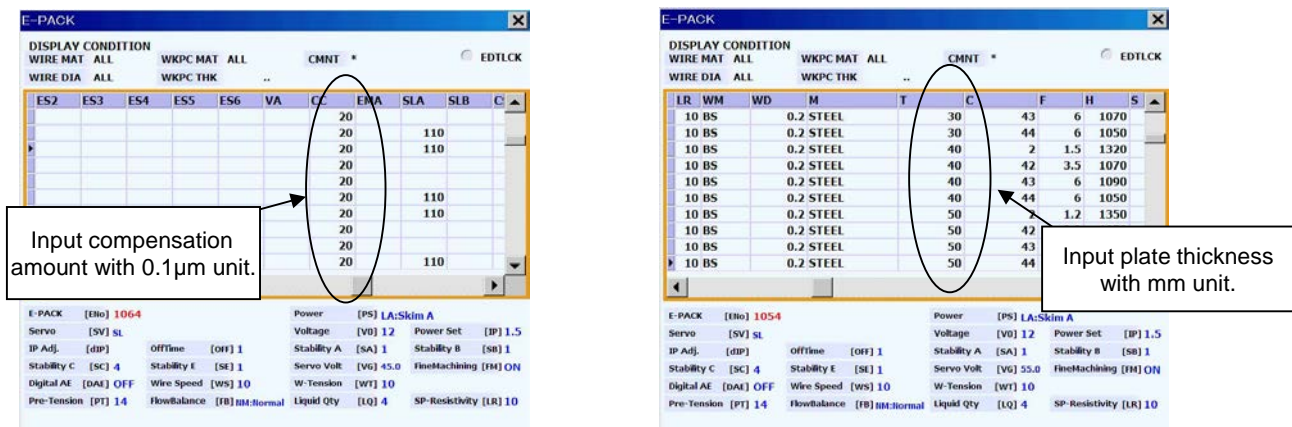
The following settings must be made to correctly use the straightness compensation function.

- 1) The STRAIGHTNESS COMPENSATION switch must be checked. (See above diagram.)
- 2) The compensation data must be input in infometer "CC" of the machining conditions to be used.
- 3) The workpiece thickness data must be input in infometer "T" of the machining conditions to be used.
- 4) Taper indexing must be completed.
- 5) Z1 and Z5 must be set with the PROGRAM or TAPER INDEXING screen.
- 6) The offset command (G41 or G42) must be issued in the program.

If the above settings have been made, the straightness compensation will be applied automatically when machining is started.

When the straightness compensation function is activated, the U or V axis will operate during machining. Operation of the straightness compensation function can be confirmed with the movement of the UV axes.

### Screen listing E-Pack



\*The input method is the same for the 0.1 μm mode.

#### 4-4-2 Setting the infometer

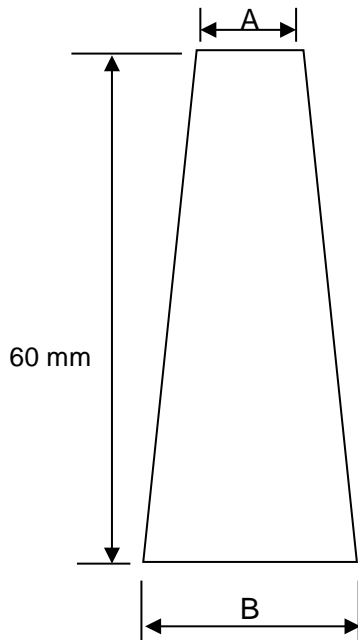
Infometer "T" : Input the workpiece thickness.

Infometer "CC" : Input the compensation amount (one-side) as a value multiplied by 10.

For example, if the machining results are as shown below when machining a 60mm punch shape, input the following:

Infometer "T" : 60

Infometer "CC" : 10



#### Calculating infometer "CC"

- 1) Calculate the upper/lower dimension difference (both sides).
- 2) Calculate the upper/lower dimension difference (one-side).
- 3) Multiple the value by 10.

Example (For shape shown on left)

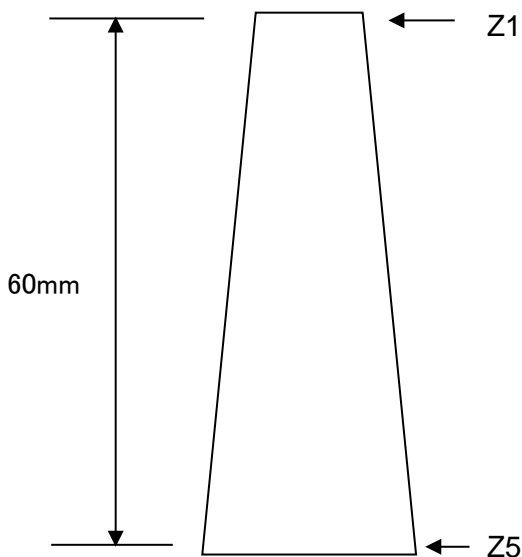
A=9.998mm

B=10.000mm

- 1) ...  $10.000 - 9.998 = 0.002$  mm  
The upper/lower dimension difference (both sides) is 2  $\mu\text{m}$ .
- 2) ...  $2 \div 2 = 1$   
The upper/lower dimension difference (one-side) is 1  $\mu\text{m}$ .
- 3) ...  $1 \times 10 = 10$   
The infometer "CC" value is "10".

\* The infometer "CC" value may be a minus value when machining a die shape.

#### 4-4-3 Setting Z1 and Z5



#### Setting Z1 and Z5

Designate the Z1 and Z5 positions as shown on the left.

Z1 (program dimension height)

... top of workpiece

Z5 (random shape designation height)

... bottom of workpiece

If the workpiece is directly placed on the table, input as follows:

Z1=60.

Z5=0.

Refer to Chapter 2 Basic Operations, Taper Machining in the Instruction Manual for details on taper indexing.

#### **NOTE**

Input the CC data for all conditions from rough machining to final finishing.

**5-1 ø0.20 Wire**  
**Machining Characteristics Data**

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | STDP1 |

Thickness 5 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 1001            | RH | 6.5 | 120.0  | 177.0 | 193.0 | 195.0 |     |     |     |     | 0.0       |
| 2                 | 1002            | HL | 9.5 | -      | 105.0 | 121.0 | 123.0 |     |     |     |     | 72.0      |
| 3                 | 1003            | LC | 8.5 | -      | -     | 108.0 | 110.0 |     |     |     |     | 13.0      |
| 4                 | 1004            | LA | 8.5 | -      | -     | -     | 107.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 1011            | RH | 5.5 | 118.0  | 171.0 | 189.0 | 193.0 |     |     |     |     | 0.0       |
| 2                 | 1012            | HL | 7.5 | -      | 101.0 | 119.0 | 123.0 |     |     |     |     | 70.0      |
| 3                 | 1013            | LC | 8.0 | -      | -     | 106.0 | 110.0 |     |     |     |     | 13.0      |
| 4                 | 1014            | LA | 8.0 | -      | -     | -     | 105.0 |     |     |     |     | 5.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 1021            | RH | 3.0 | 126.0  | 166.0 | 185.0 | 189.0 |     |     |     |     | 0.0       |
| 2                 | 1022            | HL | 5.5 | -      | 101.0 | 120.0 | 124.0 |     |     |     |     | 65.0      |
| 3                 | 1023            | LC | 6.0 | -      | -     | 107.0 | 111.0 |     |     |     |     | 13.0      |
| 4                 | 1024            | LA | 6.0 | -      | -     | -     | 106.0 |     |     |     |     | 5.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | STDP1 |

Thickness 30 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 1031            | RH | 2.2 | 131.0  | 169.0 | 187.0 | 190.0 |     |     |     |     | 0.0       |
| 2                 | 1032            | HL | 4.5 | -      | 104.0 | 122.0 | 125.0 |     |     |     |     | 65.0      |
| 3                 | 1033            | LC | 6.0 | -      | -     | 109.0 | 112.0 |     |     |     |     | 13.0      |
| 4                 | 1034            | LA | 6.0 | -      | -     | -     | 106.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 1041            | RH | 1.5 | 136.0  | 173.0 | 188.0 | 192.0 |     |     |     |     | 0.0       |
| 2                 | 1042            | HL | 3.5 | -      | 108.0 | 123.0 | 127.0 |     |     |     |     | 65.0      |
| 3                 | 1043            | LC | 6.0 | -      | -     | 110.0 | 114.0 |     |     |     |     | 13.0      |
| 4                 | 1044            | LA | 6.0 | -      | -     | -     | 107.0 |     |     |     |     | 7.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 1051            | RH | 1.2 | 138.0  | 173.0 | 188.0 | 191.0 |     |     |     |     | 0.0       |
| 2                 | 1052            | HL | 3.2 | -      | 108.0 | 123.0 | 126.0 |     |     |     |     | 65.0      |
| 3                 | 1053            | LC | 5.0 | -      | -     | 110.0 | 113.0 |     |     |     |     | 13.0      |
| 4                 | 1054            | LA | 5.0 | -      | -     | -     | 106.0 |     |     |     |     | 7.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | STDP1 |

Thickness 60 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 1061            | RH | 1.0 | 140.0  | 173.0 | 189.0 | 192.0 |     |     |     |     | 0.0       |
| 2                 | 1062            | HL | 3.0 | -      | 108.0 | 124.0 | 127.0 |     |     |     |     | 65.0      |
| 3                 | 1063            | LC | 4.5 | -      | -     | 110.0 | 113.0 |     |     |     |     | 14.0      |
| 4                 | 1064            | LA | 5.0 | -      | -     | -     | 106.0 |     |     |     |     | 7.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 1071            | RH | 0.9 | 141.0  | 171.0 | 188.0 | 191.0 |     |     |     |     | 0.0       |
| 2                 | 1072            | HL | 2.7 | -      | 106.0 | 123.0 | 126.0 |     |     |     |     | 65.0      |
| 3                 | 1073            | LC | 4.5 | -      | -     | 110.0 | 113.0 |     |     |     |     | 13.0      |
| 4                 | 1074            | LA | 5.0 | -      | -     | -     | 107.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 1081            | RH | 0.8 | 143.0  | 170.0 | 187.0 | 191.0 |     |     |     |     | 0.0       |
| 2                 | 1082            | HL | 2.5 | -      | 105.0 | 122.0 | 126.0 |     |     |     |     | 65.0      |
| 3                 | 1083            | LC | 4.5 | -      | -     | 110.0 | 114.0 |     |     |     |     | 12.0      |
| 4                 | 1084            | LA | 5.0 | -      | -     | -     | 108.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | STDP1 |

Thickness 90 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 1091            | RH | 0.7 | 143.0  | 170.0 | 186.0 | 190.0 |     |     |     |     | 0.0       |
| 2                 | 1092            | HL | 2.2 | -      | 105.0 | 121.0 | 125.0 |     |     |     |     | 65.0      |
| 3                 | 1093            | LC | 4.5 | -      | -     | 109.0 | 113.0 |     |     |     |     | 12.0      |
| 4                 | 1094            | LA | 4.5 | -      | -     | -     | 107.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 1101            | RH | 0.7 | 143.0  | 169.0 | 184.0 | 189.0 |     |     |     |     | 0.0       |
| 2                 | 1102            | HL | 2.0 | -      | 104.0 | 119.0 | 124.0 |     |     |     |     | 65.0      |
| 3                 | 1103            | LC | 4.5 | -      | -     | 107.0 | 112.0 |     |     |     |     | 12.0      |
| 4                 | 1104            | LA | 4.5 | -      | -     | -     | 106.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No,               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 5mm                | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                    | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 1001                  | 1002                  | 1003                     | 1004                     |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 14                    | 12                       | 10                       |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 13.0                  | 2.5                      | 2.0                      |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                          |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 1                        | 1                        |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                        |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 8                     | 8                     | 1                        | 1                        |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                        |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                        |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 60.0<br>(58.0 ~ 62.0) | 150.0<br>(148.0 ~ 152.0) | 115.0<br>(113.0 ~ 117.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                      |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       | 10                       |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                        |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 6.5                   | 9.5                   | 8.5                      | 8.5                      |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 120.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 177.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 193.0 | 121.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 195.0 | 123.0 | 110.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 72.0  | 13.0  | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 9.0 ~ 11.0  | 18.2 ~ 22.2 | 7.7 ~ 8.6   | 7.7 ~ 8.6   |  |  |  |
| Average Voltage Gap  | V   |  | 47 ~ 59     | 57 ~ 67     | 154 ~ 166   | 121 ~ 132   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 600.0       | 401.3       | 220.4       | 151.9       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 10mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                    | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 1011                  | 1012                  | 1013                     | 1014                     |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                       | 10                       |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 14.0                  | 3.0                      | 2.0                      |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                          |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 1                        | 1                        |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                        |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 1                        | 1                        |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                        |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                        |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 65.0<br>(63.0 ~ 67.0) | 155.0<br>(153.0 ~ 157.0) | 110.0<br>(108.0 ~ 112.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                      |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       | 10                       |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                        |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 5.5                   | 7.5                   | 8.0                      | 8.0                      |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 118.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 171.0 | 101.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 189.0 | 119.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 193.0 | 123.0 | 110.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 13.0  | 5.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 6.1 ~ 7.4   | 14.0 ~ 17.2 | 7.3 ~ 8.2   | 7.3 ~ 8.1   |  |  |  |
| Average Voltage Gap  | V   |  | 37 ~ 49     | 62 ~ 72     | 159 ~ 169   | 115 ~ 127   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 405.0       | 282.7       | 175.8       | 127.3       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 20mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 1021                  | 1022                  | 1023                     | 1024                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                       | 10                    |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 8.0                   | 14.0                  | 3.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 8                     | 1                        | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 42.0<br>(39.0 ~ 45.0) | 65.0<br>(63.0 ~ 67.0) | 120.0<br>(118.0 ~ 122.0) | 75.0<br>(73.0 ~ 77.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 15                    | 15                    | 15                       | 15                    |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 3.0                   | 5.5                   | 6.0                      | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 126.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 166.0 | 101.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 185.0 | 120.0 | 107.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 189.0 | 124.0 | 111.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  | 5.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 4.4 ~ 5.4   | 9.6 ~ 11.8  | 6.0 ~ 6.5   | 6.0 ~ 6.5   |  |  |  |
| Average Voltage Gap  | V   |  | 37 ~ 49     | 62 ~ 72     | 124 ~ 136   | 81 ~ 93     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 294.0       | 201.7       | 131.1       | 97.2        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 30mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 1031                  | 1032                  | 1033                     | 1034                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                       | 10                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 8.0                   | 14.0                  | 3.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 9                     | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 9                     | 1                        | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 46.0<br>(43.0 ~ 49.0) | 68.0<br>(66.0 ~ 70.0) | 116.0<br>(114.0 ~ 118.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                       | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.2                   | 4.5                   | 6.0                      | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 169.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 187.0 | 122.0 | 109.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 190.0 | 125.0 | 112.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.1 ~ 3.7   | 6.7 ~ 8.3   | 5.5 ~ 6.0   | 5.4 ~ 6.1   |  |  |  |
| Average Voltage Gap  | V   |  | 37 ~ 49     | 65 ~ 75     | 118 ~ 130   | 75 ~ 87     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 204.0       | 140.4       | 99.8        | 77.4        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 40mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 1041                  | 1042                  | 1043                     | 1044                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                       | 10                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 10                    | 1                        | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(47.0 ~ 53.0) | 70.0<br>(68.0 ~ 72.0) | 112.0<br>(110.0 ~ 114.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                       | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.5                   | 3.5                   | 6.0                      | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 136.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 173.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 188.0 | 123.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 192.0 | 127.0 | 114.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  | 7.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.7 ~ 2.1   | 3.9 ~ 4.8   | 5.4 ~ 6.0   | 5.5 ~ 6.1   |  |  |  |
| Average Voltage Gap  | V   |  | 37 ~ 49     | 67 ~ 77     | 112 ~ 124   | 70 ~ 81     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 114.0       | 79.3        | 64.4        | 54.3        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 50mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                  | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 943                   | 1051                  | 1052                  | 1053                   | 1054                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                     | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                     | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                     | 10                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                    | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                        |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                      | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                      | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                    | 1                      | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                      | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                      | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 44.0<br>(41.0 ~ 47.0) | 68.0<br>(66.0 ~ 70.0) | 98.0<br>(96.0 ~ 100.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                     | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                    | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                     | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                     | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                     | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                     | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                      | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                     | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                     | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.2                   | 3.2                   | 5.0                    | 5.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                    | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                    | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 138.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 173.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 188.0 | 123.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 191.0 | 126.0 | 113.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  | 7.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.6 ~ 2.0   | 3.3 ~ 4.1   | 5.0 ~ 5.6   | 5.1 ~ 5.7   |  |  |  |
| Average Voltage Gap  | V   |  | 36 ~ 47     | 65 ~ 75     | 100 ~ 112   | 60 ~ 72     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 108.0       | 72.7        | 59.1        | 50.0        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 60mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 943                   | 1061                  | 1062                  | 1063                  | 1064                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                    | 10                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 38.0<br>(35.0 ~ 41.0) | 60.0<br>(58.0 ~ 62.0) | 85.0<br>(83.0 ~ 87.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.0                   | 3.0                   | 4.5                   | 5.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 140.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 173.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 189.0 | 124.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 192.0 | 127.0 | 113.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 14.0  | 7.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.5 ~ 1.9   | 2.8 ~ 3.5   | 4.7 ~ 5.2   | 4.7 ~ 5.2   |  |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 46     | 57 ~ 67     | 89 ~ 101    | 51 ~ 62     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 102.0       | 66.2        | 54.2        | 45.8        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 70mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 944                   | 1071                  | 1072                  | 1073                  | 1074                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 13                    | 11                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 55.0<br>(53.0 ~ 57.0) | 65.0<br>(63.0 ~ 67.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.9                   | 2.7                   | 4.5                   | 5.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 141.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 171.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 188.0 | 123.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 191.0 | 126.0 | 113.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.2 ~ 1.7   | 2.6 ~ 3.3   | 4.8 ~ 5.3   | 4.6 ~ 5.2   |  |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 47     | 52 ~ 62     | 85 ~ 103    | 50 ~ 61     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 87.0        | 58.3        | 48.9        | 41.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 80mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 944                   | 1081                  | 1082                  | 1083                  | 1084                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 14                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 42.0<br>(39.0 ~ 45.0) | 47.0<br>(45.0 ~ 49.0) | 65.0<br>(63.0 ~ 67.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.8                   | 2.5                   | 4.5                   | 5.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 143.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 170.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 187.0 | 122.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 191.0 | 126.0 | 114.0 | 108.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 12.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.0 ~ 1.2   | 2.5 ~ 3.1   | 5.0 ~ 5.5   | 4.6 ~ 5.1   |  |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 48     | 44 ~ 54     | 81 ~ 93     | 50 ~ 61     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 66.0        | 47.4        | 41.2        | 36.1        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 90mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 945                   | 1091                  | 1092                  | 1093                  | 1094                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 14                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 44.0<br>(41.0 ~ 47.0) | 42.0<br>(40.0 ~ 44.0) | 60.0<br>(58.0 ~ 62.0) | 35.0<br>(33.0 ~ 37.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.7                   | 2.2                   | 4.5                   | 4.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 143.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 170.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 186.0 | 121.0 | 109.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 190.0 | 125.0 | 113.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 12.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.0   | 2.5 ~ 3.1   | 4.5 ~ 5.0   | 4.4 ~ 4.7   |  |  |  |
| Average Voltage Gap  | V   |  | 38 ~ 49     | 39 ~ 49     | 71 ~ 83     | 43 ~ 54     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 54.0        | 40.9        | 35.7        | 31.6        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 100mm              | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 945                   | 1101                  | 1102                  | 1103                  | 1104                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 14                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 46.0<br>(43.0 ~ 49.0) | 37.0<br>(35.0 ~ 39.0) | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.7                   | 2.0                   | 4.5                   | 4.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 143.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 169.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 184.0 | 119.0 | 107.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 189.0 | 124.0 | 112.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 12.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 0.6 ~ 0.8   | 2.6 ~ 3.1   | 4.1 ~ 4.6   | 4.2 ~ 4.3   |  |  |  |
| Average Voltage Gap  | V   |  | 41 ~ 52     | 34 ~ 44     | 62 ~ 73     | 38 ~ 49     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 42.0        | 33.7        | 29.9        | 26.7        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | STDD1 |

Thickness 5 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 11901           | RH | 6.5 | 124.0  | 180.0 | 193.0 | 196.0 |     |     |     |     | 0.0       |
| 2                 | 11902           | HL | 9.5 | -      | 108.0 | 121.0 | 124.0 |     |     |     |     | 72.0      |
| 3                 | 11903           | LC | 8.5 | -      | -     | 108.0 | 111.0 |     |     |     |     | 13.0      |
| 4                 | 11904           | LA | 8.5 | -      | -     | -     | 108.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 11911           | RH | 5.5 | 121.0  | 173.0 | 190.0 | 195.0 |     |     |     |     | 0.0       |
| 2                 | 11912           | HL | 7.5 | -      | 103.0 | 120.0 | 125.0 |     |     |     |     | 70.0      |
| 3                 | 11913           | LC | 8.0 | -      | -     | 107.0 | 112.0 |     |     |     |     | 13.0      |
| 4                 | 11914           | LA | 8.0 | -      | -     | -     | 107.0 |     |     |     |     | 5.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 11921           | RH | 3.0 | 127.0  | 169.0 | 186.0 | 190.0 |     |     |     |     | 0.0       |
| 2                 | 11922           | HL | 5.5 | -      | 104.0 | 121.0 | 125.0 |     |     |     |     | 65.0      |
| 3                 | 11923           | LC | 6.0 | -      | -     | 108.0 | 112.0 |     |     |     |     | 13.0      |
| 4                 | 11924           | LA | 6.0 | -      | -     | -     | 107.0 |     |     |     |     | 5.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | STDD1 |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 11931           | RH | 2.2 | 129.0  | 173.0 | 188.0 | 191.0 |     |     |     |     | 0.0       |
| 2                 | 11932           | HL | 4.5 | -      | 108.0 | 123.0 | 126.0 |     |     |     |     | 65.0      |
| 3                 | 11933           | LC | 6.0 | -      | -     | 110.0 | 113.0 |     |     |     |     | 13.0      |
| 4                 | 11934           | LA | 6.0 | -      | -     | -     | 107.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 11941           | RH | 1.5 | 132.0  | 177.0 | 190.0 | 193.0 |     |     |     |     | 0.0       |
| 2                 | 11942           | HL | 3.5 | -      | 112.0 | 125.0 | 128.0 |     |     |     |     | 65.0      |
| 3                 | 11943           | LC | 6.0 | -      | -     | 112.0 | 115.0 |     |     |     |     | 13.0      |
| 4                 | 11944           | LA | 6.0 | -      | -     | -     | 108.0 |     |     |     |     | 7.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 11951           | RH | 1.2 | 135.0  | 175.0 | 188.0 | 191.0 |     |     |     |     | 0.0       |
| 2                 | 11952           | HL | 3.2 | -      | 110.0 | 123.0 | 126.0 |     |     |     |     | 65.0      |
| 3                 | 11953           | LC | 5.0 | -      | -     | 110.0 | 113.0 |     |     |     |     | 13.0      |
| 4                 | 11954           | LA | 5.0 | -      | -     | -     | 106.0 |     |     |     |     | 7.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | STDD1 |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 11961           | RH | 1.0 | 138.0  | 174.0 | 187.0 | 191.0 |     |     |     |     | 0.0       |
| 2                 | 11962           | HL | 3.0 | -      | 109.0 | 122.0 | 126.0 |     |     |     |     | 65.0      |
| 3                 | 11963           | LC | 4.5 | -      | -     | 108.0 | 112.0 |     |     |     |     | 14.0      |
| 4                 | 11964           | LA | 5.0 | -      | -     | -     | 105.0 |     |     |     |     | 7.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 11971           | RH | 0.9 | 137.0  | 174.0 | 186.0 | 190.0 |     |     |     |     | 0.0       |
| 2                 | 11972           | HL | 2.7 | -      | 109.0 | 121.0 | 125.0 |     |     |     |     | 65.0      |
| 3                 | 11973           | LC | 4.5 | -      | -     | 108.0 | 112.0 |     |     |     |     | 13.0      |
| 4                 | 11974           | LA | 5.0 | -      | -     | -     | 106.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 11981           | RH | 0.8 | 137.0  | 175.0 | 185.0 | 189.0 |     |     |     |     | 0.0       |
| 2                 | 11982           | HL | 2.5 | -      | 110.0 | 120.0 | 124.0 |     |     |     |     | 65.0      |
| 3                 | 11983           | LC | 4.5 | -      | -     | 108.0 | 112.0 |     |     |     |     | 12.0      |
| 4                 | 11984           | LA | 5.0 | -      | -     | -     | 106.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | STDD1 |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 11991           | RH | 0.7 | 140.0  | 175.0 | 185.0 | 189.0 |     |     |     |     | 0.0       |
| 2                 | 11992           | HL | 2.2 | -      | 110.0 | 120.0 | 124.0 |     |     |     |     | 65.0      |
| 3                 | 11993           | LC | 4.5 | -      | -     | 108.0 | 112.0 |     |     |     |     | 12.0      |
| 4                 | 11994           | LA | 4.5 | -      | -     | -     | 106.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 12001           | RH | 0.7 | 143.0  | 175.0 | 185.0 | 189.0 |     |     |     |     | 0.0       |
| 2                 | 12002           | HL | 2.0 | -      | 110.0 | 120.0 | 124.0 |     |     |     |     | 65.0      |
| 3                 | 12003           | LC | 4.5 | -      | -     | 108.0 | 112.0 |     |     |     |     | 12.0      |
| 4                 | 12004           | LA | 4.5 | -      | -     | -     | 106.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 5mm                | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                    | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 11901                 | 11902                 | 11903                    | 11904                    |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 14                    | 12                       | 10                       |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 13.0                  | 2.5                      | 2.0                      |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                          |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 1                        | 1                        |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                        |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 8                     | 8                     | 1                        | 1                        |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                        |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                        |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 65.0<br>(63.0 ~ 67.0) | 150.0<br>(148.0 ~ 152.0) | 115.0<br>(113.0 ~ 117.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                      |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       | 10                       |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                        |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 6.5                   | 9.5                   | 8.5                      | 8.5                      |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 124.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 180.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 193.0 | 121.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 196.0 | 124.0 | 111.0 | 108.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 72.0  | 13.0  | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 9.0 ~ 11.0  | 18.2 ~ 22.2 | 7.7 ~ 8.6   | 7.7 ~ 8.6   |  |  |  |
| Average Voltage Gap  | V   |  | 47 ~ 59     | 62 ~ 72     | 154 ~ 166   | 121 ~ 132   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 600.0       | 401.3       | 220.4       | 151.9       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 10mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                    | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 11911                 | 11912                 | 11913                    | 11914                    |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                       | 10                       |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 14.0                  | 3.0                      | 2.0                      |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                          |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 1                        | 1                        |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                        |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 1                        | 1                        |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                        |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                        |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 70.0<br>(68.0 ~ 72.0) | 155.0<br>(153.0 ~ 157.0) | 110.0<br>(108.0 ~ 112.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                      |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       | 10                       |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                        |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 5.5                   | 7.5                   | 8.0                      | 8.0                      |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 121.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 173.0 | 103.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 190.0 | 120.0 | 107.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 195.0 | 125.0 | 112.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 13.0  | 5.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 6.1 ~ 7.4   | 14.0 ~ 17.2 | 7.3 ~ 8.2   | 7.3 ~ 8.1   |  |  |  |
| Average Voltage Gap  | V   |  | 37 ~ 49     | 67 ~ 77     | 159 ~ 169   | 115 ~ 127   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 405.0       | 282.7       | 175.8       | 127.3       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 20mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 11921                 | 11922                 | 11923                    | 11924                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                       | 10                    |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 8.0                   | 14.0                  | 3.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 1                        | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 42.0<br>(39.0 ~ 45.0) | 70.0<br>(68.0 ~ 72.0) | 120.0<br>(118.0 ~ 122.0) | 75.0<br>(73.0 ~ 77.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 15                    | 15                    | 15                       | 15                    |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 3.0                   | 5.5                   | 6.0                      | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 127.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 169.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 186.0 | 121.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 190.0 | 125.0 | 112.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  | 5.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 4.4 ~ 5.4   | 9.6 ~ 11.8  | 6.0 ~ 6.5   | 6.0 ~ 6.5   |  |  |  |
| Average Voltage Gap  | V   |  | 37 ~ 49     | 67 ~ 77     | 124 ~ 136   | 81 ~ 93     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 294.0       | 201.7       | 131.1       | 97.2        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 30mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 11931                 | 11932                 | 11933                    | 11934                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                       | 10                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 8.0                   | 14.0                  | 3.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 9                     | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 9                     | 1                        | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 46.0<br>(43.0 ~ 49.0) | 73.0<br>(71.0 ~ 75.0) | 116.0<br>(114.0 ~ 118.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                       | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.2                   | 4.5                   | 6.0                      | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 129.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 173.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 188.0 | 123.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 191.0 | 126.0 | 113.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.1 ~ 3.7   | 6.7 ~ 8.3   | 5.5 ~ 6.0   | 5.4 ~ 6.1   |  |  |  |
| Average Voltage Gap  | V   |  | 37 ~ 49     | 70 ~ 80     | 118 ~ 130   | 75 ~ 87     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 204.0       | 140.4       | 99.8        | 77.4        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 40mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 11941                 | 11942                 | 11943                    | 11944                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                       | 10                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 10                    | 1                        | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(47.0 ~ 53.0) | 75.0<br>(73.0 ~ 77.0) | 102.0<br>(100.0 ~ 104.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                       | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.5                   | 3.5                   | 6.0                      | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 177.0 | 112.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 190.0 | 125.0 | 112.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 193.0 | 128.0 | 115.0 | 108.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  | 7.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.7 ~ 2.1   | 3.9 ~ 4.8   | 5.4 ~ 6.0   | 5.5 ~ 6.1   |  |  |  |
| Average Voltage Gap  | V   |  | 37 ~ 49     | 72 ~ 82     | 112 ~ 124   | 70 ~ 81     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 114.0       | 79.3        | 64.4        | 54.3        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 50mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 943                   | 11951                 | 11952                 | 11953                 | 11954                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                    | 10                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 44.0<br>(41.0 ~ 47.0) | 65.0<br>(63.0 ~ 67.0) | 88.0<br>(86.0 ~ 90.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.2                   | 3.2                   | 5.0                   | 5.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 175.0 | 110.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 188.0 | 123.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 191.0 | 126.0 | 113.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  | 7.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.6 ~ 2.0   | 3.3 ~ 4.1   | 5.0 ~ 5.6   | 5.1 ~ 5.7   |  |  |  |
| Average Voltage Gap  | V   |  | 36 ~ 47     | 70 ~ 80     | 100 ~ 112   | 60 ~ 72     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 108.0       | 72.7        | 59.1        | 50.0        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 60mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 943                   | 11961                 | 11962                 | 11963                 | 11964                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                    | 10                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 38.0<br>(35.0 ~ 41.0) | 55.0<br>(53.0 ~ 57.0) | 75.0<br>(73.0 ~ 77.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.0                   | 3.0                   | 4.5                   | 5.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 138.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 174.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 187.0 | 122.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 191.0 | 126.0 | 112.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 14.0  | 7.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.5 ~ 1.9   | 2.8 ~ 3.5   | 4.7 ~ 5.2   | 4.7 ~ 5.2   |  |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 46     | 62 ~ 72     | 89 ~ 101    | 51 ~ 62     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 102.0       | 66.2        | 54.2        | 45.8        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 70mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 944                   | 11971                 | 11972                 | 11973                 | 11974                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 13                    | 11                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 48.0<br>(46.0 ~ 50.0) | 70.0<br>(68.0 ~ 72.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.9                   | 2.7                   | 4.5                   | 5.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 137.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 174.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 186.0 | 121.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 190.0 | 125.0 | 112.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.2 ~ 1.7   | 2.6 ~ 3.3   | 4.8 ~ 5.3   | 4.6 ~ 5.2   |  |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 47     | 57 ~ 67     | 85 ~ 103    | 50 ~ 61     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 87.0        | 58.3        | 48.9        | 41.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 80mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 944                   | 11981                 | 11982                 | 11983                 | 11984                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 14                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 42.0<br>(39.0 ~ 45.0) | 42.0<br>(40.0 ~ 44.0) | 65.0<br>(63.0 ~ 67.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.8                   | 2.5                   | 4.5                   | 5.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 137.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 175.0 | 110.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 185.0 | 120.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 189.0 | 124.0 | 112.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 12.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.0 ~ 1.2   | 2.5 ~ 3.1   | 5.0 ~ 5.5   | 4.6 ~ 5.1   |  |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 48     | 49 ~ 59     | 81 ~ 93     | 50 ~ 61     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 66.0        | 47.4        | 41.2        | 36.1        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 90mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 945                   | 11991                 | 11992                 | 11993                 | 11994                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 14                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 44.0<br>(41.0 ~ 47.0) | 42.0<br>(40.0 ~ 44.0) | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.7                   | 2.2                   | 4.5                   | 4.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 140.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 175.0 | 110.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 185.0 | 120.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 189.0 | 124.0 | 112.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 12.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.0   | 2.5 ~ 3.1   | 4.5 ~ 5.0   | 4.4 ~ 4.7   |  |  |  |
| Average Voltage Gap  | V   |  | 38 ~ 49     | 44 ~ 54     | 71 ~ 83     | 43 ~ 54     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 54.0        | 40.9        | 35.7        | 31.6        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 100mm              | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 945                   | 12001                 | 12002                 | 12003                 | 12004                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 14                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 46.0<br>(43.0 ~ 49.0) | 42.0<br>(40.0 ~ 44.0) | 55.0<br>(53.0 ~ 57.0) | 35.0<br>(33.0 ~ 37.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.7                   | 2.0                   | 4.5                   | 4.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 143.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 175.0 | 110.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 185.0 | 120.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 189.0 | 124.0 | 112.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 12.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 0.6 ~ 0.8   | 2.6 ~ 3.1   | 4.1 ~ 4.6   | 4.2 ~ 4.3   |  |  |  |
| Average Voltage Gap  | V   |  | 41 ~ 52     | 39 ~ 49     | 62 ~ 73     | 38 ~ 49     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 42.0        | 33.7        | 29.9        | 26.7        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.20BS            | STEEL         | STDPO2 |

Thickness 5 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 16001           | RH | 4.0 | 132.0  | 191.0 | 212.0 | 215.0 | 217.0 |     |     |     | 0.0       |
| 2                 | 16002           | RH | 7.0 | -      | 108.0 | 129.0 | 132.0 | 134.0 |     |     |     | 83.0      |
| 3                 | 16003           | LC | 7.5 | -      | -     | 107.0 | 110.0 | 112.0 |     |     |     | 22.0      |
| 4                 | 16004           | LC | 7.5 | -      | -     | -     | 107.0 | 109.0 |     |     |     | 3.0       |
| 5                 | 16005           | LC | 7.0 | -      | -     | -     | -     | 106.0 |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 6.0   | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 0.80  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 16011           | RH | 3.0 | 127.0  | 185.0 | 199.0 | 201.0 | 203.0 |     |     |     | 0.0       |
| 2                 | 16012           | RH | 6.5 | -      | 107.0 | 121.0 | 123.0 | 125.0 |     |     |     | 78.0      |
| 3                 | 16013           | LC | 7.5 | -      | -     | 106.0 | 108.0 | 110.0 |     |     |     | 15.0      |
| 4                 | 16014           | LC | 7.0 | -      | -     | -     | 106.0 | 108.0 |     |     |     | 2.0       |
| 5                 | 16015           | LC | 6.5 | -      | -     | -     | -     | 105.0 |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 6.0   | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 0.80  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 16021           | RH | 2.4 | 131.0  | 173.0 | 189.0 | 192.0 | 194.0 |     |     |     | 0.0       |
| 2                 | 16022           | RH | 4.0 | -      | 105.0 | 121.0 | 124.0 | 126.0 |     |     |     | 68.0      |
| 3                 | 16023           | LC | 7.0 | -      | -     | 104.0 | 107.0 | 109.0 |     |     |     | 17.0      |
| 4                 | 16024           | LC | 7.0 | -      | -     | -     | 104.0 | 106.0 |     |     |     | 3.0       |
| 5                 | 16025           | LC | 6.0 | -      | -     | -     | -     | 105.0 |     |     |     | 1.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 6.0   | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 0.80  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.20BS            | STEEL         | STDPO2 |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 16031           | RH | 1.6 | 133.0  | 170.0 | 187.0 | 201.0 | 203.0 | 204.0 |     |     | 0.0       |
| 2                 | 16032           | RH | 3.3 | -      | 106.0 | 123.0 | 137.0 | 139.0 | 140.0 |     |     | 64.0      |
| 3                 | 16033           | RH | 2.8 | -      | -     | 105.0 | 119.0 | 121.0 | 122.0 |     |     | 18.0      |
| 4                 | 16034           | LC | 6.5 | -      | -     | -     | 105.0 | 107.0 | 108.0 |     |     | 14.0      |
| 5                 | 16035           | LC | 6.5 | -      | -     | -     | -     | 105.0 | 106.0 |     |     | 2.0       |
| 6                 | 16036           | LC | 6.5 | -      | -     | -     | -     | -     | 104.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 16041           | RH | 0.9 | 135.0  | 167.0 | 184.0 | 195.0 | 197.0 | 198.0 |     |     | 0.0       |
| 2                 | 16042           | RH | 2.6 | -      | 107.0 | 124.0 | 135.0 | 137.0 | 138.0 |     |     | 60.0      |
| 3                 | 16043           | RH | 2.8 | -      | -     | 106.0 | 117.0 | 119.0 | 120.0 |     |     | 18.0      |
| 4                 | 16044           | LC | 6.0 | -      | -     | -     | 106.0 | 108.0 | 109.0 |     |     | 11.0      |
| 5                 | 16045           | LC | 6.0 | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 2.0       |
| 6                 | 16046           | LC | 6.0 | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |       |       |     |     |           |
| 1                 | 16051           | RH | 0.9 | 148.0  | 167.0 | 184.0 | 195.0 | 197.0 | 198.0 |     |     | 0.0       |
| 2                 | 16052           | RH | 2.7 | -      | 107.0 | 124.0 | 135.0 | 137.0 | 138.0 |     |     | 60.0      |
| 3                 | 16053           | RH | 2.9 | -      | -     | 106.0 | 117.0 | 119.0 | 120.0 |     |     | 18.0      |
| 4                 | 16054           | LC | 5.5 | -      | -     | -     | 106.0 | 108.0 | 109.0 |     |     | 11.0      |
| 5                 | 16055           | LC | 5.5 | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 2.0       |
| 6                 | 16056           | LC | 5.5 | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.20BS            | STEEL         | STDPO2 |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |       |       |     |     |           |
| 1                 | 16061           | RH | 1.0 | 161.0  | 167.0 | 184.0 | 196.0 | 197.0 | 197.0 |     |     | 0.0       |
| 2                 | 16062           | RH | 2.8 | -      | 107.0 | 124.0 | 136.0 | 137.0 | 137.0 |     |     | 60.0      |
| 3                 | 16063           | RH | 3.0 | -      | -     | 106.0 | 118.0 | 119.0 | 119.0 |     |     | 18.0      |
| 4                 | 16064           | LC | 5.0 | -      | -     | -     | 106.0 | 107.0 | 107.0 |     |     | 12.0      |
| 5                 | 16065           | LC | 5.0 | -      | -     | -     | -     | 106.0 | 106.0 |     |     | 1.0       |
| 6                 | 16066           | LC | 5.0 | -      | -     | -     | -     | -     | 105.0 |     |     | 1.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.20BS           | STEEL         | 5mm                | STDPO2  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 16001                 | 16002                 | 16003                    | 16004                 | 16005                 |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | LC                       | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 10                       | 9                     | 9                     |       |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 6.0                   | 2.5                      | 2.0                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                          |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                       | 8                     | 6                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 2                        | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 10                       | 9                     | 9                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                        | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 68.0<br>(65.0 ~ 71.0) | 83.0<br>(81.0 ~ 85.0) | 105.0<br>(103.0 ~ 107.0) | 95.0<br>(93.0 ~ 97.0) | 84.0<br>(82.0 ~ 86.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                      | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                      | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                       | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                    | 10                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 4.0                   | 7.0                   | 7.5                      | 7.5                   | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 191.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 212.0 | 129.0 | 107.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 215.0 | 132.0 | 110.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 217.0 | 134.0 | 112.0 | 109.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 83.0  | 22.0  | 3.0   | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 5.9 ~ 7.2   | 6.0 ~ 7.3   | 6.6 ~ 7.3   | 6.6 ~ 7.3   | 6.1 ~ 6.8   |  |  |
| Average Voltage Gap  | V   |  | 63 ~ 76     | 80 ~ 90     | 110 ~ 121   | 100 ~ 111   | 86 ~ 98     |  |  |
| Avg. Linear Feedrate | ALF |  | 393.0       | 198.0       | 134.2       | 101.6       | 80.4        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.20BS           | STEEL         | 10mm               | STDPO2  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 16011                 | 16012                 | 16013                 | 16014                 | 16015                 |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 11                    | 10                    | 10                    |       |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 6.0                   | 2.0                   | 2.0                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                    | 8                     | 6                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 2                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 10                    | 9                     | 9                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 60.0<br>(58.0 ~ 62.0) | 95.0<br>(93.0 ~ 97.0) | 80.0<br>(78.0 ~ 82.0) | 67.0<br>(65.0 ~ 69.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 3.0                   | 6.5                   | 7.5                   | 7.0                   | 6.5                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 127.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 185.0 | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 199.0 | 121.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 201.0 | 123.0 | 108.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 203.0 | 125.0 | 110.0 | 108.0 | 105.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 78.0  | 15.0  | 2.0   | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 3.8 ~ 4.6   | 8.0 ~ 9.8   | 6.6 ~ 7.3   | 6.1 ~ 6.7   | 5.7 ~ 6.3   |  |  |
| Average Voltage Gap  | V   |  | 45 ~ 60     | 57 ~ 67     | 101 ~ 112   | 84 ~ 96     | 70 ~ 82     |  |  |
| Avg. Linear Feedrate | ALF |  | 252.0       | 171.2       | 121.4       | 92.2        | 73.4        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.20BS           | STEEL         | 20mm               | STDPO2  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 16021                 | 16022                 | 16023                 | 16024                 | 16025                 |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 11                    | 10                    | 10                    |       |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 6.0                   | 2.5                   | 2.0                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                    | 8                     | 6                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 2                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 8                     | 10                    | 9                     | 9                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 57.0<br>(55.0 ~ 59.0) | 85.0<br>(83.0 ~ 87.0) | 55.0<br>(53.0 ~ 57.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 2.4                   | 4.0                   | 7.0                   | 7.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 173.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 189.0 | 121.0 | 104.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 192.0 | 124.0 | 107.0 | 104.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 194.0 | 126.0 | 109.0 | 106.0 | 105.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 68.0  | 17.0  | 3.0   | 1.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 2.8 ~ 3.4   | 4.7 ~ 5.7   | 6.2 ~ 6.8   | 6.1 ~ 6.8   | 5.3 ~ 5.8   |  |  |
| Average Voltage Gap  | V   |  | 32 ~ 49     | 54 ~ 64     | 91 ~ 102    | 62 ~ 73     | 53 ~ 65     |  |  |
| Avg. Linear Feedrate | ALF |  | 186.0       | 116.5       | 89.7        | 72.8        | 59.8        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.20BS           | STEEL         | 30mm               | STDPO2  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 942                   | 16031                 | 16032                 | 16033                 | 16034                 | 16035                 | 16036                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 10                    | 8                     |       |       |
| Power Setting      | IP  | 7.0                   | 7.0                   | 6.0                   | 5.0                   | 2.0                   | 2.0                   | 1.5                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 6                     | 10                    | 9                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 8                     | 6                     | 10                    | 9                     | 9                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 43.0<br>(40.0 ~ 46.0) | 59.0<br>(57.0 ~ 61.0) | 50.0<br>(48.0 ~ 52.0) | 70.0<br>(68.0 ~ 72.0) | 50.0<br>(48.0 ~ 52.0) | 43.0<br>(41.0 ~ 45.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.6                   | 3.3                   | 2.8                   | 6.5                   | 6.5                   | 6.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 170.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 187.0 | 123.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 201.0 | 137.0 | 119.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 203.0 | 139.0 | 121.0 | 107.0 | 105.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 204.0 | 140.0 | 122.0 | 108.0 | 106.0 | 104.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 64.0  | 18.0  | 14.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 2.0 ~ 2.4   | 3.6 ~ 4.7   | 6.1 ~ 7.5   | 5.8 ~ 6.4   | 5.3 ~ 5.9   | 5.9 ~ 6.4   |  |
| Average Voltage Gap  | V   |  | 37 ~ 50     | 50 ~ 65     | 47 ~ 57     | 88 ~ 100    | 64 ~ 76     | 47 ~ 59     |  |
| Avg. Linear Feedrate | ALF |  | 132.0       | 86.3        | 71.2        | 59.6        | 50.6        | 44.5        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.20BS           | STEEL         | 40mm               | STDPO2  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 942                   | 16041                 | 16042                 | 16043                 | 16044                 | 16045                 | 16046                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 10                    | 10                    |       |       |
| Power Setting      | IP  | 7.0                   | 7.0                   | 6.0                   | 5.0                   | 2.0                   | 2.0                   | 1.5                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 6                     | 10                    | 8                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 6                     | 10                    | 9                     | 9                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(42.0 ~ 48.0) | 62.0<br>(60.0 ~ 64.0) | 50.0<br>(48.0 ~ 52.0) | 70.0<br>(68.0 ~ 72.0) | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(38.0 ~ 42.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 1.0                   | 0.9                   | 2.6                   | 2.8                   | 6.0                   | 6.0                   | 6.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 167.0 | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 184.0 | 124.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 195.0 | 135.0 | 117.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 197.0 | 137.0 | 119.0 | 108.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 198.0 | 138.0 | 120.0 | 109.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 18.0  | 11.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.2 ~ 1.4   | 3.0 ~ 3.7   | 6.1 ~ 7.5   | 5.3 ~ 5.9   | 5.3 ~ 5.9   | 5.3 ~ 5.8   |  |
| Average Voltage Gap  | V   |  | 38 ~ 56     | 52 ~ 69     | 47 ~ 57     | 81 ~ 93     | 58 ~ 70     | 44 ~ 56     |  |
| Avg. Linear Feedrate | ALF |  | 78.0        | 56.2        | 49.4        | 43.1        | 38.2        | 34.2        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.20BS           | STEEL         | 50mm               | STDPO2  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 943                   | 16051                 | 16052                 | 16053                 | 16054                 | 16055                 | 16056                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 10                    | 12                    |       |       |
| Power Setting      | IP  | 7.0                   | 7.0                   | 6.0                   | 5.0                   | 2.0                   | 2.0                   | 1.5                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 6                     | 10                    | 7                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 8                     | 6                     | 10                    | 9                     | 9                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(42.0 ~ 48.0) | 56.0<br>(54.0 ~ 58.0) | 50.0<br>(48.0 ~ 52.0) | 70.0<br>(68.0 ~ 72.0) | 50.0<br>(48.0 ~ 52.0) | 38.0<br>(36.0 ~ 40.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 0.7                   | 0.9                   | 2.7                   | 2.9                   | 5.5                   | 5.5                   | 5.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 148.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 167.0 | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 184.0 | 124.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 195.0 | 135.0 | 117.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 197.0 | 137.0 | 119.0 | 108.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 198.0 | 138.0 | 120.0 | 109.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 18.0  | 11.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.9 ~ 1.2   | 3.4 ~ 4.8   | 5.1 ~ 6.5   | 4.8 ~ 5.4   | 4.7 ~ 5.3   | 4.9 ~ 5.4   |  |
| Average Voltage Gap  | V   |  | 36 ~ 55     | 47 ~ 58     | 47 ~ 57     | 74 ~ 86     | 52 ~ 64     | 41 ~ 54     |  |
| Avg. Linear Feedrate | ALF |  | 63.0        | 50.2        | 43.8        | 38.3        | 34.0        | 30.6        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.20BS           | STEEL         | 60mm               | STDPO2  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 943                   | 16061                 | 16062                 | 16063                 | 16064                 | 16065                 | 16066                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 12                    | 14                    |       |       |
| Power Setting      | IP  | 7.0                   | 7.0                   | 6.0                   | 5.0                   | 2.0                   | 2.0                   | 1.5                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 6                     | 10                    | 7                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 8                     | 6                     | 10                    | 9                     | 9                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(42.0 ~ 48.0) | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(48.0 ~ 52.0) | 70.0<br>(68.0 ~ 72.0) | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(33.0 ~ 37.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.0                   | 2.8                   | 3.0                   | 5.0                   | 5.0                   | 5.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 161.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 167.0 | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 184.0 | 124.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 196.0 | 136.0 | 118.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 197.0 | 137.0 | 119.0 | 107.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 197.0 | 137.0 | 119.0 | 107.0 | 106.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 18.0  | 12.0  | 1.0   | 1.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.7 ~ 0.9   | 3.8 ~ 4.9   | 4.1 ~ 5.0   | 4.3 ~ 4.8   | 4.2 ~ 4.8   | 4.4 ~ 4.9   |  |
| Average Voltage Gap  | V   |  | 34 ~ 53     | 41 ~ 57     | 47 ~ 57     | 67 ~ 79     | 46 ~ 58     | 38 ~ 51     |  |
| Avg. Linear Feedrate | ALF |  | 48.0        | 40.5        | 35.3        | 31.3        | 28.0        | 25.5        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.20BS            | STEEL         | STDDO2 |

Thickness 5 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 14001           | RH | 4.0 | 132.0  | 190.0 | 211.0 | 215.0 | 217.0 |     |     |     | 0.0       |
| 2                 | 14002           | RH | 7.0 | -      | 107.0 | 128.0 | 132.0 | 134.0 |     |     |     | 83.0      |
| 3                 | 14003           | LC | 7.5 | -      | -     | 106.0 | 110.0 | 112.0 |     |     |     | 22.0      |
| 4                 | 14004           | LC | 7.5 | -      | -     | -     | 107.0 | 109.0 |     |     |     | 3.0       |
| 5                 | 14005           | LC | 7.0 | -      | -     | -     | -     | 106.0 |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 6.0   | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 0.80  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 14011           | RH | 3.0 | 127.0  | 184.0 | 198.0 | 201.0 | 203.0 |     |     |     | 0.0       |
| 2                 | 14012           | RH | 6.5 | -      | 106.0 | 120.0 | 123.0 | 125.0 |     |     |     | 78.0      |
| 3                 | 14013           | LC | 7.5 | -      | -     | 105.0 | 108.0 | 110.0 |     |     |     | 15.0      |
| 4                 | 14014           | LC | 7.0 | -      | -     | -     | 106.0 | 108.0 |     |     |     | 2.0       |
| 5                 | 14015           | LC | 6.5 | -      | -     | -     | -     | 105.0 |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 6.0   | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 0.80  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 14021           | RH | 2.4 | 131.0  | 172.0 | 188.0 | 192.0 | 194.0 |     |     |     | 0.0       |
| 2                 | 14022           | RH | 4.0 | -      | 104.0 | 120.0 | 124.0 | 126.0 |     |     |     | 68.0      |
| 3                 | 14023           | LC | 7.0 | -      | -     | 103.0 | 107.0 | 109.0 |     |     |     | 17.0      |
| 4                 | 14024           | LC | 7.0 | -      | -     | -     | 104.0 | 106.0 |     |     |     | 3.0       |
| 5                 | 14025           | LC | 6.0 | -      | -     | -     | -     | 105.0 |     |     |     | 1.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 6.0   | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 0.80  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.20BS            | STEEL         | STDDO2 |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 14031           | RH | 1.6 | 133.0  | 169.0 | 186.0 | 201.0 | 203.0 | 205.0 |     |     | 0.0       |
| 2                 | 14032           | RH | 3.3 | -      | 105.0 | 122.0 | 137.0 | 139.0 | 141.0 |     |     | 64.0      |
| 3                 | 14033           | RH | 2.8 | -      | -     | 104.0 | 119.0 | 121.0 | 123.0 |     |     | 18.0      |
| 4                 | 14034           | LC | 6.5 | -      | -     | -     | 105.0 | 107.0 | 109.0 |     |     | 14.0      |
| 5                 | 14035           | LC | 6.5 | -      | -     | -     | -     | 105.0 | 107.0 |     |     | 2.0       |
| 6                 | 14036           | LC | 6.5 | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 14041           | RH | 0.9 | 135.0  | 166.0 | 183.0 | 195.0 | 197.0 | 198.0 |     |     | 0.0       |
| 2                 | 14042           | RH | 2.6 | -      | 106.0 | 123.0 | 135.0 | 137.0 | 138.0 |     |     | 60.0      |
| 3                 | 14043           | RH | 2.8 | -      | -     | 105.0 | 117.0 | 119.0 | 120.0 |     |     | 18.0      |
| 4                 | 14044           | LC | 6.0 | -      | -     | -     | 106.0 | 108.0 | 109.0 |     |     | 11.0      |
| 5                 | 14045           | LC | 6.0 | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 2.0       |
| 6                 | 14046           | LC | 6.0 | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |       |       |     |     |           |
| 1                 | 14051           | RH | 0.9 | 148.0  | 166.0 | 183.0 | 195.0 | 197.0 | 198.0 |     |     | 0.0       |
| 2                 | 14052           | RH | 2.7 | -      | 106.0 | 123.0 | 135.0 | 137.0 | 138.0 |     |     | 60.0      |
| 3                 | 14053           | RH | 2.9 | -      | -     | 105.0 | 117.0 | 119.0 | 120.0 |     |     | 18.0      |
| 4                 | 14054           | LC | 5.5 | -      | -     | -     | 106.0 | 108.0 | 109.0 |     |     | 11.0      |
| 5                 | 14055           | LC | 5.5 | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 2.0       |
| 6                 | 14056           | LC | 5.5 | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.20BS            | STEEL         | STDDO2 |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |       |       |     |     |           |
| 1                 | 14061           | RH | 1.0 | 161.0  | 166.0 | 183.0 | 196.0 | 197.0 | 197.0 |     |     | 0.0       |
| 2                 | 14062           | RH | 2.8 | -      | 106.0 | 123.0 | 136.0 | 137.0 | 137.0 |     |     | 60.0      |
| 3                 | 14063           | RH | 3.0 | -      | -     | 105.0 | 118.0 | 119.0 | 119.0 |     |     | 18.0      |
| 4                 | 14064           | LC | 5.0 | -      | -     | -     | 106.0 | 107.0 | 107.0 |     |     | 12.0      |
| 5                 | 14065           | LC | 5.0 | -      | -     | -     | -     | 106.0 | 106.0 |     |     | 1.0       |
| 6                 | 14066           | LC | 5.0 | -      | -     | -     | -     | -     | 105.0 |     |     | 1.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.20BS           | STEEL         | 5mm                | STDDO2  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 14001                 | 14002                 | 14003                    | 14004                 | 14005                 |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | LC                       | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 10                       | 9                     | 9                     |       |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 6.0                   | 2.5                      | 2.0                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                          |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                       | 8                     | 6                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 2                        | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 10                       | 9                     | 9                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                        | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 68.0<br>(65.0 ~ 71.0) | 83.0<br>(81.0 ~ 85.0) | 105.0<br>(103.0 ~ 107.0) | 95.0<br>(93.0 ~ 97.0) | 84.0<br>(82.0 ~ 86.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                      | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                      | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                       | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                    | 10                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 4.0                   | 7.0                   | 7.5                      | 7.5                   | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 190.0 | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 211.0 | 128.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 215.0 | 132.0 | 110.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 217.0 | 134.0 | 112.0 | 109.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 83.0  | 22.0  | 3.0   | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 5.9 ~ 7.2   | 6.0 ~ 7.3   | 6.6 ~ 7.3   | 6.6 ~ 7.3   | 6.1 ~ 6.8   |  |  |
| Average Voltage Gap  | V   |  | 63 ~ 76     | 80 ~ 90     | 110 ~ 121   | 100 ~ 111   | 86 ~ 98     |  |  |
| Avg. Linear Feedrate | ALF |  | 393.0       | 198.0       | 134.2       | 101.6       | 80.4        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.20BS           | STEEL         | 10mm               | STDDO2  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 14011                 | 14012                 | 14013                 | 14014                 | 14015                 |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 11                    | 10                    | 10                    |       |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 6.0                   | 2.0                   | 2.0                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                    | 8                     | 6                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 2                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 10                    | 9                     | 9                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 60.0<br>(58.0 ~ 62.0) | 95.0<br>(93.0 ~ 97.0) | 80.0<br>(78.0 ~ 82.0) | 67.0<br>(65.0 ~ 69.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 3.0                   | 6.5                   | 7.5                   | 7.0                   | 6.5                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 127.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 184.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 198.0 | 120.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 201.0 | 123.0 | 108.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 203.0 | 125.0 | 110.0 | 108.0 | 105.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 78.0  | 15.0  | 2.0   | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 3.8 ~ 4.6   | 8.0 ~ 9.8   | 6.6 ~ 7.3   | 6.1 ~ 6.7   | 5.7 ~ 6.3   |  |  |
| Average Voltage Gap  | V   |  | 45 ~ 60     | 57 ~ 67     | 101 ~ 112   | 84 ~ 96     | 70 ~ 82     |  |  |
| Avg. Linear Feedrate | ALF |  | 252.0       | 171.2       | 121.4       | 92.2        | 73.4        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.20BS           | STEEL         | 20mm               | STDDO2  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 14021                 | 14022                 | 14023                 | 14024                 | 14025                 |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 11                    | 10                    | 10                    |       |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 6.0                   | 2.5                   | 2.0                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                    | 8                     | 6                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 2                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 8                     | 10                    | 9                     | 9                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 57.0<br>(55.0 ~ 59.0) | 85.0<br>(83.0 ~ 87.0) | 55.0<br>(53.0 ~ 57.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 2.4                   | 4.0                   | 7.0                   | 7.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 172.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 188.0 | 120.0 | 103.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 192.0 | 124.0 | 107.0 | 104.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 194.0 | 126.0 | 109.0 | 106.0 | 105.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 68.0  | 17.0  | 3.0   | 1.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 2.8 ~ 3.4   | 4.7 ~ 5.7   | 6.2 ~ 6.8   | 6.1 ~ 6.8   | 5.3 ~ 5.8   |  |  |
| Average Voltage Gap  | V   |  | 32 ~ 49     | 54 ~ 64     | 91 ~ 102    | 62 ~ 73     | 53 ~ 65     |  |  |
| Avg. Linear Feedrate | ALF |  | 186.0       | 116.5       | 89.7        | 72.8        | 59.8        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.20BS           | STEEL         | 30mm               | STDDO2  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 942                   | 14031                 | 14032                 | 14033                 | 14034                 | 14035                 | 14036                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 10                    | 8                     |       |       |
| Power Setting      | IP  | 7.0                   | 7.0                   | 6.0                   | 5.0                   | 2.0                   | 2.0                   | 1.5                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 6                     | 10                    | 9                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 8                     | 6                     | 10                    | 9                     | 9                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 43.0<br>(40.0 ~ 46.0) | 59.0<br>(57.0 ~ 61.0) | 50.0<br>(48.0 ~ 52.0) | 70.0<br>(68.0 ~ 72.0) | 50.0<br>(48.0 ~ 52.0) | 43.0<br>(41.0 ~ 45.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.6                   | 3.3                   | 2.8                   | 6.5                   | 6.5                   | 6.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 169.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 186.0 | 122.0 | 104.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 201.0 | 137.0 | 119.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 203.0 | 139.0 | 121.0 | 107.0 | 105.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 205.0 | 141.0 | 123.0 | 109.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 64.0  | 18.0  | 14.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 2.0 ~ 2.4   | 3.6 ~ 4.7   | 6.1 ~ 7.5   | 5.8 ~ 6.4   | 5.3 ~ 5.9   | 5.9 ~ 6.4   |  |
| Average Voltage Gap  | V   |  | 37 ~ 50     | 50 ~ 65     | 47 ~ 57     | 88 ~ 100    | 64 ~ 76     | 47 ~ 59     |  |
| Avg. Linear Feedrate | ALF |  | 132.0       | 86.3        | 71.2        | 59.6        | 50.6        | 44.5        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.20BS           | STEEL         | 40mm               | STDDO2  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 942                   | 14041                 | 14042                 | 14043                 | 14044                 | 14045                 | 14046                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 10                    | 10                    |       |       |
| Power Setting      | IP  | 7.0                   | 7.0                   | 6.0                   | 5.0                   | 2.0                   | 2.0                   | 1.5                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 6                     | 10                    | 8                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 6                     | 10                    | 9                     | 9                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(42.0 ~ 48.0) | 62.0<br>(60.0 ~ 64.0) | 50.0<br>(48.0 ~ 52.0) | 70.0<br>(68.0 ~ 72.0) | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(38.0 ~ 42.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 1.0                   | 0.9                   | 2.6                   | 2.8                   | 6.0                   | 6.0                   | 6.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 166.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 183.0 | 123.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 195.0 | 135.0 | 117.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 197.0 | 137.0 | 119.0 | 108.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 198.0 | 138.0 | 120.0 | 109.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 18.0  | 11.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.2 ~ 1.4   | 3.0 ~ 3.7   | 6.1 ~ 7.5   | 5.3 ~ 5.9   | 5.3 ~ 5.9   | 5.3 ~ 5.8   |  |
| Average Voltage Gap  | V   |  | 38 ~ 56     | 52 ~ 69     | 47 ~ 57     | 81 ~ 93     | 58 ~ 70     | 44 ~ 56     |  |
| Avg. Linear Feedrate | ALF |  | 78.0        | 56.2        | 49.4        | 43.1        | 38.2        | 34.2        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.20BS           | STEEL         | 50mm               | STDDO2  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 943                   | 14051                 | 14052                 | 14053                 | 14054                 | 14055                 | 14056                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 10                    | 12                    |       |       |
| Power Setting      | IP  | 7.0                   | 7.0                   | 6.0                   | 5.0                   | 2.0                   | 2.0                   | 1.5                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 6                     | 10                    | 7                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 8                     | 6                     | 10                    | 9                     | 9                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(42.0 ~ 48.0) | 56.0<br>(54.0 ~ 58.0) | 50.0<br>(48.0 ~ 52.0) | 70.0<br>(68.0 ~ 72.0) | 50.0<br>(48.0 ~ 52.0) | 38.0<br>(36.0 ~ 40.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 0.7                   | 0.9                   | 2.7                   | 2.9                   | 5.5                   | 5.5                   | 5.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 148.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 166.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 183.0 | 123.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 195.0 | 135.0 | 117.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 197.0 | 137.0 | 119.0 | 108.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 198.0 | 138.0 | 120.0 | 109.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 18.0  | 11.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.9 ~ 1.2   | 3.4 ~ 4.8   | 5.1 ~ 6.5   | 4.8 ~ 5.4   | 4.7 ~ 5.3   | 4.9 ~ 5.4   |  |
| Average Voltage Gap  | V   |  | 36 ~ 55     | 47 ~ 58     | 47 ~ 57     | 74 ~ 86     | 52 ~ 64     | 41 ~ 54     |  |
| Avg. Linear Feedrate | ALF |  | 63.0        | 50.2        | 43.8        | 38.3        | 34.0        | 30.6        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.20BS           | STEEL         | 60mm               | STDDO2  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 943                   | 14061                 | 14062                 | 14063                 | 14064                 | 14065                 | 14066                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 12                    | 14                    |       |       |
| Power Setting      | IP  | 7.0                   | 7.0                   | 6.0                   | 5.0                   | 2.0                   | 2.0                   | 1.5                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 6                     | 10                    | 7                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 8                     | 6                     | 10                    | 9                     | 9                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(42.0 ~ 48.0) | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(48.0 ~ 52.0) | 70.0<br>(68.0 ~ 72.0) | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(33.0 ~ 37.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.0                   | 2.8                   | 3.0                   | 5.0                   | 5.0                   | 5.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 161.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 166.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 183.0 | 123.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 196.0 | 136.0 | 118.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 197.0 | 137.0 | 119.0 | 107.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 197.0 | 137.0 | 119.0 | 107.0 | 106.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 18.0  | 12.0  | 1.0   | 1.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.7 ~ 0.9   | 3.8 ~ 4.9   | 4.1 ~ 5.0   | 4.3 ~ 4.8   | 4.2 ~ 4.8   | 4.4 ~ 4.9   |  |
| Average Voltage Gap  | V   |  | 34 ~ 53     | 41 ~ 57     | 47 ~ 57     | 67 ~ 79     | 46 ~ 58     | 38 ~ 51     |  |
| Avg. Linear Feedrate | ALF |  | 48.0        | 40.5        | 35.3        | 31.3        | 28.0        | 25.5        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | ACUP  |

Thickness 5 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0  |        |       |       |       |       |       |     |     |           |
| 1                 | 1261            | RH | 6.0  | 115.0  | 180.0 | 215.0 | 230.0 | 233.0 | 235.0 |     |     | 0.0       |
| 2                 | 1262            | RH | 8.0  | -      | 105.0 | 140.0 | 155.0 | 158.0 | 160.0 |     |     | 75.0      |
| 3                 | 1263            | HL | 8.0  | -      | -     | 105.0 | 120.0 | 123.0 | 125.0 |     |     | 35.0      |
| 4                 | 1264            | LC | 12.0 | -      | -     | -     | 105.0 | 108.0 | 110.0 |     |     | 15.0      |
| 5                 | 1265            | LC | 10.5 | -      | -     | -     | -     | 105.0 | 107.0 |     |     | 3.0       |
| 6                 | 1266            | LC | 8.0  | -      | -     | -     | -     | -     | 104.0 |     |     | 3.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0  |        |       |       |       |       |       |     |     |           |
| 1                 | 1271            | RH | 4.0  | 121.0  | 175.0 | 210.0 | 224.0 | 227.0 | 229.0 |     |     | 0.0       |
| 2                 | 1272            | RH | 8.0  | -      | 105.0 | 140.0 | 154.0 | 157.0 | 159.0 |     |     | 70.0      |
| 3                 | 1273            | HL | 7.5  | -      | -     | 105.0 | 119.0 | 122.0 | 124.0 |     |     | 35.0      |
| 4                 | 1274            | LC | 11.0 | -      | -     | -     | 105.0 | 108.0 | 110.0 |     |     | 14.0      |
| 5                 | 1275            | LC | 10.0 | -      | -     | -     | -     | 105.0 | 107.0 |     |     | 3.0       |
| 6                 | 1276            | LC | 7.5  | -      | -     | -     | -     | -     | 104.0 |     |     | 3.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0  |        |       |       |       |       |       |     |     |           |
| 1                 | 1281            | RH | 3.0  | 123.0  | 176.0 | 211.0 | 223.0 | 227.0 | 229.0 |     |     | 0.0       |
| 2                 | 1282            | RH | 6.0  | -      | 106.0 | 141.0 | 153.0 | 157.0 | 159.0 |     |     | 70.0      |
| 3                 | 1283            | HL | 7.0  | -      | -     | 106.0 | 118.0 | 122.0 | 124.0 |     |     | 35.0      |
| 4                 | 1284            | LC | 10.5 | -      | -     | -     | 106.0 | 110.0 | 112.0 |     |     | 12.0      |
| 5                 | 1285            | LC | 9.5  | -      | -     | -     | -     | 106.0 | 108.0 |     |     | 4.0       |
| 6                 | 1286            | LC | 7.0  | -      | -     | -     | -     | -     | 105.0 |     |     | 3.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | ACUP  |

Thickness 30 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0  |        |       |       |       |       |       |     |     |           |
| 1                 | 1291            | RH | 2.5  | 128.0  | 171.0 | 201.0 | 215.0 | 217.0 | 218.0 |     |     | 0.0       |
| 2                 | 1292            | RH | 5.0  | -      | 106.0 | 136.0 | 150.0 | 152.0 | 153.0 |     |     | 65.0      |
| 3                 | 1293            | HL | 5.5  | -      | -     | 106.0 | 120.0 | 122.0 | 123.0 |     |     | 30.0      |
| 4                 | 1294            | LC | 10.5 | -      | -     | -     | 106.0 | 108.0 | 109.0 |     |     | 14.0      |
| 5                 | 1295            | LC | 9.0  | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 2.0       |
| 6                 | 1296            | LC | 6.0  | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0  |        |       |       |       |       |       |     |     |           |
| 1                 | 1301            | RH | 2.0  | 131.0  | 166.0 | 191.0 | 205.0 | 207.0 | 208.0 |     |     | 0.0       |
| 2                 | 1302            | RH | 5.0  | -      | 106.0 | 131.0 | 145.0 | 147.0 | 148.0 |     |     | 60.0      |
| 3                 | 1303            | HL | 5.0  | -      | -     | 106.0 | 120.0 | 122.0 | 123.0 |     |     | 25.0      |
| 4                 | 1304            | LC | 10.5 | -      | -     | -     | 106.0 | 108.0 | 109.0 |     |     | 14.0      |
| 5                 | 1305            | LC | 8.5  | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 2.0       |
| 6                 | 1306            | LC | 5.5  | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7  |        |       |       |       |       |       |     |     |           |
| 1                 | 1311            | RH | 1.5  | 133.0  | 164.0 | 189.0 | 204.0 | 207.0 | 208.0 |     |     | 0.0       |
| 2                 | 1312            | RH | 4.7  | -      | 106.0 | 131.0 | 146.0 | 149.0 | 150.0 |     |     | 58.0      |
| 3                 | 1313            | HL | 4.7  | -      | -     | 106.0 | 121.0 | 124.0 | 125.0 |     |     | 25.0      |
| 4                 | 1314            | LC | 10.2 | -      | -     | -     | 106.0 | 109.0 | 110.0 |     |     | 15.0      |
| 5                 | 1315            | LC | 8.2  | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 3.0       |
| 6                 | 1316            | LC | 5.2  | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | ACUP  |

Thickness 60 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7  |        |       |       |       |       |       |     |     |           |
| 1                 | 1321            | RH | 1.0  | 135.0  | 161.0 | 186.0 | 201.0 | 204.0 | 205.0 |     |     | 0.0       |
| 2                 | 1322            | RH | 4.5  | -      | 106.0 | 131.0 | 146.0 | 149.0 | 150.0 |     |     | 55.0      |
| 3                 | 1323            | HL | 4.5  | -      | -     | 106.0 | 121.0 | 124.0 | 125.0 |     |     | 25.0      |
| 4                 | 1324            | LC | 10.0 | -      | -     | -     | 106.0 | 109.0 | 110.0 |     |     | 15.0      |
| 5                 | 1325            | LC | 8.0  | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 3.0       |
| 6                 | 1326            | LC | 5.0  | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |       |       |     |     |           |
| 1                 | 1331            | RH | 0.9 | 137.0  | 164.0 | 189.0 | 203.0 | 207.0 | 208.0 |     |     | 0.0       |
| 2                 | 1332            | RH | 4.2 | -      | 106.0 | 131.0 | 145.0 | 149.0 | 150.0 |     |     | 58.0      |
| 3                 | 1333            | HL | 4.2 | -      | -     | 106.0 | 120.0 | 124.0 | 125.0 |     |     | 25.0      |
| 4                 | 1334            | LC | 9.7 | -      | -     | -     | 106.0 | 110.0 | 111.0 |     |     | 14.0      |
| 5                 | 1335            | LC | 7.7 | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 4.0       |
| 6                 | 1336            | LC | 4.7 | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |       |       |     |     |           |
| 1                 | 1341            | RH | 0.8 | 139.0  | 166.0 | 191.0 | 204.0 | 208.0 | 209.0 |     |     | 0.0       |
| 2                 | 1342            | RH | 4.0 | -      | 106.0 | 131.0 | 144.0 | 148.0 | 149.0 |     |     | 60.0      |
| 3                 | 1343            | HL | 4.0 | -      | -     | 106.0 | 119.0 | 123.0 | 124.0 |     |     | 25.0      |
| 4                 | 1344            | LC | 9.5 | -      | -     | -     | 106.0 | 110.0 | 111.0 |     |     | 13.0      |
| 5                 | 1345            | LC | 7.5 | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 4.0       |
| 6                 | 1346            | LC | 4.5 | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

|                    |               |       |
|--------------------|---------------|-------|
| Wire Dia. and Type | Material Type | Class |
| φ0.20BS            | STEEL         | ACUP  |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |       |       |     |     |           |
| 1                 | 1351            | RH | 0.7 | 141.0  | 170.0 | 195.0 | 207.0 | 210.0 | 211.0 |     |     | 0.0       |
| 2                 | 1352            | RH | 3.7 | -      | 107.0 | 132.0 | 144.0 | 147.0 | 148.0 |     |     | 63.0      |
| 3                 | 1353            | HL | 3.7 | -      | -     | 107.0 | 119.0 | 122.0 | 123.0 |     |     | 25.0      |
| 4                 | 1354            | LC | 9.0 | -      | -     | -     | 107.0 | 110.0 | 111.0 |     |     | 12.0      |
| 5                 | 1355            | LC | 7.0 | -      | -     | -     | -     | 107.0 | 108.0 |     |     | 3.0       |
| 6                 | 1356            | LC | 4.2 | -      | -     | -     | -     | -     | 106.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |       |       |     |     |           |
| 1                 | 1361            | RH | 0.6 | 143.0  | 172.0 | 197.0 | 209.0 | 212.0 | 213.0 |     |     | 0.0       |
| 2                 | 1362            | RH | 3.5 | -      | 107.0 | 132.0 | 144.0 | 147.0 | 148.0 |     |     | 65.0      |
| 3                 | 1363            | HL | 3.5 | -      | -     | 107.0 | 119.0 | 122.0 | 123.0 |     |     | 25.0      |
| 4                 | 1364            | LC | 8.5 | -      | -     | -     | 107.0 | 110.0 | 111.0 |     |     | 12.0      |
| 5                 | 1365            | LC | 6.5 | -      | -     | -     | -     | 107.0 | 108.0 |     |     | 3.0       |
| 6                 | 1366            | LC | 4.0 | -      | -     | -     | -     | -     | 106.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 5mm                | ACUP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 941                   | 1261                  | 1262                  | 1263                     | 1264                  | 1265                  | 1266                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                       | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                       | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                       | 6                     | 6                     | 10                    |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 5.0                   | 12.0                     | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 9                     | 10                    | 10                       |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                       | 10                    | 10                    | 8                     |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 1                        | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 8                     | 10                       | 10                    | 9                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                        | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 56.0<br>(53.0 ~ 59.0) | 74.0<br>(72.0 ~ 76.0) | 110.0<br>(108.0 ~ 112.0) | 68.0<br>(66.0 ~ 70.0) | 84.0<br>(82.0 ~ 86.0) | 80.0<br>(78.0 ~ 82.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                      | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                       | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 10                    | 10                       | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 12                    | 4                     | 4                        | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 2.0                   | 6.0                   | 8.0                   | 8.0                      | 12.0                  | 10.5                  | 8.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 115.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 180.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 215.0 | 140.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 230.0 | 155.0 | 120.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 233.0 | 158.0 | 123.0 | 108.0 | 105.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 235.0 | 160.0 | 125.0 | 110.0 | 107.0 | 104.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 75.0  | 35.0  | 15.0  | 3.0   | 3.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 6.4 ~ 7.8   | 11.5 ~ 14.1 | 12.1 ~ 14.9 | 11.2 ~ 12.5 | 9.7 ~ 10.7  | 7.4 ~ 8.2   |  |
| Average Voltage Gap  | V   |  | 41 ~ 67     | 66 ~ 81     | 107 ~ 117   | 78 ~ 92     | 91 ~ 105    | 89 ~ 103    |  |
| Avg. Linear Feedrate | ALF |  | 426.0       | 274.0       | 204.7       | 159.0       | 126.2       | 99.4        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 10mm               | ACUP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 941                   | 1271                  | 1272                  | 1273                  | 1274                  | 1275                  | 1276                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 7                     | 6                     | 10                    |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 5.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 9                     | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                    | 10                    | 10                    | 8                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 7                     | 8                     | 10                    | 10                    | 9                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 64.0<br>(62.0 ~ 66.0) | 88.0<br>(86.0 ~ 90.0) | 72.0<br>(70.0 ~ 74.0) | 72.0<br>(70.0 ~ 74.0) | 62.0<br>(60.0 ~ 64.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 2.0                   | 4.0                   | 8.0                   | 7.5                   | 11.0                  | 10.0                  | 7.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 121.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 175.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 210.0 | 140.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 224.0 | 154.0 | 119.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 227.0 | 157.0 | 122.0 | 108.0 | 105.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 229.0 | 159.0 | 124.0 | 110.0 | 107.0 | 104.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 70.0  | 35.0  | 14.0  | 3.0   | 3.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 4.6 ~ 5.6   | 11.1 ~ 13.6 | 10.4 ~ 12.7 | 10.3 ~ 11.4 | 9.3 ~ 10.3  | 7.0 ~ 7.8   |  |
| Average Voltage Gap  | V   |  | 32 ~ 53     | 57 ~ 74     | 85 ~ 95     | 80 ~ 94     | 83 ~ 96     | 76 ~ 90     |  |
| Avg. Linear Feedrate | ALF |  | 306.0       | 216.6       | 165.0       | 131.6       | 107.6       | 86.6        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 20mm               | ACUP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 941                   | 1281                  | 1282                  | 1283                  | 1284                  | 1285                  | 1286                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 8                     | 7                     | 11                    |       |       |
| Power Setting      | IP  | 6.0                   | 8.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 9                     | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 9                     | 10                    | 10                    | 8                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 9                     | 10                    | 9                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 42.0<br>(39.0 ~ 45.0) | 60.0<br>(58.0 ~ 62.0) | 80.0<br>(78.0 ~ 82.0) | 72.0<br>(70.0 ~ 74.0) | 64.0<br>(62.0 ~ 66.0) | 50.0<br>(48.0 ~ 52.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 11                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 2.0                   | 3.0                   | 6.0                   | 7.0                   | 10.5                  | 9.5                   | 7.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 123.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 176.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 211.0 | 141.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 223.0 | 153.0 | 118.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 227.0 | 157.0 | 122.0 | 110.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 229.0 | 159.0 | 124.0 | 112.0 | 108.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 70.0  | 35.0  | 12.0  | 4.0   | 3.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 3.3 ~ 4.1   | 8.4 ~ 10.3  | 7.9 ~ 9.7   | 10.0 ~ 11.0 | 9.0 ~ 9.9   | 6.6 ~ 7.4   |  |
| Average Voltage Gap  | V   |  | 32 ~ 53     | 52 ~ 68     | 77 ~ 87     | 80 ~ 94     | 73 ~ 86     | 60 ~ 74     |  |
| Avg. Linear Feedrate | ALF |  | 222.0       | 159.1       | 122.2       | 102.4       | 86.7        | 71.9        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 30mm               | ACUP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 942                   | 1291                  | 1292                  | 1293                  | 1294                  | 1295                  | 1296                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 10                    | 8                     | 13                    |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 9                     | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 9                     | 10                    | 8                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 9                     | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 41.0<br>(38.0 ~ 44.0) | 60.0<br>(58.0 ~ 62.0) | 70.0<br>(68.0 ~ 72.0) | 55.0<br>(53.0 ~ 57.0) | 64.0<br>(62.0 ~ 66.0) | 55.0<br>(53.0 ~ 57.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.5                   | 5.0                   | 5.5                   | 10.5                  | 9.0                   | 6.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 128.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 171.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 201.0 | 136.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 215.0 | 150.0 | 120.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 217.0 | 152.0 | 122.0 | 108.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 218.0 | 153.0 | 123.0 | 109.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 30.0  | 14.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 2.8 ~ 3.4   | 5.5 ~ 6.5   | 7.5 ~ 9.2   | 10.2 ~ 11.2 | 8.5 ~ 9.2   | 5.7 ~ 6.0   |  |
| Average Voltage Gap  | V   |  | 33 ~ 48     | 51 ~ 69     | 67 ~ 77     | 55 ~ 75     | 64 ~ 77     | 59 ~ 73     |  |
| Avg. Linear Feedrate | ALF |  | 186.0       | 122.6       | 98.5        | 85.4        | 73.6        | 60.8        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 40mm               | ACUP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 942                   | 1301                  | 1302                  | 1303                  | 1304                  | 1305                  | 1306                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 10                    | 8                     | 13                    |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 9                     | 10                    | 8                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 8                     | 9                     | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 60.0<br>(58.0 ~ 62.0) | 68.0<br>(66.0 ~ 70.0) | 32.0<br>(30.0 ~ 34.0) | 54.0<br>(52.0 ~ 56.0) | 46.0<br>(44.0 ~ 48.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.0                   | 5.0                   | 5.0                   | 10.5                  | 8.5                   | 5.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 166.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 191.0 | 131.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 205.0 | 145.0 | 120.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 207.0 | 147.0 | 122.0 | 108.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 208.0 | 148.0 | 123.0 | 109.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 25.0  | 14.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 2.0 ~ 2.5   | 5.5 ~ 6.4   | 7.2 ~ 8.9   | 10.3 ~ 11.4 | 8.0 ~ 8.8   | 5.3 ~ 5.9   |  |
| Average Voltage Gap  | V   |  | 31 ~ 50     | 49 ~ 70     | 65 ~ 75     | 41 ~ 55     | 59 ~ 72     | 57 ~ 71     |  |
| Avg. Linear Feedrate | ALF |  | 135.0       | 98.0        | 81.4        | 72.4        | 63.3        | 53.3        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 50mm               | ACUP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 943                   | 1311                  | 1312                  | 1313                  | 1314                  | 1315                  | 1316                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 10                    | 9                     | 13                    |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 9                     | 10                    | 8                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 6                     | 8                     | 9                     | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 39.0<br>(36.0 ~ 42.0) | 58.0<br>(56.0 ~ 60.0) | 61.0<br>(59.0 ~ 63.0) | 27.0<br>(25.0 ~ 29.0) | 45.0<br>(43.0 ~ 47.0) | 40.0<br>(38.0 ~ 42.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.5                   | 4.7                   | 4.7                   | 10.2                  | 8.2                   | 5.2                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 164.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 189.0 | 131.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 204.0 | 146.0 | 121.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 207.0 | 149.0 | 124.0 | 109.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 208.0 | 150.0 | 125.0 | 110.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 58.0  | 25.0  | 15.0  | 3.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.9 ~ 2.3   | 5.2 ~ 6.2   | 5.5 ~ 6.9   | 10.2 ~ 11.0 | 7.8 ~ 8.6   | 5.1 ~ 5.7   |  |
| Average Voltage Gap  | V   |  | 29 ~ 49     | 47 ~ 58     | 58 ~ 68     | 37 ~ 50     | 54 ~ 67     | 52 ~ 66     |  |
| Avg. Linear Feedrate | ALF |  | 126.0       | 92.1        | 73.8        | 66.1        | 58.3        | 49.4        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 60mm               | ACUP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 943                   | 1321                  | 1322                  | 1323                  | 1324                  | 1325                  | 1326                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 10                    | 9                     | 13                    |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 9                     | 10                    | 8                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 6                     | 8                     | 9                     | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 38.0<br>(35.0 ~ 41.0) | 56.0<br>(54.0 ~ 58.0) | 59.0<br>(57.0 ~ 61.0) | 25.0<br>(23.0 ~ 27.0) | 40.0<br>(38.0 ~ 42.0) | 35.0<br>(33.0 ~ 37.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.0                   | 4.5                   | 4.5                   | 10.0                  | 8.0                   | 5.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 161.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 186.0 | 131.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 201.0 | 146.0 | 121.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 204.0 | 149.0 | 124.0 | 109.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 205.0 | 150.0 | 125.0 | 110.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 55.0  | 25.0  | 15.0  | 3.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.6 ~ 1.9   | 4.9 ~ 5.9   | 3.9 ~ 4.8   | 9.7 ~ 10.7  | 7.7 ~ 8.5   | 5.0 ~ 5.5   |  |
| Average Voltage Gap  | V   |  | 28 ~ 49     | 46 ~ 65     | 56 ~ 66     | 33 ~ 46     | 49 ~ 62     | 47 ~ 60     |  |
| Avg. Linear Feedrate | ALF |  | 105.0       | 79.3        | 60.8        | 55.3        | 49.7        | 42.9        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 70mm               | ACUP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 944                   | 1331                  | 1332                  | 1333                  | 1334                  | 1335                  | 1336                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 11                    | 10                    | 10                    |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 7                     | 8                     | 10                    | 8                     | 5                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 7                     | 7                     | 8                     | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 39.0<br>(36.0 ~ 42.0) | 55.0<br>(53.0 ~ 57.0) | 57.0<br>(55.0 ~ 59.0) | 25.0<br>(23.0 ~ 27.0) | 35.0<br>(33.0 ~ 37.0) | 32.0<br>(30.0 ~ 34.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.9                   | 4.2                   | 4.2                   | 9.7                   | 7.7                   | 4.7                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 137.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 164.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 189.0 | 131.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 203.0 | 145.0 | 120.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 207.0 | 149.0 | 124.0 | 110.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 208.0 | 150.0 | 125.0 | 111.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 58.0  | 25.0  | 14.0  | 4.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.2 ~ 1.5   | 4.4 ~ 5.4   | 3.7 ~ 4.6   | 9.2 ~ 10.2  | 7.2 ~ 7.9   | 4.6 ~ 5.0   |  |
| Average Voltage Gap  | V   |  | 28 ~ 51     | 44 ~ 64     | 54 ~ 64     | 34 ~ 47     | 45 ~ 57     | 44 ~ 56     |  |
| Avg. Linear Feedrate | ALF |  | 81.0        | 63.5        | 50.6        | 46.6        | 42.2        | 36.8        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 80mm               | ACUP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 944                   | 1341                  | 1342                  | 1343                  | 1344                  | 1345                  | 1346                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 12                    | 10                    | 10                    |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 7                     | 8                     | 10                    | 8                     | 4                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 7                     | 7                     | 8                     | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 54.0<br>(52.0 ~ 56.0) | 55.0<br>(53.0 ~ 57.0) | 25.0<br>(23.0 ~ 27.0) | 30.0<br>(28.0 ~ 32.0) | 30.0<br>(28.0 ~ 32.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.8                   | 4.0                   | 4.0                   | 9.5                   | 7.5                   | 4.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 139.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 166.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 191.0 | 131.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 204.0 | 144.0 | 119.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 208.0 | 148.0 | 123.0 | 110.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 209.0 | 149.0 | 124.0 | 111.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 25.0  | 13.0  | 4.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.9 ~ 1.1   | 4.0 ~ 4.9   | 3.6 ~ 4.4   | 8.9 ~ 9.8   | 6.7 ~ 7.4   | 4.2 ~ 4.6   |  |
| Average Voltage Gap  | V   |  | 29 ~ 52     | 43 ~ 64     | 52 ~ 62     | 35 ~ 47     | 42 ~ 54     | 40 ~ 53     |  |
| Avg. Linear Feedrate | ALF |  | 60.0        | 49.0        | 40.7        | 37.9        | 34.8        | 30.8        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 90mm               | ACUP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 945                   | 1351                  | 1352                  | 1353                  | 1354                  | 1355                  | 1356                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 13                    | 11                    | 11                    |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 7                     | 7                     | 10                    | 8                     | 4                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 6                     | 8                     | 7                     | 7                     | 9                     | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 43.0<br>(40.0 ~ 46.0) | 52.0<br>(50.0 ~ 54.0) | 51.0<br>(49.0 ~ 53.0) | 22.0<br>(20.0 ~ 24.0) | 30.0<br>(28.0 ~ 32.0) | 27.0<br>(25.0 ~ 29.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.7                   | 3.7                   | 3.7                   | 9.0                   | 7.0                   | 4.2                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 141.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 170.0 | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 195.0 | 132.0 | 107.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 207.0 | 144.0 | 119.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 210.0 | 147.0 | 122.0 | 110.0 | 107.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 211.0 | 148.0 | 123.0 | 111.0 | 108.0 | 106.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 63.0  | 25.0  | 12.0  | 3.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.7 ~ 1.0   | 3.8 ~ 4.6   | 3.4 ~ 4.2   | 8.5 ~ 9.4   | 6.5 ~ 7.2   | 3.8 ~ 4.3   |  |
| Average Voltage Gap  | V   |  | 33 ~ 56     | 42 ~ 61     | 48 ~ 58     | 34 ~ 47     | 40 ~ 52     | 37 ~ 51     |  |
| Avg. Linear Feedrate | ALF |  | 51.0        | 42.4        | 35.8        | 33.5        | 31.0        | 27.5        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 100mm              | ACUP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 945                   | 1361                  | 1362                  | 1363                  | 1364                  | 1365                  | 1366                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 14                    | 11                    | 11                    |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 7                     | 7                     | 10                    | 8                     | 4                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 6                     | 8                     | 7                     | 7                     | 9                     | 7                     | 7                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 46.0<br>(43.0 ~ 49.0) | 50.0<br>(48.0 ~ 52.0) | 47.0<br>(45.0 ~ 49.0) | 20.0<br>(18.0 ~ 22.0) | 30.0<br>(28.0 ~ 32.0) | 25.0<br>(23.0 ~ 27.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.6                   | 3.5                   | 3.5                   | 8.5                   | 6.5                   | 4.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 143.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 172.0 | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 197.0 | 132.0 | 107.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 209.0 | 144.0 | 119.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 212.0 | 147.0 | 122.0 | 110.0 | 107.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 213.0 | 148.0 | 123.0 | 111.0 | 108.0 | 106.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 25.0  | 12.0  | 3.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.6 ~ 0.9   | 3.6 ~ 4.4   | 3.2 ~ 3.9   | 8.1 ~ 9.0   | 6.3 ~ 7.0   | 3.5 ~ 3.9   |  |
| Average Voltage Gap  | V   |  | 36 ~ 60     | 41 ~ 59     | 44 ~ 54     | 33 ~ 46     | 39 ~ 51     | 36 ~ 49     |  |
| Avg. Linear Feedrate | ALF |  | 45.0        | 37.9        | 32.2        | 30.3        | 28.1        | 25.0        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | ACUD  |

Thickness 5 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0  |        |       |       |       |       |       |     |     |           |
| 1                 | 12201           | RH | 6.0  | 115.0  | 179.0 | 214.0 | 229.0 | 232.0 | 234.0 |     |     | 0.0       |
| 2                 | 12202           | RH | 8.0  | -      | 104.0 | 139.0 | 154.0 | 157.0 | 159.0 |     |     | 75.0      |
| 3                 | 12203           | HL | 8.0  | -      | -     | 104.0 | 119.0 | 122.0 | 124.0 |     |     | 35.0      |
| 4                 | 12204           | LC | 12.0 | -      | -     | -     | 104.0 | 107.0 | 109.0 |     |     | 15.0      |
| 5                 | 12205           | LC | 10.5 | -      | -     | -     | -     | 104.0 | 106.0 |     |     | 3.0       |
| 6                 | 12206           | LC | 8.0  | -      | -     | -     | -     | -     | 103.0 |     |     | 3.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0  |        |       |       |       |       |       |     |     |           |
| 1                 | 12211           | RH | 4.0  | 121.0  | 174.0 | 209.0 | 223.0 | 226.0 | 228.0 |     |     | 0.0       |
| 2                 | 12212           | RH | 8.0  | -      | 104.0 | 139.0 | 153.0 | 156.0 | 158.0 |     |     | 70.0      |
| 3                 | 12213           | HL | 7.5  | -      | -     | 104.0 | 118.0 | 121.0 | 123.0 |     |     | 35.0      |
| 4                 | 12214           | LC | 11.0 | -      | -     | -     | 104.0 | 107.0 | 109.0 |     |     | 14.0      |
| 5                 | 12215           | LC | 10.0 | -      | -     | -     | -     | 104.0 | 106.0 |     |     | 3.0       |
| 6                 | 12216           | LC | 7.5  | -      | -     | -     | -     | -     | 103.0 |     |     | 3.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0  |        |       |       |       |       |       |     |     |           |
| 1                 | 12221           | RH | 3.0  | 123.0  | 174.0 | 209.0 | 221.0 | 225.0 | 227.0 |     |     | 0.0       |
| 2                 | 12222           | RH | 6.0  | -      | 104.0 | 139.0 | 151.0 | 155.0 | 157.0 |     |     | 70.0      |
| 3                 | 12223           | HL | 7.0  | -      | -     | 104.0 | 116.0 | 120.0 | 122.0 |     |     | 35.0      |
| 4                 | 12224           | LC | 10.5 | -      | -     | -     | 104.0 | 108.0 | 110.0 |     |     | 12.0      |
| 5                 | 12225           | LC | 9.5  | -      | -     | -     | -     | 104.0 | 106.0 |     |     | 4.0       |
| 6                 | 12226           | LC | 7.0  | -      | -     | -     | -     | -     | 103.0 |     |     | 3.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | ACUD  |

Thickness 30 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0  |        |       |       |       |       |       |     |     |           |
| 1                 | 12231           | RH | 2.5  | 128.0  | 169.0 | 199.0 | 213.0 | 215.0 | 216.0 |     |     | 0.0       |
| 2                 | 12232           | RH | 5.0  | -      | 104.0 | 134.0 | 148.0 | 150.0 | 151.0 |     |     | 65.0      |
| 3                 | 12233           | HL | 5.5  | -      | -     | 104.0 | 118.0 | 120.0 | 121.0 |     |     | 30.0      |
| 4                 | 12234           | LC | 10.5 | -      | -     | -     | 104.0 | 106.0 | 107.0 |     |     | 14.0      |
| 5                 | 12235           | LC | 9.0  | -      | -     | -     | -     | 104.0 | 105.0 |     |     | 2.0       |
| 6                 | 12236           | LC | 6.0  | -      | -     | -     | -     | -     | 103.0 |     |     | 2.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0  |        |       |       |       |       |       |     |     |           |
| 1                 | 12241           | RH | 2.0  | 131.0  | 164.0 | 189.0 | 203.0 | 205.0 | 206.0 |     |     | 0.0       |
| 2                 | 12242           | RH | 5.0  | -      | 104.0 | 129.0 | 143.0 | 145.0 | 146.0 |     |     | 60.0      |
| 3                 | 12243           | HL | 5.0  | -      | -     | 104.0 | 118.0 | 120.0 | 121.0 |     |     | 25.0      |
| 4                 | 12244           | LC | 10.5 | -      | -     | -     | 104.0 | 106.0 | 107.0 |     |     | 14.0      |
| 5                 | 12245           | LC | 8.5  | -      | -     | -     | -     | 104.0 | 105.0 |     |     | 2.0       |
| 6                 | 12246           | LC | 5.5  | -      | -     | -     | -     | -     | 103.0 |     |     | 2.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7  |        |       |       |       |       |       |     |     |           |
| 1                 | 12251           | RH | 1.5  | 133.0  | 162.0 | 187.0 | 202.0 | 205.0 | 206.0 |     |     | 0.0       |
| 2                 | 12252           | RH | 4.7  | -      | 104.0 | 129.0 | 144.0 | 147.0 | 148.0 |     |     | 58.0      |
| 3                 | 12253           | HL | 4.7  | -      | -     | 104.0 | 119.0 | 122.0 | 123.0 |     |     | 25.0      |
| 4                 | 12254           | LC | 10.2 | -      | -     | -     | 104.0 | 107.0 | 108.0 |     |     | 15.0      |
| 5                 | 12255           | LC | 8.2  | -      | -     | -     | -     | 104.0 | 105.0 |     |     | 3.0       |
| 6                 | 12256           | LC | 5.2  | -      | -     | -     | -     | -     | 103.0 |     |     | 2.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | ACUD  |

Thickness 60 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7  |        |       |       |       |       |       |     |     |           |
| 1                 | 12261           | RH | 1.0  | 135.0  | 158.0 | 183.0 | 198.0 | 201.0 | 202.0 |     |     | 0.0       |
| 2                 | 12262           | RH | 4.5  | -      | 103.0 | 128.0 | 143.0 | 146.0 | 147.0 |     |     | 55.0      |
| 3                 | 12263           | HL | 4.5  | -      | -     | 103.0 | 118.0 | 121.0 | 122.0 |     |     | 25.0      |
| 4                 | 12264           | LC | 10.0 | -      | -     | -     | 103.0 | 106.0 | 107.0 |     |     | 15.0      |
| 5                 | 12265           | LC | 8.0  | -      | -     | -     | -     | 103.0 | 104.0 |     |     | 3.0       |
| 6                 | 12266           | LC | 5.0  | -      | -     | -     | -     | -     | 102.0 |     |     | 2.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |       |       |     |     |           |
| 1                 | 12271           | RH | 0.9 | 137.0  | 162.0 | 187.0 | 201.0 | 205.0 | 206.0 |     |     | 0.0       |
| 2                 | 12272           | RH | 4.2 | -      | 104.0 | 129.0 | 143.0 | 147.0 | 148.0 |     |     | 58.0      |
| 3                 | 12273           | HL | 4.2 | -      | -     | 104.0 | 118.0 | 122.0 | 123.0 |     |     | 25.0      |
| 4                 | 12274           | LC | 9.7 | -      | -     | -     | 104.0 | 108.0 | 109.0 |     |     | 14.0      |
| 5                 | 12275           | LC | 7.7 | -      | -     | -     | -     | 104.0 | 105.0 |     |     | 4.0       |
| 6                 | 12276           | LC | 4.7 | -      | -     | -     | -     | -     | 103.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |       |       |     |     |           |
| 1                 | 12281           | RH | 0.8 | 139.0  | 164.0 | 189.0 | 202.0 | 206.0 | 207.0 |     |     | 0.0       |
| 2                 | 12282           | RH | 4.0 | -      | 104.0 | 129.0 | 142.0 | 146.0 | 147.0 |     |     | 60.0      |
| 3                 | 12283           | HL | 4.0 | -      | -     | 104.0 | 117.0 | 121.0 | 122.0 |     |     | 25.0      |
| 4                 | 12284           | LC | 9.5 | -      | -     | -     | 104.0 | 108.0 | 109.0 |     |     | 13.0      |
| 5                 | 12285           | LC | 7.5 | -      | -     | -     | -     | 104.0 | 105.0 |     |     | 4.0       |
| 6                 | 12286           | LC | 4.5 | -      | -     | -     | -     | -     | 103.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | ACUD  |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |       |       |     |     |           |
| 1                 | 12291           | RH | 0.7 | 141.0  | 167.0 | 192.0 | 204.0 | 207.0 | 208.0 |     |     | 0.0       |
| 2                 | 12292           | RH | 3.7 | -      | 104.0 | 129.0 | 141.0 | 144.0 | 145.0 |     |     | 63.0      |
| 3                 | 12293           | HL | 3.7 | -      | -     | 104.0 | 116.0 | 119.0 | 120.0 |     |     | 25.0      |
| 4                 | 12294           | LC | 9.0 | -      | -     | -     | 104.0 | 107.0 | 108.0 |     |     | 12.0      |
| 5                 | 12295           | LC | 7.0 | -      | -     | -     | -     | 104.0 | 105.0 |     |     | 3.0       |
| 6                 | 12296           | LC | 4.2 | -      | -     | -     | -     | -     | 103.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |       |       |     |     |           |
| 1                 | 12301           | RH | 0.6 | 143.0  | 169.0 | 194.0 | 206.0 | 209.0 | 210.0 |     |     | 0.0       |
| 2                 | 12302           | RH | 3.5 | -      | 104.0 | 129.0 | 141.0 | 144.0 | 145.0 |     |     | 65.0      |
| 3                 | 12303           | HL | 3.5 | -      | -     | 104.0 | 116.0 | 119.0 | 120.0 |     |     | 25.0      |
| 4                 | 12304           | LC | 8.5 | -      | -     | -     | 104.0 | 107.0 | 108.0 |     |     | 12.0      |
| 5                 | 12305           | LC | 6.5 | -      | -     | -     | -     | 104.0 | 105.0 |     |     | 3.0       |
| 6                 | 12306           | LC | 4.0 | -      | -     | -     | -     | -     | 103.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 5mm                | ACUD    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 941                   | 12201                 | 12202                 | 12203                    | 12204                 | 12205                 | 12206                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                       | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                       | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                       | 6                     | 6                     | 10                    |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 5.0                   | 12.0                     | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 9                     | 10                    | 10                       |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                       | 10                    | 10                    | 8                     |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 1                        | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 8                     | 10                       | 10                    | 9                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                        | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 56.0<br>(53.0 ~ 59.0) | 74.0<br>(72.0 ~ 76.0) | 110.0<br>(108.0 ~ 112.0) | 68.0<br>(66.0 ~ 70.0) | 84.0<br>(82.0 ~ 86.0) | 80.0<br>(78.0 ~ 82.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                      | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                       | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 10                    | 10                       | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 12                    | 4                     | 4                        | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 2.0                   | 6.0                   | 8.0                   | 8.0                      | 12.0                  | 10.5                  | 8.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 115.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 179.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 214.0 | 139.0 | 104.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 229.0 | 154.0 | 119.0 | 104.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 232.0 | 157.0 | 122.0 | 107.0 | 104.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 234.0 | 159.0 | 124.0 | 109.0 | 106.0 | 103.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 75.0  | 35.0  | 15.0  | 3.0   | 3.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 6.4 ~ 7.8   | 11.5 ~ 14.1 | 12.1 ~ 14.9 | 11.2 ~ 12.5 | 9.7 ~ 10.7  | 7.4 ~ 8.2   |  |
| Average Voltage Gap  | V   |  | 41 ~ 67     | 66 ~ 81     | 107 ~ 117   | 78 ~ 92     | 91 ~ 105    | 89 ~ 103    |  |
| Avg. Linear Feedrate | ALF |  | 426.0       | 274.0       | 204.7       | 159.0       | 126.2       | 99.4        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 10mm               | ACUD    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 941                   | 12211                 | 12212                 | 12213                 | 12214                 | 12215                 | 12216                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 7                     | 6                     | 10                    |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 5.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 9                     | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                    | 10                    | 10                    | 8                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 7                     | 8                     | 10                    | 10                    | 9                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 64.0<br>(62.0 ~ 66.0) | 88.0<br>(86.0 ~ 90.0) | 72.0<br>(70.0 ~ 74.0) | 72.0<br>(70.0 ~ 74.0) | 62.0<br>(60.0 ~ 64.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 2.0                   | 4.0                   | 8.0                   | 7.5                   | 11.0                  | 10.0                  | 7.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 121.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 174.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 209.0 | 139.0 | 104.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 223.0 | 153.0 | 118.0 | 104.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 226.0 | 156.0 | 121.0 | 107.0 | 104.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 228.0 | 158.0 | 123.0 | 109.0 | 106.0 | 103.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 70.0  | 35.0  | 14.0  | 3.0   | 3.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 4.6 ~ 5.6   | 11.1 ~ 13.6 | 10.4 ~ 12.7 | 10.3 ~ 11.4 | 9.3 ~ 10.3  | 7.0 ~ 7.8   |  |
| Average Voltage Gap  | V   |  | 32 ~ 53     | 57 ~ 74     | 85 ~ 95     | 80 ~ 94     | 83 ~ 96     | 76 ~ 90     |  |
| Avg. Linear Feedrate | ALF |  | 306.0       | 216.6       | 165.0       | 131.6       | 107.6       | 86.6        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 20mm               | ACUD    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 941                   | 12221                 | 12222                 | 12223                 | 12224                 | 12225                 | 12226                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 8                     | 7                     | 11                    |       |       |
| Power Setting      | IP  | 6.0                   | 8.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 9                     | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 9                     | 10                    | 10                    | 8                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 9                     | 10                    | 9                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 42.0<br>(39.0 ~ 45.0) | 60.0<br>(58.0 ~ 62.0) | 80.0<br>(78.0 ~ 82.0) | 72.0<br>(70.0 ~ 74.0) | 64.0<br>(62.0 ~ 66.0) | 50.0<br>(48.0 ~ 52.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 11                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 2.0                   | 3.0                   | 6.0                   | 7.0                   | 10.5                  | 9.5                   | 7.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 123.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 174.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 209.0 | 139.0 | 104.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 221.0 | 151.0 | 116.0 | 104.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 225.0 | 155.0 | 120.0 | 108.0 | 104.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 227.0 | 157.0 | 122.0 | 110.0 | 106.0 | 103.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 70.0  | 35.0  | 12.0  | 4.0   | 3.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 3.3 ~ 4.1   | 8.4 ~ 10.3  | 7.9 ~ 9.7   | 10.0 ~ 11.0 | 9.0 ~ 9.9   | 6.6 ~ 7.4   |  |
| Average Voltage Gap  | V   |  | 32 ~ 53     | 52 ~ 68     | 77 ~ 87     | 80 ~ 94     | 73 ~ 86     | 60 ~ 74     |  |
| Avg. Linear Feedrate | ALF |  | 222.0       | 159.1       | 122.2       | 102.4       | 86.7        | 71.9        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 30mm               | ACUD    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 942                   | 12231                 | 12232                 | 12233                 | 12234                 | 12235                 | 12236                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 10                    | 8                     | 13                    |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 9                     | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 9                     | 10                    | 8                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 9                     | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 41.0<br>(38.0 ~ 44.0) | 60.0<br>(58.0 ~ 62.0) | 70.0<br>(68.0 ~ 72.0) | 55.0<br>(53.0 ~ 57.0) | 64.0<br>(62.0 ~ 66.0) | 55.0<br>(53.0 ~ 57.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.5                   | 5.0                   | 5.5                   | 10.5                  | 9.0                   | 6.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 128.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 169.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 199.0 | 134.0 | 104.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 213.0 | 148.0 | 118.0 | 104.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 215.0 | 150.0 | 120.0 | 106.0 | 104.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 216.0 | 151.0 | 121.0 | 107.0 | 105.0 | 103.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 30.0  | 14.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 2.8 ~ 3.4   | 5.5 ~ 6.5   | 7.5 ~ 9.2   | 10.2 ~ 11.2 | 8.5 ~ 9.2   | 5.7 ~ 6.0   |  |
| Average Voltage Gap  | V   |  | 33 ~ 48     | 51 ~ 69     | 67 ~ 77     | 55 ~ 75     | 64 ~ 77     | 59 ~ 73     |  |
| Avg. Linear Feedrate | ALF |  | 186.0       | 122.6       | 98.5        | 85.4        | 73.6        | 60.8        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 40mm               | ACUD    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 942                   | 12241                 | 12242                 | 12243                 | 12244                 | 12245                 | 12246                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 10                    | 8                     | 13                    |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 9                     | 10                    | 8                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 8                     | 9                     | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 60.0<br>(58.0 ~ 62.0) | 68.0<br>(66.0 ~ 70.0) | 46.0<br>(44.0 ~ 48.0) | 64.0<br>(62.0 ~ 66.0) | 62.0<br>(60.0 ~ 64.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.0                   | 5.0                   | 5.0                   | 10.5                  | 8.5                   | 5.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 164.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 189.0 | 129.0 | 104.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 203.0 | 143.0 | 118.0 | 104.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 205.0 | 145.0 | 120.0 | 106.0 | 104.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 206.0 | 146.0 | 121.0 | 107.0 | 105.0 | 103.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 25.0  | 14.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 2.0 ~ 2.5   | 5.5 ~ 6.4   | 7.2 ~ 8.9   | 10.3 ~ 11.4 | 8.0 ~ 8.8   | 5.3 ~ 5.9   |  |
| Average Voltage Gap  | V   |  | 31 ~ 50     | 49 ~ 70     | 65 ~ 75     | 41 ~ 55     | 59 ~ 72     | 57 ~ 71     |  |
| Avg. Linear Feedrate | ALF |  | 135.0       | 98.0        | 81.4        | 72.4        | 63.3        | 53.3        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 50mm               | ACUD    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 943                   | 12251                 | 12252                 | 12253                 | 12254                 | 12255                 | 12256                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 10                    | 9                     | 13                    |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 9                     | 10                    | 8                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 6                     | 8                     | 9                     | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 39.0<br>(36.0 ~ 42.0) | 58.0<br>(56.0 ~ 60.0) | 61.0<br>(59.0 ~ 63.0) | 41.0<br>(39.0 ~ 43.0) | 58.0<br>(56.0 ~ 60.0) | 55.0<br>(53.0 ~ 57.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.5                   | 4.7                   | 4.7                   | 10.2                  | 8.2                   | 5.2                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 162.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 187.0 | 129.0 | 104.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 202.0 | 144.0 | 119.0 | 104.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 205.0 | 147.0 | 122.0 | 107.0 | 104.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 206.0 | 148.0 | 123.0 | 108.0 | 105.0 | 103.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 58.0  | 25.0  | 15.0  | 3.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.9 ~ 2.3   | 5.2 ~ 6.2   | 5.5 ~ 6.9   | 10.2 ~ 11.0 | 7.8 ~ 8.6   | 5.1 ~ 5.7   |  |
| Average Voltage Gap  | V   |  | 29 ~ 49     | 47 ~ 58     | 58 ~ 68     | 37 ~ 50     | 54 ~ 67     | 52 ~ 66     |  |
| Avg. Linear Feedrate | ALF |  | 126.0       | 92.1        | 73.8        | 66.1        | 58.3        | 49.4        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 60mm               | ACUD    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 943                   | 12261                 | 12262                 | 12263                 | 12264                 | 12265                 | 12266                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 10                    | 9                     | 13                    |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 9                     | 10                    | 8                     | 6                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 6                     | 8                     | 9                     | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 38.0<br>(35.0 ~ 41.0) | 56.0<br>(54.0 ~ 58.0) | 59.0<br>(57.0 ~ 61.0) | 36.0<br>(34.0 ~ 38.0) | 52.0<br>(50.0 ~ 54.0) | 48.0<br>(46.0 ~ 50.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.0                   | 4.5                   | 4.5                   | 10.0                  | 8.0                   | 5.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 158.0 | 103.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 183.0 | 128.0 | 103.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 198.0 | 143.0 | 118.0 | 103.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 201.0 | 146.0 | 121.0 | 106.0 | 103.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 202.0 | 147.0 | 122.0 | 107.0 | 104.0 | 102.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 55.0  | 25.0  | 15.0  | 3.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.6 ~ 1.9   | 4.9 ~ 5.9   | 3.9 ~ 4.8   | 9.7 ~ 10.7  | 7.7 ~ 8.5   | 5.0 ~ 5.5   |  |
| Average Voltage Gap  | V   |  | 28 ~ 49     | 46 ~ 65     | 56 ~ 66     | 33 ~ 46     | 49 ~ 62     | 47 ~ 60     |  |
| Avg. Linear Feedrate | ALF |  | 105.0       | 79.3        | 60.8        | 55.3        | 49.7        | 42.9        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 70mm               | ACUD    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 944                   | 12271                 | 12272                 | 12273                 | 12274                 | 12275                 | 12276                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 11                    | 10                    | 10                    |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 7                     | 8                     | 10                    | 8                     | 5                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 7                     | 7                     | 8                     | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 39.0<br>(36.0 ~ 42.0) | 55.0<br>(53.0 ~ 57.0) | 57.0<br>(55.0 ~ 59.0) | 36.0<br>(34.0 ~ 38.0) | 49.0<br>(47.0 ~ 51.0) | 46.0<br>(44.0 ~ 48.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.9                   | 4.2                   | 4.2                   | 9.7                   | 7.7                   | 4.7                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 137.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 162.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 187.0 | 129.0 | 104.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 201.0 | 143.0 | 118.0 | 104.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 205.0 | 147.0 | 122.0 | 108.0 | 104.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 206.0 | 148.0 | 123.0 | 109.0 | 105.0 | 103.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 58.0  | 25.0  | 14.0  | 4.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.2 ~ 1.5   | 4.4 ~ 5.4   | 3.7 ~ 4.6   | 9.2 ~ 10.2  | 7.2 ~ 7.9   | 4.6 ~ 5.0   |  |
| Average Voltage Gap  | V   |  | 28 ~ 51     | 44 ~ 64     | 54 ~ 64     | 34 ~ 47     | 45 ~ 57     | 44 ~ 56     |  |
| Avg. Linear Feedrate | ALF |  | 81.0        | 63.5        | 50.6        | 46.6        | 42.2        | 36.8        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 80mm               | ACUD    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 944                   | 12281                 | 12282                 | 12283                 | 12284                 | 12285                 | 12286                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 12                    | 10                    | 10                    |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 7                     | 8                     | 10                    | 8                     | 4                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 7                     | 7                     | 8                     | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 54.0<br>(52.0 ~ 56.0) | 55.0<br>(53.0 ~ 57.0) | 36.0<br>(34.0 ~ 38.0) | 46.0<br>(44.0 ~ 48.0) | 44.0<br>(42.0 ~ 46.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.8                   | 4.0                   | 4.0                   | 9.5                   | 7.5                   | 4.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 139.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 164.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 189.0 | 129.0 | 104.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 202.0 | 142.0 | 117.0 | 104.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 206.0 | 146.0 | 121.0 | 108.0 | 104.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 207.0 | 147.0 | 122.0 | 109.0 | 105.0 | 103.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 25.0  | 13.0  | 4.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.9 ~ 1.1   | 4.0 ~ 4.9   | 3.6 ~ 4.4   | 8.9 ~ 9.8   | 6.7 ~ 7.4   | 4.2 ~ 4.6   |  |
| Average Voltage Gap  | V   |  | 29 ~ 52     | 43 ~ 64     | 52 ~ 62     | 35 ~ 47     | 42 ~ 54     | 40 ~ 53     |  |
| Avg. Linear Feedrate | ALF |  | 60.0        | 49.0        | 40.7        | 37.9        | 34.8        | 30.8        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 90mm               | ACUD    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 945                   | 12291                 | 12292                 | 12293                 | 12294                 | 12295                 | 12296                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 13                    | 11                    | 11                    |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 7                     | 7                     | 10                    | 8                     | 4                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 6                     | 8                     | 7                     | 7                     | 9                     | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 43.0<br>(40.0 ~ 46.0) | 52.0<br>(50.0 ~ 54.0) | 51.0<br>(49.0 ~ 53.0) | 36.0<br>(34.0 ~ 38.0) | 44.0<br>(42.0 ~ 46.0) | 43.0<br>(41.0 ~ 45.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.7                   | 3.7                   | 3.7                   | 9.0                   | 7.0                   | 4.2                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 141.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 167.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 192.0 | 129.0 | 104.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 204.0 | 141.0 | 116.0 | 104.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 207.0 | 144.0 | 119.0 | 107.0 | 104.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 208.0 | 145.0 | 120.0 | 108.0 | 105.0 | 103.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 63.0  | 25.0  | 12.0  | 3.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.7 ~ 1.0   | 3.8 ~ 4.6   | 3.4 ~ 4.2   | 8.5 ~ 9.4   | 6.5 ~ 7.2   | 3.8 ~ 4.3   |  |
| Average Voltage Gap  | V   |  | 33 ~ 56     | 42 ~ 61     | 48 ~ 58     | 34 ~ 47     | 40 ~ 52     | 37 ~ 51     |  |
| Avg. Linear Feedrate | ALF |  | 51.0        | 42.4        | 35.8        | 33.5        | 31.0        | 27.5        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 100mm              | ACUD    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 945                   | 12301                 | 12302                 | 12303                 | 12304                 | 12305                 | 12306                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 14                    | 11                    | 11                    |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 7                     | 7                     | 10                    | 8                     | 4                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 6                     | 8                     | 7                     | 7                     | 9                     | 7                     | 7                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 46.0<br>(43.0 ~ 49.0) | 50.0<br>(48.0 ~ 52.0) | 47.0<br>(45.0 ~ 49.0) | 36.0<br>(34.0 ~ 38.0) | 43.0<br>(41.0 ~ 45.0) | 42.0<br>(40.0 ~ 44.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.6                   | 3.5                   | 3.5                   | 8.5                   | 6.5                   | 4.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 143.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 169.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 194.0 | 129.0 | 104.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 206.0 | 141.0 | 116.0 | 104.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 209.0 | 144.0 | 119.0 | 107.0 | 104.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 210.0 | 145.0 | 120.0 | 108.0 | 105.0 | 103.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 25.0  | 12.0  | 3.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.6 ~ 0.9   | 3.6 ~ 4.4   | 3.2 ~ 3.9   | 8.1 ~ 9.0   | 6.3 ~ 7.0   | 3.5 ~ 3.9   |  |
| Average Voltage Gap  | V   |  | 36 ~ 60     | 41 ~ 59     | 44 ~ 54     | 33 ~ 46     | 39 ~ 51     | 36 ~ 49     |  |
| Avg. Linear Feedrate | ALF |  | 45.0        | 37.9        | 32.2        | 30.3        | 28.1        | 25.0        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | SPB   |

Thickness 5 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 1141            | RH | 7.0  | 120.0  | 161.0 | 172.0 | 174.0 |     |     |     |     | 0.0       |
| 2                 | 1142            | MP | 6.5  | -      | 106.0 | 117.0 | 119.0 |     |     |     |     | 55.0      |
| 3                 | 1143            | LC | 11.0 | -      | -     | 108.0 | 110.0 |     |     |     |     | 9.0       |
| 4                 | 1144            | LA | 15.5 | -      | -     | -     | 106.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 1151            | RH | 5.0  | 128.0  | 159.0 | 169.0 | 172.0 |     |     |     |     | 0.0       |
| 2                 | 1152            | MP | 6.0  | -      | 104.0 | 114.0 | 117.0 |     |     |     |     | 55.0      |
| 3                 | 1153            | LC | 11.2 | -      | -     | 108.0 | 111.0 |     |     |     |     | 6.0       |
| 4                 | 1154            | LA | 12.2 | -      | -     | -     | 107.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 1161            | RH | 2.8  | 133.0  | 158.0 | 165.0 | 167.0 |     |     |     |     | 0.0       |
| 2                 | 1162            | MP | 4.5  | -      | 108.0 | 115.0 | 117.0 |     |     |     |     | 50.0      |
| 3                 | 1163            | LC | 10.5 | -      | -     | 111.0 | 113.0 |     |     |     |     | 4.0       |
| 4                 | 1164            | LA | 8.5  | -      | -     | -     | 109.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | SPB   |

Thickness 30 mm

| No,               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 1171            | RH | 2.3  | 135.0  | 161.0 | 168.0 | 169.0 |     |     |     |     | 0.0       |
| 2                 | 1172            | MP | 4.0  | -      | 109.0 | 116.0 | 117.0 |     |     |     |     | 52.0      |
| 3                 | 1173            | LC | 10.0 | -      | -     | 109.0 | 110.0 |     |     |     |     | 7.0       |
| 4                 | 1174            | LA | 8.2  | -      | -     | -     | 107.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 1181            | RH | 1.8 | 136.0  | 164.0 | 172.0 | 175.0 |     |     |     |     | 0.0       |
| 2                 | 1182            | MP | 3.4 | -      | 109.0 | 117.0 | 120.0 |     |     |     |     | 55.0      |
| 3                 | 1183            | LC | 9.0 | -      | -     | 107.0 | 110.0 |     |     |     |     | 10.0      |
| 4                 | 1184            | LA | 8.0 | -      | -     | -     | 108.0 |     |     |     |     | 2.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 1191            | RH | 1.4 | 135.0  | 165.0 | 174.0 | 178.0 |     |     |     |     | 0.0       |
| 2                 | 1192            | MP | 3.5 | -      | 109.0 | 118.0 | 122.0 |     |     |     |     | 56.0      |
| 3                 | 1193            | LC | 7.5 | -      | -     | 108.0 | 112.0 |     |     |     |     | 10.0      |
| 4                 | 1194            | LA | 6.2 | -      | -     | -     | 108.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | SPB   |

Thickness 60 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 1201            | RH | 1.0 | 135.0  | 167.0 | 177.0 | 180.0 |     |     |     |     | 0.0       |
| 2                 | 1202            | MP | 3.6 | -      | 109.0 | 119.0 | 122.0 |     |     |     |     | 58.0      |
| 3                 | 1203            | LC | 6.0 | -      | -     | 109.0 | 112.0 |     |     |     |     | 10.0      |
| 4                 | 1204            | LA | 4.5 | -      | -     | -     | 107.0 |     |     |     |     | 5.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 1211            | RH | 0.8 | 134.0  | 171.0 | 181.0 | 183.0 |     |     |     |     | 0.0       |
| 2                 | 1212            | MP | 3.2 | -      | 109.0 | 119.0 | 121.0 |     |     |     |     | 62.0      |
| 3                 | 1213            | LC | 5.1 | -      | -     | 110.0 | 112.0 |     |     |     |     | 9.0       |
| 4                 | 1214            | LA | 4.2 | -      | -     | -     | 108.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 1221            | RH | 0.7 | 134.0  | 174.0 | 185.0 | 185.0 |     |     |     |     | 0.0       |
| 2                 | 1222            | MP | 2.8 | -      | 109.0 | 120.0 | 120.0 |     |     |     |     | 65.0      |
| 3                 | 1223            | LC | 4.2 | -      | -     | 111.0 | 111.0 |     |     |     |     | 9.0       |
| 4                 | 1224            | LA | 4.0 | -      | -     | -     | 108.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | SPB   |

Thickness 90 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 1231            | RH | 0.6 | 136.0  | 176.0 | 186.0 | 189.0 |     |     |     |     | 0.0       |
| 2                 | 1232            | MP | 2.5 | -      | 109.0 | 119.0 | 122.0 |     |     |     |     | 67.0      |
| 3                 | 1233            | LC | 4.2 | -      | -     | 111.0 | 114.0 |     |     |     |     | 8.0       |
| 4                 | 1234            | LA | 4.0 | -      | -     | -     | 109.0 |     |     |     |     | 5.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 1241            | RH | 0.6 | 138.0  | 179.0 | 189.0 | 192.0 |     |     |     |     | 0.0       |
| 2                 | 1242            | MP | 2.2 | -      | 109.0 | 119.0 | 122.0 |     |     |     |     | 70.0      |
| 3                 | 1243            | LC | 4.2 | -      | -     | 111.0 | 114.0 |     |     |     |     | 8.0       |
| 4                 | 1244            | LA | 4.0 | -      | -     | -     | 109.0 |     |     |     |     | 5.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No,               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 5mm                | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                    | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 1141                  | 1142                  | 1143                     | 1144                     |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                       | LA                       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 8                        | 12                       |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 6.0                   | 3.0                      | 1.5                      |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                          |       |       |       |       |
| Off Time           | OFF | 6                     | 2                     | 1                     | 1                        | 1                        |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 1                     | 1                        | 1                        |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 16                    | 1                        | 1                        |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                        |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                        |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 48.0<br>(45.0 ~ 51.0) | 84.0<br>(82.0 ~ 86.0) | 140.0<br>(138.0 ~ 142.0) | 150.0<br>(148.0 ~ 152.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                      |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 10                    | 9                        | 9                        |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 9                     | 9                        | 9                        |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 6                     | 4                        | 4                        |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 7.0                   | 6.5                   | 11.0                     | 15.5                     |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 120.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 161.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 172.0 | 117.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 174.0 | 119.0 | 110.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 55.0  | 9.0   | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 9.7 ~ 10.6  | 14.4 ~ 17.7 | 9.7 ~ 10.7  | 12.8 ~ 15.0 |  |  |  |
| Average Voltage Gap  | V   |  | 49 ~ 63     | 99 ~ 113    | 158 ~ 170   | 149 ~ 165   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 609.0       | 373.1       | 231.8       | 181.4       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 10mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                    | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 1151                  | 1152                  | 1153                     | 1154                     |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                       | LA                       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 8                        | 12                       |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 8.0                   | 6.0                   | 3.0                      | 1.5                      |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                          |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 1                     | 1                        | 1                        |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                        |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 8                     | 16                    | 1                        | 1                        |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                        |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                        |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 49.0<br>(46.0 ~ 52.0) | 80.0<br>(78.0 ~ 82.0) | 135.0<br>(133.0 ~ 137.0) | 135.0<br>(133.0 ~ 137.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                      |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 10                    | 9                        | 9                        |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 9                     | 9                        | 9                        |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 6                     | 4                        | 4                        |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 5.0                   | 6.0                   | 11.2                     | 12.2                     |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 128.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 159.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 169.0 | 114.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 172.0 | 117.0 | 111.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 55.0  | 6.0   | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 6.1 ~ 6.6   | 13.2 ~ 16.1 | 9.8 ~ 10.9  | 10.8 ~ 12.0 |  |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 54     | 91 ~ 108    | 149 ~ 161   | 133 ~ 148   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 381.0       | 265.8       | 186.1       | 146.3       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 20mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                    | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 1161                  | 1162                  | 1163                     | 1164                     |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                       | LA                       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                       | 13                       |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 9.0                   | 7.0                   | 3.0                      | 1.5                      |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                          |                          |       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 1                     | 1                        | 1                        |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                        |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 8                     | 16                    | 1                        | 1                        |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                        |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                        |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 42.0<br>(39.0 ~ 45.0) | 79.0<br>(77.0 ~ 81.0) | 125.0<br>(123.0 ~ 127.0) | 105.0<br>(103.0 ~ 107.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                      | OFF                      |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 9                        | 9                        |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 9                     | 9                        | 9                        |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                        | 4                        |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 40                    | 20                       | 20                       |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 2.8                   | 4.5                   | 10.5                     | 8.5                      |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 158.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 165.0 | 115.0 | 111.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 167.0 | 117.0 | 113.0 | 109.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 50.0  | 4.0   | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.8 ~ 4.1   | 8.1 ~ 9.9   | 9.4 ~ 10.4  | 7.6 ~ 8.5   |  |  |  |
| Average Voltage Gap  | V   |  | 32 ~ 54     | 82 ~ 97     | 155 ~ 169   | 116 ~ 129   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 237.0       | 164.7       | 129.0       | 101.8       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 30mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 1171                  | 1172                  | 1173                     | 1174                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                       | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                       | 13                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 7.0                   | 3.0                      | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 15                    | 1                        | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 80.0<br>(78.0 ~ 82.0) | 107.0<br>(105.0 ~ 109.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 9                     | 9                        | 9                     |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 40                    | 20                       | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.3                   | 4.0                   | 10.0                     | 8.2                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 161.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 168.0 | 116.0 | 109.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 169.0 | 117.0 | 110.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 52.0  | 7.0   | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.0 ~ 3.3   | 5.9 ~ 7.1   | 9.1 ~ 9.9   | 7.4 ~ 8.2   |  |  |  |
| Average Voltage Gap  | V   |  | 30 ~ 50     | 75 ~ 85     | 129 ~ 143   | 96 ~ 109    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 189.0       | 127.3       | 104.1       | 85.1        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 40mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 1181                  | 1182                  | 1183                  | 1184                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                    | 13                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 7.0                   | 3.0                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 2                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 15                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 36.0<br>(33.0 ~ 39.0) | 80.0<br>(78.0 ~ 82.0) | 90.0<br>(88.0 ~ 92.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 13                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 9                     | 9                     | 9                     |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 40                    | 30                    | 30                    |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.8                   | 3.4                   | 9.0                   | 8.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 136.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 164.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 172.0 | 117.0 | 107.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 175.0 | 120.0 | 110.0 | 108.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 55.0  | 10.0  | 2.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.2 ~ 2.9   | 5.0 ~ 6.1   | 8.1 ~ 9.0   | 7.2 ~ 8.0   |  |  |  |
| Average Voltage Gap  | V   |  | 27 ~ 48     | 73 ~ 88     | 113 ~ 127   | 77 ~ 92     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 153.0       | 104.8       | 87.0        | 73.1        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 50mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 943                   | 1191                  | 1192                  | 1193                  | 1194                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                    | 13                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 7.0                   | 3.0                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 2                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 16                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 34.0<br>(31.0 ~ 37.0) | 74.0<br>(72.0 ~ 76.0) | 85.0<br>(83.0 ~ 87.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 13                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 9                     | 9                     | 9                     |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 45                    | 30                    | 30                    |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.4                   | 3.5                   | 7.5                   | 6.2                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 165.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 174.0 | 118.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 178.0 | 122.0 | 112.0 | 108.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 56.0  | 10.0  | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.6 ~ 2.2   | 3.3 ~ 4.0   | 7.0 ~ 7.5   | 5.7 ~ 6.2   |  |  |  |
| Average Voltage Gap  | V   |  | 25 ~ 42     | 70 ~ 82     | 102 ~ 115   | 68 ~ 82     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 114.0       | 75.0        | 64.0        | 54.2        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 60mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 943                   | 1201                  | 1202                  | 1203                  | 1204                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                    | 13                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 7.0                   | 3.0                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 2                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 3                     | 16                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 72.0<br>(70.0 ~ 74.0) | 80.0<br>(78.0 ~ 82.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 13                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 7                     | 9                     | 9                     | 9                     |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 16                    | 6                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 50                    | 40                    | 40                    |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.0                   | 3.6                   | 6.0                   | 4.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 167.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 177.0 | 119.0 | 109.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 180.0 | 122.0 | 112.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 58.0  | 10.0  | 5.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.8 ~ 2.0   | 3.1 ~ 3.8   | 5.5 ~ 6.0   | 4.2 ~ 4.6   |  |  |  |
| Average Voltage Gap  | V   |  | 23 ~ 38     | 65 ~ 79     | 96 ~ 109    | 60 ~ 73     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 114.0       | 73.5        | 60.6        | 49.3        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 70mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 944                   | 1211                  | 1212                  | 1213                  | 1214                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                    | 13                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 8.0                   | 3.0                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 16                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 33.0<br>(30.0 ~ 36.0) | 60.0<br>(58.0 ~ 62.0) | 75.0<br>(73.0 ~ 77.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 13                    | 11                    | 11                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 9                     | 9                     | 9                     |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 50                    | 40                    | 40                    |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.8                   | 3.2                   | 5.1                   | 4.2                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 134.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 171.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 181.0 | 119.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 183.0 | 121.0 | 112.0 | 108.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 62.0  | 9.0   | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.0 ~ 1.6   | 2.9 ~ 3.5   | 4.6 ~ 5.1   | 3.7 ~ 4.2   |  |  |  |
| Average Voltage Gap  | V   |  | 24 ~ 37     | 52 ~ 70     | 81 ~ 95     | 57 ~ 69     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 78.0        | 55.5        | 46.6        | 38.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 80mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 944                   | 1221                  | 1222                  | 1223                  | 1224                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                    | 13                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 9.0                   | 3.0                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 16                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(32.0 ~ 38.0) | 50.0<br>(48.0 ~ 52.0) | 68.0<br>(66.0 ~ 70.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 13                    | 11                    | 11                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 9                     | 9                     | 9                     |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 50                    | 40                    | 40                    |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.7                   | 2.8                   | 4.2                   | 4.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 134.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 174.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 185.0 | 120.0 | 111.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 185.0 | 120.0 | 111.0 | 108.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 9.0   | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 0.7 ~ 1.3   | 2.7 ~ 3.3   | 3.6 ~ 4.0   | 3.6 ~ 4.0   |  |  |  |
| Average Voltage Gap  | V   |  | 25 ~ 36     | 45 ~ 64     | 77 ~ 90     | 51 ~ 64     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 60.0        | 45.0        | 37.6        | 32.3        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 90mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 945                   | 1231                  | 1232                  | 1233                  | 1234                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 12                    | 14                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 10.0                  | 3.0                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 16                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 41.0<br>(39.0 ~ 43.0) | 62.0<br>(60.0 ~ 64.0) | 42.0<br>(40.0 ~ 44.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 13                    | 12                    | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 9                     | 9                     | 9                     |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 50                    | 30                    | 30                    |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.6                   | 2.5                   | 4.2                   | 4.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 136.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 176.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 186.0 | 119.0 | 111.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 189.0 | 122.0 | 114.0 | 109.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 67.0  | 8.0   | 5.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 0.6 ~ 1.0   | 2.7 ~ 3.3   | 3.7 ~ 4.0   | 3.6 ~ 4.0   |  |  |  |
| Average Voltage Gap  | V   |  | 30 ~ 40     | 43 ~ 55     | 72 ~ 85     | 48 ~ 60     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 48.0        | 37.9        | 32.6        | 28.5        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 100mm              | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 945                   | 1241                  | 1242                  | 1243                  | 1244                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 13                    | 16                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 11.0                  | 3.0                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 16                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 42.0<br>(39.0 ~ 45.0) | 42.0<br>(40.0 ~ 44.0) | 60.0<br>(58.0 ~ 62.0) | 35.0<br>(33.0 ~ 37.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 13                    | 12                    | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 9                     | 9                     | 9                     |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 50                    | 30                    | 30                    |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.6                   | 2.2                   | 4.2                   | 4.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 138.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 179.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 189.0 | 119.0 | 111.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 192.0 | 122.0 | 114.0 | 109.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 8.0   | 5.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 0.5 ~ 0.8   | 2.7 ~ 3.3   | 3.8 ~ 4.1   | 3.6 ~ 4.0   |  |  |  |
| Average Voltage Gap  | V   |  | 36 ~ 46     | 38 ~ 52     | 68 ~ 81     | 47 ~ 58     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 39.0        | 32.1        | 28.2        | 25.1        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | WC-Co         | STD   |

Thickness 5 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 1401            | RL | 3.0 | 125.0  | 165.0 | 178.0 | 182.0 | 183.0 |     |     |     | 0.0       |
| 2                 | 1402            | KL | 6.0 | -      | 105.0 | 118.0 | 122.0 | 123.0 |     |     |     | 60.0      |
| 3                 | 1403            | LC | 8.0 | -      | -     | 105.0 | 109.0 | 110.0 |     |     |     | 13.0      |
| 4                 | 1404            | LC | 8.0 | -      | -     | -     | 105.0 | 106.0 |     |     |     | 4.0       |
| 5                 | 1405            | LC | 7.0 | -      | -     | -     | -     | 104.0 |     |     |     | 2.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 13.0  | 6.0   | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.80  | 0.80  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 1411            | RL | 2.5 | 133.0  | 165.0 | 173.0 | 182.0 | 184.0 |     |     |     | 0.0       |
| 2                 | 1412            | KL | 5.0 | -      | 105.0 | 113.0 | 122.0 | 124.0 |     |     |     | 60.0      |
| 3                 | 1413            | LC | 7.0 | -      | -     | 105.0 | 114.0 | 116.0 |     |     |     | 8.0       |
| 4                 | 1414            | LC | 7.0 | -      | -     | -     | 105.0 | 107.0 |     |     |     | 9.0       |
| 5                 | 1415            | LC | 6.0 | -      | -     | -     | -     | 104.0 |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 13.0  | 6.0   | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.80  | 0.80  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 1421            | RL | 1.5 | 130.0  | 165.0 | 171.0 | 180.0 | 182.0 |     |     |     | 0.0       |
| 2                 | 1422            | KL | 3.5 | -      | 105.0 | 111.0 | 120.0 | 122.0 |     |     |     | 60.0      |
| 3                 | 1423            | LC | 7.0 | -      | -     | 105.0 | 114.0 | 116.0 |     |     |     | 6.0       |
| 4                 | 1424            | LC | 6.0 | -      | -     | -     | 105.0 | 107.0 |     |     |     | 9.0       |
| 5                 | 1425            | LC | 6.0 | -      | -     | -     | -     | 104.0 |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 13.0  | 6.0   | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.80  | 0.80  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | WC-Co         | STD   |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 1431            | RL | 1.2 | 132.0  | 163.0 | 183.0 | 195.0 | 200.0 | 201.0 |     |     | 0.0       |
| 2                 | 1432            | KL | 2.0 | -      | 106.0 | 126.0 | 138.0 | 143.0 | 144.0 |     |     | 57.0      |
| 3                 | 1433            | RL | 2.5 | -      | -     | 106.0 | 118.0 | 123.0 | 124.0 |     |     | 20.0      |
| 4                 | 1434            | LC | 6.0 | -      | -     | -     | 106.0 | 111.0 | 112.0 |     |     | 12.0      |
| 5                 | 1435            | LC | 6.0 | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 5.0       |
| 6                 | 1436            | LC | 6.0 | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.20  | 1.80  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 1441            | RL | 1.0 | 135.0  | 161.0 | 181.0 | 193.0 | 198.0 | 199.0 |     |     | 0.0       |
| 2                 | 1442            | KL | 2.5 | -      | 106.0 | 126.0 | 138.0 | 143.0 | 144.0 |     |     | 55.0      |
| 3                 | 1443            | RL | 2.5 | -      | -     | 106.0 | 118.0 | 123.0 | 124.0 |     |     | 20.0      |
| 4                 | 1444            | LC | 6.0 | -      | -     | -     | 106.0 | 111.0 | 112.0 |     |     | 12.0      |
| 5                 | 1445            | LC | 6.0 | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 5.0       |
| 6                 | 1446            | LC | 6.0 | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.20  | 1.80  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |       |       |     |     |           |
| 1                 | 1451            | RL | 1.0 | 136.0  | 166.0 | 186.0 | 199.0 | 202.0 | 203.0 |     |     | 0.0       |
| 2                 | 1452            | KL | 2.7 | -      | 106.0 | 126.0 | 139.0 | 142.0 | 143.0 |     |     | 60.0      |
| 3                 | 1453            | RL | 2.2 | -      | -     | 106.0 | 119.0 | 122.0 | 123.0 |     |     | 20.0      |
| 4                 | 1454            | LC | 6.0 | -      | -     | -     | 106.0 | 109.0 | 110.0 |     |     | 13.0      |
| 5                 | 1455            | LC | 6.0 | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 3.0       |
| 6                 | 1456            | LC | 6.0 | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.20  | 1.80  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | WC-Co         | STD   |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |       |       |     |     |           |
| 1                 | 1461            | RL | 1.0 | 137.0  | 173.0 | 193.0 | 207.0 | 209.0 | 210.0 |     |     | 0.0       |
| 2                 | 1462            | KL | 3.0 | -      | 108.0 | 128.0 | 142.0 | 144.0 | 145.0 |     |     | 65.0      |
| 3                 | 1463            | RL | 2.0 | -      | -     | 108.0 | 122.0 | 124.0 | 125.0 |     |     | 20.0      |
| 4                 | 1464            | LC | 6.0 | -      | -     | -     | 108.0 | 110.0 | 111.0 |     |     | 14.0      |
| 5                 | 1465            | LC | 6.0 | -      | -     | -     | -     | 108.0 | 109.0 |     |     | 2.0       |
| 6                 | 1466            | LC | 6.0 | -      | -     | -     | -     | -     | 107.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.20  | 1.80  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |       |       |     |     |           |
| 1                 | 1471            | RL | 0.7 | 140.0  | 172.0 | 196.0 | 209.0 | 212.0 | 213.0 |     |     | 0.0       |
| 2                 | 1472            | KL | 3.0 | -      | 107.0 | 131.0 | 144.0 | 147.0 | 148.0 |     |     | 65.0      |
| 3                 | 1473            | RL | 1.7 | -      | -     | 107.0 | 120.0 | 123.0 | 124.0 |     |     | 24.0      |
| 4                 | 1474            | LC | 5.5 | -      | -     | -     | 107.0 | 110.0 | 111.0 |     |     | 13.0      |
| 5                 | 1475            | LC | 5.0 | -      | -     | -     | -     | 107.0 | 108.0 |     |     | 3.0       |
| 6                 | 1476            | LC | 5.0 | -      | -     | -     | -     | -     | 106.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.20  | 1.80  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |       |       |     |     |           |
| 1                 | 1481            | RL | 0.5 | 143.0  | 171.0 | 199.0 | 212.0 | 216.0 | 217.0 |     |     | 0.0       |
| 2                 | 1482            | KL | 3.0 | -      | 106.0 | 134.0 | 147.0 | 151.0 | 152.0 |     |     | 65.0      |
| 3                 | 1483            | RL | 1.4 | -      | -     | 106.0 | 119.0 | 123.0 | 124.0 |     |     | 28.0      |
| 4                 | 1484            | LC | 5.5 | -      | -     | -     | 106.0 | 110.0 | 111.0 |     |     | 13.0      |
| 5                 | 1485            | LC | 4.5 | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 4.0       |
| 6                 | 1486            | LC | 4.5 | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.20  | 1.80  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | WC-Co         | STD   |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |       |       |     |     |           |
| 1                 | 1491            | RL | 0.4 | 144.0  | 171.0 | 197.0 | 210.0 | 213.0 | 214.0 |     |     | 0.0       |
| 2                 | 1492            | KL | 2.2 | -      | 106.0 | 132.0 | 145.0 | 148.0 | 149.0 |     |     | 65.0      |
| 3                 | 1493            | RL | 1.3 | -      | -     | 106.0 | 119.0 | 122.0 | 123.0 |     |     | 26.0      |
| 4                 | 1494            | LC | 5.0 | -      | -     | -     | 106.0 | 109.0 | 110.0 |     |     | 13.0      |
| 5                 | 1495            | LC | 4.3 | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 3.0       |
| 6                 | 1496            | LC | 4.0 | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.20  | 1.80  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |       |       |     |     |           |
| 1                 | 1501            | RL | 0.3 | 146.0  | 171.0 | 196.0 | 209.0 | 211.0 | 212.0 |     |     | 0.0       |
| 2                 | 1502            | KL | 1.5 | -      | 106.0 | 131.0 | 144.0 | 146.0 | 147.0 |     |     | 65.0      |
| 3                 | 1503            | RL | 1.2 | -      | -     | 106.0 | 119.0 | 121.0 | 122.0 |     |     | 25.0      |
| 4                 | 1504            | LC | 5.0 | -      | -     | -     | 106.0 | 108.0 | 109.0 |     |     | 13.0      |
| 5                 | 1505            | LC | 4.2 | -      | -     | -     | -     | 106.0 | 107.0 |     |     | 2.0       |
| 6                 | 1506            | LC | 3.0 | -      | -     | -     | -     | -     | 105.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.20  | 1.80  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 1401                  | 1402                  | 1403                  | 1404                  | 1405                  |       |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | LC                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 5                     | 7                     | 12                    | 10                    |       |       |       |
| Power Setting      | IP  | 6.0                   | 8.0                   | 6.0                   | 2.5                   | 2.0                   | 2.0                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 3                     | 10                    | 6                     | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 2                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 8                     | 7                     | 12                    | 10                    | 8                     | 8                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 54.0<br>(51.0 ~ 57.0) | 85.0<br>(83.0 ~ 87.0) | 70.0<br>(68.0 ~ 72.0) | 80.0<br>(78.0 ~ 82.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 12                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 3.0                   | 6.0                   | 8.0                   | 8.0                   | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 125.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 165.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 178.0 | 118.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 182.0 | 122.0 | 109.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 183.0 | 123.0 | 110.0 | 106.0 | 104.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 13.0  | 4.0   | 2.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 4.7 ~ 5.7   | 8.7 ~ 10.7  | 7.3 ~ 8.1   | 7.3 ~ 8.1   | 6.3 ~ 7.0   |  |  |
| Average Voltage Gap  | V   |  | 51 ~ 57     | 84 ~ 86     | 76 ~ 80     | 97 ~ 100    | 82 ~ 86     |  |  |
| Avg. Linear Feedrate | ALF |  | 312.0       | 203.1       | 141.1       | 108.1       | 85.0        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 10mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                  | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|------------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 1411                  | 1412                   | 1413                  | 1414                  | 1415                  |       |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                     | LC                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                     | SL                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 6                      | 7                     | 12                    | 8                     |       |       |       |
| Power Setting      | IP  | 6.0                   | 9.0                   | 7.0                    | 2.5                   | 2.0                   | 2.0                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                     |                       |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 3                      | 10                    | 6                     | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 4                      | 2                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 8                     | 7                     | 12                     | 10                    | 8                     | 8                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                      | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                      | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(57.0 ~ 63.0) | 98.0<br>(96.0 ~ 100.0) | 85.0<br>(83.0 ~ 87.0) | 69.0<br>(67.0 ~ 71.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                    | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                     | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 12                    | 12                     | 10                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                     | 10                    | 10                    | 10                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                     | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                     | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                      | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                     | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                      | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 2.5                   | 5.0                    | 7.0                   | 7.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                    | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                    | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 165.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 173.0 | 113.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 182.0 | 122.0 | 114.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 184.0 | 124.0 | 116.0 | 107.0 | 104.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 8.0   | 9.0   | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 3.8 ~ 4.7   | 3.8 ~ 4.6   | 6.3 ~ 7.0   | 6.3 ~ 7.0   | 5.3 ~ 5.9   |  |  |
| Average Voltage Gap  | V   |  | 63 ~ 65     | 97 ~ 100    | 93 ~ 94     | 94 ~ 95     | 68 ~ 69     |  |  |
| Avg. Linear Feedrate | ALF |  | 255.0       | 126.7       | 96.2        | 77.5        | 63.0        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 1421                  | 1422                  | 1423                  | 1424                  | 1425                  |       |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | LC                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 6                     | 8                     | 12                    | 8                     |       |       |       |
| Power Setting      | IP  | 6.0                   | 10.0                  | 8.0                   | 2.5                   | 2.0                   | 2.0                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 3                     | 10                    | 6                     | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 5                     | 2                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 12                    | 10                    | 8                     | 8                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 90.0<br>(88.0 ~ 92.0) | 90.0<br>(88.0 ~ 92.0) | 70.0<br>(68.0 ~ 72.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 1.5                   | 3.5                   | 7.0                   | 6.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 165.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 171.0 | 111.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 180.0 | 120.0 | 114.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 182.0 | 122.0 | 116.0 | 107.0 | 104.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 6.0   | 9.0   | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 2.1 ~ 2.5   | 4.3 ~ 5.3   | 6.5 ~ 7.2   | 5.5 ~ 6.0   | 5.4 ~ 6.0   |  |  |
| Average Voltage Gap  | V   |  | 31 ~ 41     | 88 ~ 91     | 93 ~ 95     | 77 ~ 78     | 53 ~ 54     |  |  |
| Avg. Linear Feedrate | ALF |  | 138.0       | 93.3        | 76.0        | 62.3        | 52.7        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 30mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 942                   | 1431                  | 1432                  | 1433                  | 1434                  | 1435                  | 1436                  |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 6                     | 4                     | 8                     | 12                    | 8                     |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 3                     | 10                    | 10                    | 6                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 5                     | 4                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 37.0<br>(34.0 ~ 40.0) | 85.0<br>(83.0 ~ 87.0) | 45.0<br>(43.0 ~ 47.0) | 58.0<br>(56.0 ~ 60.0) | 40.0<br>(38.0 ~ 42.0) | 32.0<br>(30.0 ~ 34.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 12                    | 12                    | 10                    | 11                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 11                    | 11                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.2                   | 2.0                   | 2.5                   | 6.0                   | 6.0                   | 6.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 163.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 183.0 | 126.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 195.0 | 138.0 | 118.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 200.0 | 143.0 | 123.0 | 111.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 201.0 | 144.0 | 124.0 | 112.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 57.0  | 20.0  | 12.0  | 5.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.6 ~ 2.0   | 4.3 ~ 5.3   | 3.2 ~ 3.9   | 5.4 ~ 6.0   | 5.5 ~ 6.1   | 5.3 ~ 5.9   |  |
| Average Voltage Gap  | V   |  | 30 ~ 37     | 84 ~ 86     | 38 ~ 42     | 64 ~ 66     | 60 ~ 61     | 32 ~ 35     |  |
| Avg. Linear Feedrate | ALF |  | 108.0       | 78.5        | 57.4        | 49.1        | 43.1        | 38.2        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.98 ~ 3.30 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 40mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 942                   | 1441                  | 1442                  | 1443                  | 1444                  | 1445                  | 1446                  |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 6                     | 4                     | 8                     | 12                    | 8                     |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 3                     | 10                    | 10                    | 6                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 5                     | 4                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 33.0<br>(30.0 ~ 36.0) | 80.0<br>(78.0 ~ 82.0) | 45.0<br>(43.0 ~ 47.0) | 58.0<br>(56.0 ~ 60.0) | 40.0<br>(38.0 ~ 42.0) | 32.0<br>(30.0 ~ 34.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 12                    | 12                    | 10                    | 11                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 11                    | 11                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.0                   | 2.5                   | 2.5                   | 6.0                   | 6.0                   | 6.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 161.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 181.0 | 126.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 193.0 | 138.0 | 118.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 198.0 | 143.0 | 123.0 | 111.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 199.0 | 144.0 | 124.0 | 112.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 55.0  | 20.0  | 12.0  | 5.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.1 ~ 1.4   | 4.3 ~ 5.3   | 3.2 ~ 3.9   | 5.4 ~ 6.0   | 5.5 ~ 6.1   | 5.3 ~ 5.9   |  |
| Average Voltage Gap  | V   |  | 30 ~ 35     | 79 ~ 81     | 38 ~ 42     | 64 ~ 66     | 60 ~ 61     | 32 ~ 35     |  |
| Avg. Linear Feedrate | ALF |  | 75.0        | 59.5        | 46.5        | 40.9        | 36.6        | 33.0        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.98 ~ 3.30 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 50mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 943                   | 1451                  | 1452                  | 1453                  | 1454                  | 1455                  | 1456                  |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 7                     | 4                     | 9                     | 14                    | 10                    |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 3                     | 10                    | 10                    | 5                     | 3                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 5                     | 4                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 34.0<br>(31.0 ~ 37.0) | 76.0<br>(74.0 ~ 78.0) | 45.0<br>(43.0 ~ 47.0) | 56.0<br>(54.0 ~ 58.0) | 45.0<br>(43.0 ~ 47.0) | 31.0<br>(29.0 ~ 33.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 12                    | 12                    | 10                    | 11                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 11                    | 11                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.0                   | 2.7                   | 2.2                   | 6.0                   | 6.0                   | 6.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 136.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 166.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 186.0 | 126.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 199.0 | 139.0 | 119.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 202.0 | 142.0 | 122.0 | 109.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 203.0 | 143.0 | 123.0 | 110.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 20.0  | 13.0  | 3.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.9 ~ 1.2   | 4.0 ~ 4.9   | 2.4 ~ 2.9   | 5.4 ~ 6.0   | 5.5 ~ 6.1   | 5.3 ~ 5.9   |  |
| Average Voltage Gap  | V   |  | 32 ~ 38     | 75 ~ 77     | 37 ~ 41     | 63 ~ 65     | 59 ~ 60     | 34 ~ 36     |  |
| Avg. Linear Feedrate | ALF |  | 63.0        | 51.0        | 38.6        | 34.7        | 31.5        | 28.8        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.98 ~ 3.30 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 60mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 943                   | 1461                  | 1462                  | 1463                  | 1464                  | 1465                  | 1466                  |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 7                     | 4                     | 10                    | 14                    | 12                    |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 3                     | 10                    | 10                    | 4                     | 3                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 5                     | 4                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(32.0 ~ 38.0) | 73.0<br>(71.0 ~ 75.0) | 45.0<br>(43.0 ~ 47.0) | 55.0<br>(53.0 ~ 57.0) | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(28.0 ~ 32.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 12                    | 12                    | 10                    | 11                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 11                    | 11                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.0                   | 3.0                   | 2.0                   | 6.0                   | 6.0                   | 6.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 137.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 173.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 193.0 | 128.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 207.0 | 142.0 | 122.0 | 108.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 209.0 | 144.0 | 124.0 | 110.0 | 108.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 210.0 | 145.0 | 125.0 | 111.0 | 109.0 | 107.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 20.0  | 14.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.0   | 3.7 ~ 4.5   | 1.6 ~ 2.0   | 5.4 ~ 6.0   | 5.0 ~ 5.6   | 5.4 ~ 6.0   |  |
| Average Voltage Gap  | V   |  | 34 ~ 41     | 72 ~ 74     | 37 ~ 41     | 61 ~ 63     | 58 ~ 59     | 37 ~ 38     |  |
| Avg. Linear Feedrate | ALF |  | 54.0        | 44.3        | 31.4        | 28.8        | 26.4        | 24.5        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.98 ~ 3.30 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 70mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 944                   | 1471                  | 1472                  | 1473                  | 1474                  | 1475                  | 1476                  |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 7                     | 4                     | 10                    | 14                    | 13                    |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 3                     | 10                    | 10                    | 4                     | 3                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 5                     | 4                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(32.0 ~ 38.0) | 73.0<br>(71.0 ~ 75.0) | 42.0<br>(40.0 ~ 44.0) | 51.0<br>(49.0 ~ 53.0) | 45.0<br>(43.0 ~ 47.0) | 30.0<br>(28.0 ~ 32.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 12                    | 12                    | 10                    | 11                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 11                    | 11                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.7                   | 3.0                   | 1.7                   | 5.5                   | 5.0                   | 5.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 140.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 172.0 | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 196.0 | 131.0 | 107.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 209.0 | 144.0 | 120.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 212.0 | 147.0 | 123.0 | 110.0 | 107.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 213.0 | 148.0 | 124.0 | 111.0 | 108.0 | 106.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 24.0  | 13.0  | 3.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.6 ~ 0.8   | 3.1 ~ 3.7   | 1.4 ~ 1.7   | 5.4 ~ 5.7   | 4.5 ~ 5.0   | 4.5 ~ 5.2   |  |
| Average Voltage Gap  | V   |  | 34 ~ 38     | 74 ~ 77     | 35 ~ 37     | 56 ~ 58     | 51 ~ 53     | 34 ~ 36     |  |
| Avg. Linear Feedrate | ALF |  | 42.0        | 34.8        | 25.3        | 23.5        | 21.8        | 20.2        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.98 ~ 3.30 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 80mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 944                   | 1481                  | 1482                  | 1483                  | 1484                  | 1485                  | 1486                  |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 7                     | 4                     | 10                    | 14                    | 14                    |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 3                     | 10                    | 10                    | 4                     | 3                     |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 5                     | 4                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(32.0 ~ 38.0) | 73.0<br>(71.0 ~ 75.0) | 40.0<br>(38.0 ~ 42.0) | 48.0<br>(46.0 ~ 50.0) | 45.0<br>(43.0 ~ 47.0) | 30.0<br>(28.0 ~ 32.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 12                    | 12                    | 10                    | 11                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 11                    | 11                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.5                   | 3.0                   | 1.4                   | 5.5                   | 4.5                   | 4.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 143.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 171.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 199.0 | 134.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 212.0 | 147.0 | 119.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 216.0 | 151.0 | 123.0 | 110.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 217.0 | 152.0 | 124.0 | 111.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 28.0  | 13.0  | 4.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.5 ~ 0.6   | 2.5 ~ 3.0   | 1.2 ~ 1.5   | 5.0 ~ 5.5   | 3.9 ~ 4.3   | 4.0 ~ 4.5   |  |
| Average Voltage Gap  | V   |  | 34 ~ 36     | 75 ~ 79     | 32 ~ 35     | 52 ~ 54     | 46 ~ 48     | 33 ~ 34     |  |
| Avg. Linear Feedrate | ALF |  | 33.0        | 27.5        | 20.5        | 19.3        | 17.9        | 16.7        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.98 ~ 3.30 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 90mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 945                   | 1491                  | 1492                  | 1493                  | 1494                  | 1495                  | 1496                  |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 8                     | 5                     | 11                    | 14                    | 12                    |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 3                     | 10                    | 10                    | 4                     | 3                     |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 5                     | 4                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 6                     | 4                     | 12                    | 11                    | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 37.0<br>(34.0 ~ 40.0) | 70.0<br>(68.0 ~ 72.0) | 38.0<br>(36.0 ~ 40.0) | 47.0<br>(45.0 ~ 49.0) | 42.0<br>(40.0 ~ 44.0) | 30.0<br>(28.0 ~ 32.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 12                    | 12                    | 10                    | 11                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 11                    | 11                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.4                   | 2.2                   | 1.3                   | 5.0                   | 4.3                   | 4.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 144.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 171.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 197.0 | 132.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 210.0 | 145.0 | 119.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 213.0 | 148.0 | 122.0 | 109.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 214.0 | 149.0 | 123.0 | 110.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 26.0  | 13.0  | 3.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.4 ~ 0.5   | 2.2 ~ 2.7   | 1.2 ~ 1.5   | 4.8 ~ 5.2   | 3.9 ~ 4.3   | 3.5 ~ 4.2   |  |
| Average Voltage Gap  | V   |  | 34 ~ 37     | 73 ~ 77     | 32 ~ 35     | 50 ~ 52     | 44 ~ 46     | 32 ~ 34     |  |
| Avg. Linear Feedrate | ALF |  | 27.0        | 22.8        | 17.8        | 16.8        | 15.7        | 14.7        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.98 ~ 3.30 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 100mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 945                   | 1501                  | 1502                  | 1503                  | 1504                  | 1505                  | 1506                  |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 9                     | 6                     | 12                    | 14                    | 12                    |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 3                     | 10                    | 10                    | 4                     | 3                     |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 5                     | 4                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 12                    | 11                    | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 68.0<br>(66.0 ~ 70.0) | 37.0<br>(35.0 ~ 39.0) | 47.0<br>(45.0 ~ 49.0) | 39.0<br>(37.0 ~ 41.0) | 30.0<br>(28.0 ~ 32.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 12                    | 12                    | 10                    | 11                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 11                    | 11                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.3                   | 1.5                   | 1.2                   | 5.0                   | 4.2                   | 3.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 146.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 171.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 196.0 | 131.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 209.0 | 144.0 | 119.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 211.0 | 146.0 | 121.0 | 108.0 | 106.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 212.0 | 147.0 | 122.0 | 109.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 25.0  | 13.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.3 ~ 0.4   | 2.0 ~ 2.4   | 1.3 ~ 1.5   | 4.7 ~ 5.1   | 3.9 ~ 4.3   | 2.9 ~ 3.2   |  |
| Average Voltage Gap  | V   |  | 35 ~ 37     | 72 ~ 75     | 31 ~ 34     | 49 ~ 50     | 40 ~ 42     | 34 ~ 35     |  |
| Avg. Linear Feedrate | ALF |  | 21.0        | 18.1        | 14.9        | 14.2        | 13.4        | 12.5        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.98 ~ 3.30 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | WC-Co         | MSPP  |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 14211           | RL | 1.7 | 122.0  | 195.0 | 211.0 | 216.0 |     |     |     |     | 0.0       |
| 2                 | 14212           | RL | 3.0 | -      | 105.0 | 121.0 | 126.0 |     |     |     |     | 90.0      |
| 3                 | 14213           | LC | 7.0 | -      | -     | 104.0 | 109.0 |     |     |     |     | 17.0      |
| 4                 | 14214           | LC | 7.0 | -      | -     | -     | 103.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 4.5   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.70  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 14221           | RL | 1.5 | 128.0  | 196.0 | 212.0 | 216.0 |     |     |     |     | 0.0       |
| 2                 | 14222           | RL | 2.5 | -      | 106.0 | 122.0 | 126.0 |     |     |     |     | 90.0      |
| 3                 | 14223           | LC | 7.0 | -      | -     | 105.0 | 109.0 |     |     |     |     | 17.0      |
| 4                 | 14224           | LC | 7.0 | -      | -     | -     | 103.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 4.5   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.70  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 14231           | RL | 1.2 | 135.0  | 195.0 | 207.0 | 210.0 |     |     |     |     | 0.0       |
| 2                 | 14232           | RL | 2.2 | -      | 110.0 | 122.0 | 125.0 |     |     |     |     | 85.0      |
| 3                 | 14233           | LC | 6.5 | -      | -     | 106.0 | 109.0 |     |     |     |     | 16.0      |
| 4                 | 14234           | LC | 6.5 | -      | -     | -     | 103.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 4.5   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.70  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | WC-Co         | MSPP  |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 14241           | RL | 1.0 | 136.0  | 197.0 | 207.0 | 210.0 |     |     |     |     | 0.0       |
| 2                 | 14242           | RL | 2.0 | -      | 112.0 | 122.0 | 125.0 |     |     |     |     | 85.0      |
| 3                 | 14243           | LC | 6.5 | -      | -     | 106.0 | 109.0 |     |     |     |     | 16.0      |
| 4                 | 14244           | LC | 6.5 | -      | -     | -     | 103.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 4.5   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.70  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 14251           | RL | 0.8 | 135.0  | 189.0 | 201.0 | 205.0 |     |     |     |     | 0.0       |
| 2                 | 14252           | RL | 1.5 | -      | 109.0 | 121.0 | 125.0 |     |     |     |     | 80.0      |
| 3                 | 14253           | LC | 6.5 | -      | -     | 105.0 | 109.0 |     |     |     |     | 16.0      |
| 4                 | 14254           | LC | 6.5 | -      | -     | -     | 103.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 4.5   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.70  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 14261           | RL | 0.7 | 135.0  | 188.0 | 201.0 | 205.0 |     |     |     |     | 0.0       |
| 2                 | 14262           | RL | 1.0 | -      | 108.0 | 121.0 | 125.0 |     |     |     |     | 80.0      |
| 3                 | 14263           | LC | 6.0 | -      | -     | 105.0 | 109.0 |     |     |     |     | 16.0      |
| 4                 | 14264           | LC | 6.0 | -      | -     | -     | 103.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 4.5   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.70  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 10mm               | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                   | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-------------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 14211                 | 14212                 | 14213                    | 14214                   |       |       |       |       |
| Power Supply       | PS  | RH                    | RL                    | RL                    | LC                       | LC                      |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                      |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 10                    | 10                       | 12                      |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 10.0                  | 6.0                   | 3.0                      | 2.5                     |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                          |                         |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 9                     | 10                       | 6                       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                        | 1                       |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 9                     | 8                        | 4                       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                        | 1                       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                       |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 45.0<br>(42.0 ~ 48.0) | 55.0<br>(53.0 ~ 57.0) | 115.0<br>(113.0 ~ 117.0) | 100.0<br>(98.0 ~ 102.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                      | ON                      |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                      | OFF                     |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                       | 12                      |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                      |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                      |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                      |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                      |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                       | 10                      |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 1.7                   | 3.0                   | 7.0                      | 7.0                     |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                     |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                     |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 122.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 195.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 211.0 | 121.0 | 104.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 216.0 | 126.0 | 109.0 | 103.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 17.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.8 ~ 4.4   | 6.4 ~ 7.0   | 7.0 ~ 7.2   | 7.0 ~ 7.2   |  |  |  |
| Average Voltage Gap  | V   |  | 44 ~ 52     | 52 ~ 62     | 130 ~ 136   | 116 ~ 122   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 246.0       | 152.6       | 112.4       | 88.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 4.0 ~ 5.0   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 20mm               | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                   | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 14221                 | 14222                 | 14223                   | 14224                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RL                    | RL                    | LC                      | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                      | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 10                    | 10                      | 12                    |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 10.0                  | 6.0                   | 3.0                     | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                    |                         |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                      | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                       | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 8                     | 8                       | 4                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                       | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                       | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 45.0<br>(42.0 ~ 48.0) | 60.0<br>(58.0 ~ 62.0) | 100.0<br>(98.0 ~ 102.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                     | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                     | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                      | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                      | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                      | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                      | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                       | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                      | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                      | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 1.5                   | 2.5                   | 7.0                     | 7.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 128.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 196.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 212.0 | 122.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 216.0 | 126.0 | 109.0 | 103.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 17.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.1 ~ 2.8   | 2.7 ~ 3.1   | 7.0 ~ 7.2   | 7.0 ~ 7.2   |  |  |  |
| Average Voltage Gap  | V   |  | 38 ~ 52     | 57 ~ 67     | 105 ~ 117   | 74 ~ 81     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 147.0       | 79.7        | 67.1        | 58.0        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 4.0 ~ 5.0   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 30mm               | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 14231                 | 14232                 | 14233                 | 14234                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RL                    | RL                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 10                    | 10                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 6.0                   | 3.0                   | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                    | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 8                     | 8                     | 4                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(47.0 ~ 53.0) | 60.0<br>(58.0 ~ 62.0) | 95.0<br>(93.0 ~ 97.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 25                    | 25                    | 25                    | 25                    |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.2                   | 2.2                   | 6.5                   | 6.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 195.0 | 110.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 207.0 | 122.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 210.0 | 125.0 | 109.0 | 103.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 16.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.1 ~ 1.5   | 1.2 ~ 2.3   | 6.5 ~ 6.7   | 6.5 ~ 6.7   |  |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 52     | 57 ~ 67     | 105 ~ 116   | 72 ~ 80     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 78.0        | 44.8        | 40.2        | 36.5        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 4.0 ~ 5.0   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 40mm               | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 14241                 | 14242                 | 14243                 | 14244                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RL                    | RL                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 12                    | 10                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 6.0                   | 3.0                   | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                    | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 8                     | 8                     | 4                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(47.0 ~ 53.0) | 60.0<br>(58.0 ~ 62.0) | 85.0<br>(83.0 ~ 87.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 25                    | 25                    | 25                    | 25                    |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.0                   | 2.0                   | 6.5                   | 6.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 136.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 197.0 | 112.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 207.0 | 122.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 210.0 | 125.0 | 109.0 | 103.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 16.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 0.9 ~ 1.4   | 0.8 ~ 1.8   | 6.5 ~ 6.7   | 6.5 ~ 6.7   |  |  |  |
| Average Voltage Gap  | V   |  | 30 ~ 39     | 57 ~ 67     | 105 ~ 108   | 60 ~ 62     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 69.0        | 36.6        | 33.5        | 30.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 4.0 ~ 5.0   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 50mm               | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 943                   | 14251                 | 14252                 | 14253                 | 14254                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RL                    | RL                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 12                    | 10                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 6.0                   | 3.0                   | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                    | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 6                     | 8                     | 8                     | 4                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(32.0 ~ 38.0) | 57.0<br>(55.0 ~ 59.0) | 80.0<br>(78.0 ~ 82.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 30                    | 30                    | 30                    | 30                    |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 0.8                   | 1.5                   | 6.5                   | 6.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 189.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 201.0 | 121.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 205.0 | 125.0 | 109.0 | 103.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 80.0  | 16.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 0.6 ~ 1.2   | 1.0 ~ 2.0   | 6.5 ~ 6.7   | 6.5 ~ 6.7   |  |  |  |
| Average Voltage Gap  | V   |  | 30 ~ 39     | 54 ~ 64     | 91 ~ 96     | 52 ~ 56     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 54.0        | 33.8        | 31.1        | 28.8        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 4.0 ~ 5.0   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 60mm               | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 943                   | 14261                 | 14262                 | 14263                 | 14264                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RL                    | RL                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 12                    | 10                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 6.0                   | 3.0                   | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                    | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 6                     | 8                     | 8                     | 4                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(32.0 ~ 38.0) | 57.0<br>(55.0 ~ 59.0) | 75.0<br>(73.0 ~ 77.0) | 35.0<br>(33.0 ~ 37.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 30                    | 30                    | 30                    | 30                    |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 0.7                   | 1.0                   | 6.0                   | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 188.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 201.0 | 121.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 205.0 | 125.0 | 109.0 | 103.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 80.0  | 16.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 0.4 ~ 1.0   | 0.8 ~ 1.8   | 6.0 ~ 6.2   | 6.0 ~ 6.2   |  |  |  |
| Average Voltage Gap  | V   |  | 30 ~ 38     | 54 ~ 64     | 85 ~ 89     | 57 ~ 59     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 42.0        | 27.3        | 25.4        | 23.8        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 4.0 ~ 5.0   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | WC-Co         | MSPD  |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 14611           | RL | 1.7 | 126.0  | 198.0 | 214.0 | 219.0 |     |     |     |     | 0.0       |
| 2                 | 14612           | RL | 3.0 | -      | 108.0 | 124.0 | 129.0 |     |     |     |     | 90.0      |
| 3                 | 14613           | LC | 7.0 | -      | -     | 107.0 | 112.0 |     |     |     |     | 17.0      |
| 4                 | 14614           | LC | 7.0 | -      | -     | -     | 106.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 4.5   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.70  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 14621           | RL | 1.5 | 133.0  | 198.0 | 214.0 | 219.0 |     |     |     |     | 0.0       |
| 2                 | 14622           | RL | 2.5 | -      | 108.0 | 124.0 | 129.0 |     |     |     |     | 90.0      |
| 3                 | 14623           | LC | 7.0 | -      | -     | 107.0 | 112.0 |     |     |     |     | 17.0      |
| 4                 | 14624           | LC | 7.0 | -      | -     | -     | 106.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 4.5   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.70  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 14631           | RL | 1.2 | 136.0  | 193.0 | 208.0 | 213.0 |     |     |     |     | 0.0       |
| 2                 | 14632           | RL | 2.2 | -      | 108.0 | 123.0 | 128.0 |     |     |     |     | 85.0      |
| 3                 | 14633           | LC | 6.5 | -      | -     | 107.0 | 112.0 |     |     |     |     | 16.0      |
| 4                 | 14634           | LC | 6.5 | -      | -     | -     | 106.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 4.5   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.70  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 10mm               | MSPD    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                   | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-------------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 14611                 | 14612                 | 14613                    | 14614                   |       |       |       |       |
| Power Supply       | PS  | RH                    | RL                    | RL                    | LC                       | LC                      |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                      |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 10                    | 10                       | 12                      |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 10.0                  | 6.0                   | 3.0                      | 2.5                     |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                          |                         |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 9                     | 10                       | 6                       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                        | 1                       |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 9                     | 8                        | 4                       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                        | 1                       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                       |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 45.0<br>(42.0 ~ 48.0) | 65.0<br>(63.0 ~ 67.0) | 115.0<br>(113.0 ~ 117.0) | 100.0<br>(98.0 ~ 102.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                      | ON                      |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                     |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                       | 12                      |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                      |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                      |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                      |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                      |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 15                    | 15                    | 15                       | 15                      |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 1.7                   | 3.0                   | 7.0                      | 7.0                     |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                     |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                     |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 126.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 198.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 214.0 | 124.0 | 107.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 219.0 | 129.0 | 112.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 17.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.8 ~ 4.4   | 6.3 ~ 7.3   | 7.0 ~ 7.2   | 7.0 ~ 7.2   |  |  |  |
| Average Voltage Gap  | V   |  | 48 ~ 51     | 62 ~ 80     | 132 ~ 138   | 120 ~ 124   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 246.0       | 153.5       | 112.8       | 89.2        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 4.0 ~ 5.0   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 20mm               | MSPD    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                   | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 14621                 | 14622                 | 14623                   | 14624                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RL                    | RL                    | LC                      | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                      | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 10                    | 10                      | 12                    |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 10.0                  | 6.0                   | 3.0                     | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                    |                         |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                      | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                       | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 8                     | 8                       | 4                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                       | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                       | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 45.0<br>(42.0 ~ 48.0) | 65.0<br>(63.0 ~ 67.0) | 100.0<br>(98.0 ~ 102.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                     | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                     | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                      | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                      | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                      | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                      | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                       | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                      | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                      | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 1.5                   | 2.5                   | 7.0                     | 7.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 198.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 214.0 | 124.0 | 107.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 219.0 | 129.0 | 112.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 17.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.1 ~ 2.8   | 2.2 ~ 3.0   | 7.0 ~ 7.2   | 7.0 ~ 7.2   |  |  |  |
| Average Voltage Gap  | V   |  | 45 ~ 52     | 62 ~ 75     | 114 ~ 120   | 76 ~ 82     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 147.0       | 75.7        | 64.3        | 55.8        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 4.0 ~ 5.0   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 30mm               | MSPD    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 14631                 | 14632                 | 14633                 | 14634                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RL                    | RL                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 10                    | 10                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 6.0                   | 3.0                   | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                    | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 8                     | 8                     | 4                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(47.0 ~ 53.0) | 70.0<br>(68.0 ~ 72.0) | 95.0<br>(93.0 ~ 97.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 25                    | 25                    | 25                    | 25                    |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.2                   | 2.2                   | 6.5                   | 6.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 136.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 193.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 208.0 | 123.0 | 107.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 213.0 | 128.0 | 112.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 16.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.8 ~ 2.1   | 1.3 ~ 2.6   | 6.5 ~ 6.7   | 6.5 ~ 6.7   |  |  |  |
| Average Voltage Gap  | V   |  | 40 ~ 52     | 60 ~ 80     | 113 ~ 118   | 82 ~ 86     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 117.0       | 58.5        | 51.0        | 45.2        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 4.0 ~ 5.0   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | Cu            | STD   |

Thickness 5 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 1601            | KH | 5.0 | 144.0  | 199.0 | 205.0 | 210.0 |     |     |     |     | 0.0       |
| 2                 | 1602            | KH | 7.0 | -      | 114.0 | 120.0 | 125.0 |     |     |     |     | 85.0      |
| 3                 | 1603            | LC | 9.0 | -      | -     | 107.0 | 112.0 |     |     |     |     | 13.0      |
| 4                 | 1604            | LC | 9.0 | -      | -     | -     | 107.0 |     |     |     |     | 5.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 1611            | KH | 4.0 | 142.0  | 194.0 | 201.0 | 205.0 |     |     |     |     | 0.0       |
| 2                 | 1612            | KH | 5.0 | -      | 114.0 | 121.0 | 125.0 |     |     |     |     | 80.0      |
| 3                 | 1613            | LC | 9.0 | -      | -     | 108.0 | 112.0 |     |     |     |     | 13.0      |
| 4                 | 1614            | LC | 9.0 | -      | -     | -     | 107.0 |     |     |     |     | 5.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 1621            | KH | 2.4 | 144.0  | 189.0 | 199.0 | 203.0 |     |     |     |     | 0.0       |
| 2                 | 1622            | KH | 3.2 | -      | 112.0 | 122.0 | 126.0 |     |     |     |     | 77.0      |
| 3                 | 1623            | LC | 9.0 | -      | -     | 109.0 | 113.0 |     |     |     |     | 13.0      |
| 4                 | 1624            | LC | 9.0 | -      | -     | -     | 108.0 |     |     |     |     | 5.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | Cu            | STD   |

Thickness 30 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 1631            | KH | 2.0 | 144.0  | 190.0 | 201.0 | 205.0 |     |     |     |     | 0.0       |
| 2                 | 1632            | KH | 2.8 | -      | 114.0 | 125.0 | 129.0 |     |     |     |     | 76.0      |
| 3                 | 1633            | LC | 7.0 | -      | -     | 110.0 | 114.0 |     |     |     |     | 15.0      |
| 4                 | 1634            | LC | 7.0 | -      | -     | -     | 108.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 1641            | KH | 1.6 | 145.0  | 192.0 | 204.0 | 208.0 |     |     |     |     | 0.0       |
| 2                 | 1642            | KH | 2.5 | -      | 117.0 | 129.0 | 133.0 |     |     |     |     | 75.0      |
| 3                 | 1643            | LC | 6.0 | -      | -     | 112.0 | 116.0 |     |     |     |     | 17.0      |
| 4                 | 1644            | LC | 6.0 | -      | -     | -     | 109.0 |     |     |     |     | 7.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No,               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 1651            | KH | 1.1 | 145.0  | 191.0 | 202.0 | 207.0 |     |     |     |     | 0.0       |
| 2                 | 1652            | KH | 2.5 | -      | 116.0 | 127.0 | 132.0 |     |     |     |     | 75.0      |
| 3                 | 1653            | LC | 6.0 | -      | -     | 111.0 | 116.0 |     |     |     |     | 16.0      |
| 4                 | 1654            | LC | 6.0 | -      | -     | -     | 109.0 |     |     |     |     | 7.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | Cu            | STD   |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 1661            | KH | 0.6 | 145.0  | 191.0 | 201.0 | 207.0 |     |     |     |     | 0.0       |
| 2                 | 1662            | KH | 2.5 | -      | 116.0 | 126.0 | 132.0 |     |     |     |     | 75.0      |
| 3                 | 1663            | LC | 5.0 | -      | -     | 111.0 | 117.0 |     |     |     |     | 15.0      |
| 4                 | 1664            | LC | 6.0 | -      | -     | -     | 110.0 |     |     |     |     | 7.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 1671            | KH | 0.5 | 150.0  | 196.0 | 205.0 | 210.0 |     |     |     |     | 0.0       |
| 2                 | 1672            | KH | 2.5 | -      | 116.0 | 125.0 | 130.0 |     |     |     |     | 80.0      |
| 3                 | 1673            | LC | 5.0 | -      | -     | 111.0 | 116.0 |     |     |     |     | 14.0      |
| 4                 | 1674            | LC | 5.0 | -      | -     | -     | 110.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 1681            | KH | 0.5 | 157.0  | 202.0 | 210.0 | 213.0 |     |     |     |     | 0.0       |
| 2                 | 1682            | KH | 2.3 | -      | 117.0 | 125.0 | 128.0 |     |     |     |     | 85.0      |
| 3                 | 1683            | LC | 5.0 | -      | -     | 112.0 | 115.0 |     |     |     |     | 13.0      |
| 4                 | 1684            | LC | 5.0 | -      | -     | -     | 110.0 |     |     |     |     | 5.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | Cu            | STD   |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 1691            | KH | 0.4 | 160.0  | 207.0 | 215.0 | 218.0 |     |     |     |     | 0.0       |
| 2                 | 1692            | KH | 2.1 | -      | 117.0 | 125.0 | 128.0 |     |     |     |     | 90.0      |
| 3                 | 1693            | LC | 5.0 | -      | -     | 110.0 | 113.0 |     |     |     |     | 15.0      |
| 4                 | 1694            | LC | 4.0 | -      | -     | -     | 110.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 1701            | KH | 0.4 | 163.0  | 212.0 | 220.0 | 224.0 |     |     |     |     | 0.0       |
| 2                 | 1702            | KH | 2.0 | -      | 117.0 | 125.0 | 129.0 |     |     |     |     | 95.0      |
| 3                 | 1703            | LC | 5.0 | -      | -     | 108.0 | 112.0 |     |     |     |     | 17.0      |
| 4                 | 1704            | LC | 4.0 | -      | -     | -     | 110.0 |     |     |     |     | 2.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Cu            | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                   | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-------------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 1601                  | 1602                  | 1603                     | 1604                    |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                    | LC                       | LC                      |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                      |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 7                     | 10                       | 12                      |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 9.0                   | 4.0                   | 2.5                      | 1.5                     |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                          |                         |       |       |       |       |
| Off Time           | OFF | 6                     | 2                     | 1                     | 10                       | 6                       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                        | 1                       |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 3                     | 10                       | 6                       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                        | 1                       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                       |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 85.0<br>(82.0 ~ 88.0) | 85.0<br>(83.0 ~ 87.0) | 110.0<br>(108.0 ~ 112.0) | 100.0<br>(98.0 ~ 102.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                      | OFF                     |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                     |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                       | 12                      |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                      |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                      |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                      |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                      |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                       |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 5.0                   | 7.0                   | 9.0                      | 9.0                     |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                     |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                     |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 144.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 199.0 | 114.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 205.0 | 120.0 | 107.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 210.0 | 125.0 | 112.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 13.0  | 5.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 8.7 ~ 10.7  | 14.5 ~ 17.7 | 8.6 ~ 9.6   | 8.6 ~ 9.6   |  |  |  |
| Average Voltage Gap  | V   |  | 82 ~ 90     | 94 ~ 107    | 110 ~ 123   | 99 ~ 112    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 582.0       | 363.2       | 218.1       | 155.9       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Cu            | 10mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 1611                  | 1612                  | 1613                     | 1614                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                    | LC                       | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 7                     | 12                       | 14                    |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 9.0                   | 4.0                   | 2.5                      | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 2                     | 1                     | 10                       | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 3                     | 10                       | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 85.0<br>(82.0 ~ 88.0) | 95.0<br>(93.0 ~ 97.0) | 115.0<br>(113.0 ~ 117.0) | 90.0<br>(88.0 ~ 92.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                      | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                       | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 4.0                   | 5.0                   | 9.0                      | 9.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 142.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 194.0 | 114.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 201.0 | 121.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 205.0 | 125.0 | 112.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 80.0  | 13.0  | 5.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 4.1 ~ 4.9   | 9.3 ~ 11.3  | 8.6 ~ 9.6   | 8.7 ~ 9.7   |  |  |  |
| Average Voltage Gap  | V   |  | 82 ~ 90     | 92 ~ 104    | 114 ~ 126   | 102 ~ 114   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 270.0       | 187.9       | 139.8       | 111.5       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Cu            | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                   | Skim3                    | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-------------------------|--------------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 1621                  | 1622                  | 1623                    | 1624                     |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                    | LC                      | LC                       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                      | SL                       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 7                     | 12                      | 14                       |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 9.0                   | 5.0                   | 2.5                     | 2.0                      |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                         |                          |       |       |       |       |
| Off Time           | OFF | 6                     | 2                     | 1                     | 10                      | 6                        |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                       | 1                        |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 3                     | 10                      | 6                        |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                       | 1                        |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                       | 1                        |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 80.0<br>(77.0 ~ 83.0) | 80.0<br>(78.0 ~ 82.0) | 100.0<br>(98.0 ~ 102.0) | 110.0<br>(108.0 ~ 112.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                     | OFF                      |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                     | OFF                      |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                      | 12                       |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                      | 10                       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                      | 14                       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                      | NM                       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                       | 4                        |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                      | 10                       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                       | 0                        |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 2.4                   | 3.2                   | 9.0                     | 9.0                      |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                     | 1.0                      |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                     | 1.0                      |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 144.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 189.0 | 112.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 199.0 | 122.0 | 109.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 203.0 | 126.0 | 113.0 | 108.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 77.0  | 13.0  | 5.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.5 ~ 4.3   | 8.0 ~ 9.8   | 8.7 ~ 9.7   | 8.7 ~ 9.7   |  |  |  |
| Average Voltage Gap  | V   |  | 77 ~ 85     | 89 ~ 102    | 104 ~ 116   | 119 ~ 132   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 234.0       | 162.7       | 125.7       | 102.4       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Cu            | 30mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 1631                  | 1632                  | 1633                  | 1634                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 7                     | 12                    | 14                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 5.0                   | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 2                     | 1                     | 10                    | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 3                     | 10                    | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 78.0<br>(75.0 ~ 81.0) | 87.0<br>(85.0 ~ 89.0) | 90.0<br>(88.0 ~ 92.0) | 87.0<br>(85.0 ~ 89.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.0                   | 2.8                   | 7.0                   | 7.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 144.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 190.0 | 114.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 201.0 | 125.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 205.0 | 129.0 | 114.0 | 108.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 76.0  | 15.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.0 ~ 3.5   | 6.1 ~ 7.4   | 7.3 ~ 8.1   | 7.4 ~ 8.2   |  |  |  |
| Average Voltage Gap  | V   |  | 75 ~ 83     | 79 ~ 102    | 101 ~ 113   | 101 ~ 113   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 195.0       | 131.6       | 102.4       | 84.0        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Cu            | 40mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 1641                  | 1642                  | 1643                  | 1644                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 7                     | 12                    | 14                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 5.0                   | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 2                     | 1                     | 10                    | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 3                     | 10                    | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 75.0<br>(72.0 ~ 78.0) | 95.0<br>(93.0 ~ 97.0) | 80.0<br>(78.0 ~ 82.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.6                   | 2.5                   | 6.0                   | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 145.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 192.0 | 117.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 204.0 | 129.0 | 112.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 208.0 | 133.0 | 116.0 | 109.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 75.0  | 17.0  | 7.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.5 ~ 3.1   | 4.1 ~ 5.1   | 6.0 ~ 6.6   | 6.1 ~ 6.7   |  |  |  |
| Average Voltage Gap  | V   |  | 72 ~ 80     | 89 ~ 102    | 99 ~ 111    | 92 ~ 104    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 168.0       | 104.4       | 81.8        | 67.5        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Cu            | 50mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 943                   | 1651                  | 1652                  | 1653                  | 1654                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 7                     | 12                    | 14                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 5.0                   | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 2                     | 1                     | 10                    | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 3                     | 10                    | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 65.0<br>(62.0 ~ 68.0) | 92.0<br>(90.0 ~ 94.0) | 82.0<br>(80.0 ~ 84.0) | 72.0<br>(70.0 ~ 74.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.1                   | 2.5                   | 6.0                   | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 145.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 191.0 | 116.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 202.0 | 127.0 | 111.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 207.0 | 132.0 | 116.0 | 109.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 75.0  | 16.0  | 7.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.1 ~ 2.6   | 3.4 ~ 4.1   | 5.9 ~ 6.5   | 5.9 ~ 6.6   |  |  |  |
| Average Voltage Gap  | V   |  | 62 ~ 70     | 86 ~ 99     | 93 ~ 105    | 84 ~ 96     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 141.0       | 86.7        | 70.3        | 59.2        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Cu            | 60mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 943                   | 1661                  | 1662                  | 1663                  | 1664                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 7                     | 12                    | 14                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 5.0                   | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 2                     | 1                     | 10                    | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 3                     | 10                    | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 60.0<br>(57.0 ~ 63.0) | 90.0<br>(88.0 ~ 92.0) | 84.0<br>(82.0 ~ 86.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 0.6                   | 2.5                   | 5.0                   | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 145.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 191.0 | 116.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 201.0 | 126.0 | 111.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 207.0 | 132.0 | 117.0 | 110.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 75.0  | 15.0  | 7.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.7 ~ 2.1   | 2.7 ~ 3.3   | 5.8 ~ 6.4   | 5.8 ~ 6.4   |  |  |  |
| Average Voltage Gap  | V   |  | 57 ~ 65     | 84 ~ 96     | 87 ~ 99     | 75 ~ 86     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 114.0       | 69.8        | 58.6        | 50.5        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Cu            | 70mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 944                   | 1671                  | 1672                  | 1673                  | 1674                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 7                     | 12                    | 14                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 4.0                   | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 2                     | 1                     | 10                    | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 3                     | 10                    | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 58.0<br>(55.0 ~ 61.0) | 87.0<br>(85.0 ~ 89.0) | 72.0<br>(70.0 ~ 74.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.5                   | 2.5                   | 5.0                   | 5.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 150.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 196.0 | 116.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 205.0 | 125.0 | 111.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 210.0 | 130.0 | 116.0 | 110.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 80.0  | 14.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.6 ~ 2.0   | 2.6 ~ 3.3   | 5.3 ~ 5.9   | 5.3 ~ 5.9   |  |  |  |
| Average Voltage Gap  | V   |  | 55 ~ 63     | 81 ~ 94     | 76 ~ 88     | 63 ~ 75     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 108.0       | 67.1        | 55.9        | 47.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Cu            | 80mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 944                   | 1681                  | 1682                  | 1683                  | 1684                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 7                     | 12                    | 14                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 4.0                   | 2.5                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 2                     | 1                     | 10                    | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 3                     | 10                    | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 55.0<br>(52.0 ~ 58.0) | 85.0<br>(83.0 ~ 87.0) | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.5                   | 2.3                   | 5.0                   | 5.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 157.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 202.0 | 117.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 210.0 | 125.0 | 112.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 213.0 | 128.0 | 115.0 | 110.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 13.0  | 5.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.6 ~ 2.0   | 2.6 ~ 3.2   | 4.8 ~ 5.4   | 4.8 ~ 5.4   |  |  |  |
| Average Voltage Gap  | V   |  | 52 ~ 60     | 79 ~ 92     | 66 ~ 77     | 51 ~ 62     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 108.0       | 66.6        | 54.7        | 46.4        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Cu            | 90mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 945                   | 1691                  | 1692                  | 1693                  | 1694                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 7                     | 12                    | 14                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 4.0                   | 2.5                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 2                     | 1                     | 10                    | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 3                     | 10                    | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 62.0<br>(59.0 ~ 65.0) | 82.0<br>(80.0 ~ 84.0) | 54.0<br>(52.0 ~ 56.0) | 42.0<br>(40.0 ~ 44.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.4                   | 2.1                   | 5.0                   | 4.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 160.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 207.0 | 117.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 215.0 | 125.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 218.0 | 128.0 | 113.0 | 110.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 15.0  | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.4 ~ 1.7   | 2.4 ~ 3.1   | 4.7 ~ 5.3   | 4.3 ~ 4.8   |  |  |  |
| Average Voltage Gap  | V   |  | 59 ~ 67     | 76 ~ 89     | 58 ~ 71     | 45 ~ 56     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 93.0        | 59.5        | 49.6        | 42.0        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Cu            | 100mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 945                   | 1701                  | 1702                  | 1703                  | 1704                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 7                     | 12                    | 14                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 4.0                   | 2.5                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 2                     | 1                     | 10                    | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 3                     | 10                    | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 68.0<br>(65.0 ~ 71.0) | 80.0<br>(78.0 ~ 82.0) | 48.0<br>(46.0 ~ 50.0) | 35.0<br>(33.0 ~ 37.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.4                   | 2.0                   | 5.0                   | 4.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 163.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 212.0 | 117.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 220.0 | 125.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 224.0 | 129.0 | 112.0 | 110.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 95.0  | 17.0  | 2.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.2 ~ 1.4   | 2.3 ~ 2.9   | 4.7 ~ 5.1   | 3.9 ~ 4.3   |  |  |  |
| Average Voltage Gap  | V   |  | 65 ~ 73     | 74 ~ 87     | 47 ~ 59     | 39 ~ 50     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 78.0        | 52.0        | 44.2        | 37.5        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | Al            | STD   |

Thickness 5 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 1731            | KL | 12.0 | 127.0  | 191.0 | 208.0 | 214.0 |     |     |     |     | 0.0       |
| 2                 | 1732            | KL | 8.0  | -      | 116.0 | 133.0 | 139.0 |     |     |     |     | 75.0      |
| 3                 | 1733            | LC | 15.0 | -      | -     | 108.0 | 114.0 |     |     |     |     | 25.0      |
| 4                 | 1734            | LC | 14.0 | -      | -     | -     | 106.0 |     |     |     |     | 8.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 1741            | KL | 10.0 | 128.0  | 191.0 | 208.0 | 214.0 |     |     |     |     | 0.0       |
| 2                 | 1742            | KL | 8.0  | -      | 116.0 | 133.0 | 139.0 |     |     |     |     | 75.0      |
| 3                 | 1743            | LC | 15.0 | -      | -     | 108.0 | 114.0 |     |     |     |     | 25.0      |
| 4                 | 1744            | LC | 14.0 | -      | -     | -     | 106.0 |     |     |     |     | 8.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 1751            | KL | 8.0  | 134.0  | 191.0 | 207.0 | 213.0 |     |     |     |     | 0.0       |
| 2                 | 1752            | KL | 8.0  | -      | 116.0 | 132.0 | 138.0 |     |     |     |     | 75.0      |
| 3                 | 1753            | LC | 14.0 | -      | -     | 107.0 | 113.0 |     |     |     |     | 25.0      |
| 4                 | 1754            | LC | 13.0 | -      | -     | -     | 105.0 |     |     |     |     | 8.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | Al            | STD   |

Thickness 30 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 1761            | KL | 7.0  | 139.0  | 192.0 | 207.0 | 212.0 |     |     |     |     | 0.0       |
| 2                 | 1762            | KL | 7.0  | -      | 117.0 | 132.0 | 137.0 |     |     |     |     | 75.0      |
| 3                 | 1763            | LC | 12.0 | -      | -     | 107.0 | 112.0 |     |     |     |     | 25.0      |
| 4                 | 1764            | LC | 11.0 | -      | -     | -     | 105.0 |     |     |     |     | 7.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 1771            | KL | 6.0  | 143.0  | 192.0 | 206.0 | 211.0 |     |     |     |     | 0.0       |
| 2                 | 1772            | KL | 6.0  | -      | 117.0 | 131.0 | 136.0 |     |     |     |     | 75.0      |
| 3                 | 1773            | LC | 10.0 | -      | -     | 106.0 | 111.0 |     |     |     |     | 25.0      |
| 4                 | 1774            | LC | 9.0  | -      | -     | -     | 105.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 1781            | KL | 5.0 | 144.0  | 191.0 | 206.0 | 211.0 |     |     |     |     | 0.0       |
| 2                 | 1782            | KL | 5.5 | -      | 116.0 | 131.0 | 136.0 |     |     |     |     | 75.0      |
| 3                 | 1783            | LC | 9.5 | -      | -     | 106.0 | 111.0 |     |     |     |     | 25.0      |
| 4                 | 1784            | LC | 8.7 | -      | -     | -     | 105.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | Al            | STD   |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 1791            | KL | 4.0 | 144.0  | 190.0 | 206.0 | 211.0 |     |     |     |     | 0.0       |
| 2                 | 1792            | KL | 5.0 | -      | 115.0 | 131.0 | 136.0 |     |     |     |     | 75.0      |
| 3                 | 1793            | LC | 9.0 | -      | -     | 106.0 | 111.0 |     |     |     |     | 25.0      |
| 4                 | 1794            | LC | 8.5 | -      | -     | -     | 105.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 1801            | KL | 3.0 | 152.0  | 197.0 | 213.0 | 218.0 |     |     |     |     | 0.0       |
| 2                 | 1802            | KL | 5.5 | -      | 117.0 | 133.0 | 138.0 |     |     |     |     | 80.0      |
| 3                 | 1803            | LC | 8.5 | -      | -     | 108.0 | 113.0 |     |     |     |     | 25.0      |
| 4                 | 1804            | LC | 8.0 | -      | -     | -     | 107.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 1811            | KL | 2.0 | 159.0  | 203.0 | 220.0 | 224.0 |     |     |     |     | 0.0       |
| 2                 | 1812            | KH | 6.0 | -      | 118.0 | 135.0 | 139.0 |     |     |     |     | 85.0      |
| 3                 | 1813            | LC | 8.0 | -      | -     | 110.0 | 114.0 |     |     |     |     | 25.0      |
| 4                 | 1814            | LC | 7.5 | -      | -     | -     | 108.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | Al            | STD   |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 1821            | KH | 2.0 | 160.0  | 207.0 | 228.0 | 233.0 |     |     |     |     | 0.0       |
| 2                 | 1822            | KH | 5.5 | -      | 119.0 | 140.0 | 145.0 |     |     |     |     | 88.0      |
| 3                 | 1823            | LC | 7.2 | -      | -     | 110.0 | 115.0 |     |     |     |     | 30.0      |
| 4                 | 1824            | LC | 6.7 | -      | -     | -     | 108.0 |     |     |     |     | 7.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 1831            | KH | 2.0 | 160.0  | 210.0 | 234.0 | 239.0 |     |     |     |     | 0.0       |
| 2                 | 1832            | KH | 5.0 | -      | 120.0 | 144.0 | 149.0 |     |     |     |     | 90.0      |
| 3                 | 1833            | LC | 6.5 | -      | -     | 109.0 | 114.0 |     |     |     |     | 35.0      |
| 4                 | 1834            | LC | 6.0 | -      | -     | -     | 106.0 |     |     |     |     | 8.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Al            | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                   | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 1731                  | 1732                     | 1733                    | 1734                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                      | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                      | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                       | 6                     |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 5.0                      | 2.5                     | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 8                     | 9                        |                         |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                       | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 3                     | 2                        | 2                       | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 7                        | 9                       | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                       | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                       | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 70.0<br>(67.0 ~ 73.0) | 125.0<br>(123.0 ~ 127.0) | 100.0<br>(98.0 ~ 102.0) | 95.0<br>(93.0 ~ 97.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                     | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                     | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                      | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                       | 10                      | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                      | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                      | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 12                    | 4                        | 4                       | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                      | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                       | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 12.0                  | 8.0                      | 15.0                    | 14.0                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                      | 1.0                     | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                      | 1.0                     | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 127.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 191.0 | 116.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 208.0 | 133.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 214.0 | 139.0 | 114.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 75.0  | 25.0  | 8.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 11.2 ~ 12.2 | 14.2 ~ 17.4 | 14.7 ~ 16.3 | 13.3 ~ 14.7 |  |  |  |
| Average Voltage Gap  | V   |  | 63 ~ 79     | 121 ~ 135   | 106 ~ 120   | 104 ~ 119   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 702.0       | 403.3       | 281.3       | 210.7       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Al            | 10mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 1741                  | 1742                     | 1743                  | 1744                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                     | 6                     |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 5.0                      | 2.5                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 8                     | 9                        |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 3                     | 2                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 7                        | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 56.0<br>(53.0 ~ 59.0) | 120.0<br>(118.0 ~ 122.0) | 90.0<br>(88.0 ~ 92.0) | 90.0<br>(88.0 ~ 92.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                       | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 10.0                  | 8.0                      | 15.0                  | 14.0                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 128.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 191.0 | 116.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 208.0 | 133.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 214.0 | 139.0 | 114.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 75.0  | 25.0  | 8.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 8.4 ~ 10.2  | 14.0 ~ 17.0 | 14.7 ~ 16.3 | 13.3 ~ 14.7 |  |  |  |
| Average Voltage Gap  | V   |  | 49 ~ 63     | 114 ~ 128   | 95 ~ 110    | 99 ~ 115    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 558.0       | 348.8       | 253.6       | 194.8       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Al            | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 1751                  | 1752                     | 1753                  | 1754                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                     | 6                     |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 8.0                   | 5.0                      | 2.5                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 9                        |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 2                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 56.0<br>(53.0 ~ 59.0) | 116.0<br>(114.0 ~ 118.0) | 80.0<br>(78.0 ~ 82.0) | 75.0<br>(73.0 ~ 77.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                       | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 8.0                   | 8.0                      | 14.0                  | 13.0                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 134.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 191.0 | 116.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 207.0 | 132.0 | 107.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 213.0 | 138.0 | 113.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 75.0  | 25.0  | 8.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 7.1 ~ 8.7   | 11.2 ~ 13.8 | 13.9 ~ 15.3 | 12.7 ~ 14.1 |  |  |  |
| Average Voltage Gap  | V   |  | 47 ~ 62     | 108 ~ 124   | 83 ~ 98     | 77 ~ 92     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 474.0       | 290.4       | 218.1       | 171.6       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Al            | 30mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 1761                  | 1762                     | 1763                  | 1764                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                     | 6                     |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 8.0                   | 5.0                      | 2.5                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 9                        |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 2                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 56.0<br>(53.0 ~ 59.0) | 113.0<br>(111.0 ~ 115.0) | 72.0<br>(70.0 ~ 74.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                       | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 7.0                   | 7.0                      | 12.0                  | 11.0                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 139.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 192.0 | 117.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 207.0 | 132.0 | 107.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 212.0 | 137.0 | 112.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 75.0  | 25.0  | 7.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 6.0 ~ 7.3   | 10.4 ~ 12.8 | 11.9 ~ 13.1 | 10.6 ~ 11.8 |  |  |  |
| Average Voltage Gap  | V   |  | 48 ~ 62     | 105 ~ 120   | 77 ~ 92     | 73 ~ 88     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 399.0       | 253.6       | 189.5       | 147.8       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Al            | 40mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 1771                  | 1772                     | 1773                  | 1774                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                     | 6                     |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                      | 2.5                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 9                        |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 56.0<br>(53.0 ~ 59.0) | 110.0<br>(108.0 ~ 112.0) | 65.0<br>(63.0 ~ 67.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                       | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 6.0                   | 6.0                      | 10.0                  | 9.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 143.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 192.0 | 117.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 206.0 | 131.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 211.0 | 136.0 | 111.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 75.0  | 25.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 4.8 ~ 5.8   | 9.7 ~ 11.9  | 9.9 ~ 10.9  | 8.6 ~ 9.6   |  |  |  |
| Average Voltage Gap  | V   |  | 49 ~ 63     | 102 ~ 118   | 71 ~ 87     | 70 ~ 84     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 318.0       | 213.3       | 159.0       | 123.1       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Al            | 50mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 943                   | 1781                  | 1782                     | 1783                  | 1784                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                     | 7                     |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                      | 2.5                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 9                        |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 55.0<br>(52.0 ~ 58.0) | 108.0<br>(106.0 ~ 110.0) | 60.0<br>(58.0 ~ 62.0) | 62.0<br>(60.0 ~ 64.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                       | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 5.0                   | 5.5                      | 9.5                   | 8.7                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 144.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 191.0 | 116.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 206.0 | 131.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 211.0 | 136.0 | 111.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 75.0  | 25.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 4.2 ~ 5.1   | 9.1 ~ 11.1  | 9.4 ~ 10.4  | 8.4 ~ 9.3   |  |  |  |
| Average Voltage Gap  | V   |  | 47 ~ 62     | 100 ~ 116   | 65 ~ 80     | 69 ~ 84     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 279.0       | 191.0       | 144.6       | 113.6       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Al            | 60mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 943                   | 1791                  | 1792                     | 1793                  | 1794                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                     | 8                     |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 6.0                      | 2.5                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 4                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 54.0<br>(51.0 ~ 57.0) | 106.0<br>(104.0 ~ 108.0) | 55.0<br>(53.0 ~ 57.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                       | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 4.0                   | 5.0                      | 9.0                   | 8.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 144.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 190.0 | 115.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 206.0 | 131.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 211.0 | 136.0 | 111.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 75.0  | 25.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.6 ~ 4.4   | 8.6 ~ 10.4  | 8.9 ~ 9.9   | 8.2 ~ 9.0   |  |  |  |
| Average Voltage Gap  | V   |  | 46 ~ 61     | 99 ~ 114    | 69 ~ 74     | 68 ~ 84     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 240.0       | 168.9       | 130.0       | 103.8       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Al            | 70mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 944                   | 1801                  | 1802                     | 1803                  | 1804                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                     | 8                     |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 6.0                      | 2.5                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                       |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 4                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 62.0<br>(59.0 ~ 65.0) | 107.0<br>(105.0 ~ 109.0) | 52.0<br>(50.0 ~ 54.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                       | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 3.0                   | 5.5                      | 8.5                   | 8.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 152.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 197.0 | 117.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 213.0 | 133.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 218.0 | 138.0 | 113.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 80.0  | 25.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.8 ~ 3.4   | 8.4 ~ 10.2  | 8.4 ~ 9.3   | 7.8 ~ 8.5   |  |  |  |
| Average Voltage Gap  | V   |  | 53 ~ 69     | 100 ~ 114   | 60 ~ 75     | 67 ~ 82     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 186.0       | 139.5       | 110.5       | 90.1        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Al            | 80mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 944                   | 1811                  | 1812                     | 1813                  | 1814                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KH                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                     | 8                     |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 6.0                      | 2.5                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 11                       |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 70.0<br>(67.0 ~ 73.0) | 108.0<br>(106.0 ~ 110.0) | 50.0<br>(48.0 ~ 52.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                       | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 2.0                   | 6.0                      | 8.0                   | 7.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 159.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 203.0 | 118.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 220.0 | 135.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 224.0 | 139.0 | 114.0 | 108.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 25.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.0 ~ 2.4   | 8.2 ~ 10.0  | 7.9 ~ 8.7   | 7.3 ~ 8.1   |  |  |  |
| Average Voltage Gap  | V   |  | 61 ~ 77     | 101 ~ 115   | 61 ~ 76     | 67 ~ 81     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 132.0       | 106.3       | 87.6        | 73.6        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Al            | 90mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 945                   | 1821                  | 1822                     | 1823                  | 1824                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 10                    | 9                     |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 6.0                      | 2.5                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 11                       |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 70.0<br>(67.0 ~ 73.0) | 107.0<br>(105.0 ~ 109.0) | 50.0<br>(48.0 ~ 52.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                       | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 2.0                   | 5.5                      | 7.2                   | 6.7                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 160.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 207.0 | 119.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 228.0 | 140.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 233.0 | 145.0 | 115.0 | 108.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 88.0  | 30.0  | 7.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.7 ~ 2.2   | 7.2 ~ 9.2   | 7.2 ~ 7.9   | 6.6 ~ 7.3   |  |  |  |
| Average Voltage Gap  | V   |  | 62 ~ 77     | 100 ~ 114   | 59 ~ 75     | 62 ~ 77     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 117.0       | 94.5        | 78.2        | 65.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | Al            | 100mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 945                   | 1831                  | 1832                     | 1833                  | 1834                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 12                    | 10                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 6.0                      | 2.5                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 11                       |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 6                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 70.0<br>(67.0 ~ 73.0) | 106.0<br>(104.0 ~ 108.0) | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                       | 10                    | 10                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 2.0                   | 5.0                      | 6.5                   | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 160.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 210.0 | 120.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 234.0 | 144.0 | 109.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 239.0 | 149.0 | 114.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 35.0  | 8.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.5 ~ 1.9   | 6.2 ~ 7.6   | 6.5 ~ 7.1   | 5.9 ~ 6.5   |  |  |  |
| Average Voltage Gap  | V   |  | 63 ~ 78     | 99 ~ 113    | 58 ~ 74     | 58 ~ 73     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 102.0       | 81.8        | 68.2        | 57.6        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| 0.20BS             | Graphite      | Class1 |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 941             | RH | 2.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1901            | RL | 2.8 | 136.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 941             | RH | 2.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1911            | RL | 1.8 | 138.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 942             | RH | 1.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1921            | RL | 1.2 | 138.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



# MV2400R

## Digest

|                    |               |        |
|--------------------|---------------|--------|
| Wire Dia. and Type | Material Type | Class  |
| 0.20BS             | Graphite      | Class1 |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 942             | RH | 1.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1931            | RL | 0.9 | 138.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 943             | RH | 0.7 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1941            | RL | 0.7 | 135.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 943             | RH | 0.7 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1951            | RL | 0.5 | 132.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| 0.20BS             | Graphite      | Class1 |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 944             | RH | 0.6 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1961            | RL | 0.5 | 137.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 944             | RH | 0.6 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1971            | RL | 0.5 | 142.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 945             | RH | 0.5 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1981            | RL | 0.5 | 141.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R

## Digest

|                    |               |        |
|--------------------|---------------|--------|
| Wire Dia. and Type | Material Type | Class  |
| 0.20BS             | Graphite      | Class1 |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 945             | RH | 0.5 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1991            | RL | 0.5 | 141.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 2                 |                 |    |    | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |    | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |    | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |    | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |    | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |    | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 2                 |                 |    |    | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |    | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |    | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |    | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |    | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |    | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| 0.20BS             | Graphite      | Class2 |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 941             | RH | 2.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1902            | RL | 2.8 | 139.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 941             | RH | 2.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1912            | RL | 1.8 | 142.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 942             | RH | 1.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1922            | RL | 1.2 | 143.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| 0.20BS             | Graphite      | Class2 |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 942             | RH | 1.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1932            | RL | 0.9 | 144.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 943             | RH | 0.7 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1942            | RL | 0.8 | 144.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 943             | RH | 0.7 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1952            | RL | 0.7 | 144.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R

## Digest

|                    |               |        |
|--------------------|---------------|--------|
| Wire Dia. and Type | Material Type | Class  |
| 0.20BS             | Graphite      | Class2 |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 944             | RH | 0.6 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1962            | RL | 0.6 | 146.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 944             | RH | 0.6 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1972            | RL | 0.6 | 148.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 945             | RH | 0.5 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1982            | RL | 0.6 | 146.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R

## Digest

|                    |               |        |
|--------------------|---------------|--------|
| Wire Dia. and Type | Material Type | Class  |
| 0.20BS             | Graphite      | Class2 |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 945             | RH | 0.5 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1992            | RL | 0.5 | 145.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 2                 |                 |    |    | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |    | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |    | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |    | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |    | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |    | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 2                 |                 |    |    | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |    | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |    | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |    | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |    | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |    | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| 0.20BS             | Graphite      | Class3 |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 941             | RH | 2.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1903            | RL | 3.0 | 140.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 941             | RH | 2.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1913            | RL | 2.0 | 141.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 942             | RH | 1.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1923            | RL | 1.3 | 145.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| 0.20BS             | Graphite      | Class3 |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 942             | RH | 1.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1933            | RL | 1.0 | 148.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 943             | RH | 0.7 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1943            | RL | 1.0 | 147.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 943             | RH | 0.7 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1953            | RL | 1.0 | 147.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| 0.20BS             | Graphite      | Class3 |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 944             | RH | 0.6 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1963            | RL | 0.9 | 150.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 944             | RH | 0.6 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1973            | RL | 0.8 | 154.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 945             | RH | 0.5 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1983            | RL | 0.6 | 154.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R

## Digest

|                    |               |        |
|--------------------|---------------|--------|
| Wire Dia. and Type | Material Type | Class  |
| 0.20BS             | Graphite      | Class3 |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 945             | RH | 0.5 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 1993            | RL | 0.5 | 153.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 2                 |                 |    |    | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |    | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |    | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |    | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |    | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |    | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 2                 |                 |    |    | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |    | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |    | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |    | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |    | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |    | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.20BS             | Graphite      | 10mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 941               | 1901              |        | 1902              |        | 1903              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 6.0               | 6.0               |        | 7.0               |        | 9.0               |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 11                |        | 12                |        | 12                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 8                 | 14                |        | 15                |        | 11                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 60.0<br>(58 ~ 62) | 60.0<br>(57 ~ 63) |        | 80.0<br>(77 ~ 83) |        | 55.0<br>(52 ~ 58) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 6                 | 8                 |        | 8                 |        | 8                 |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 12                |        | 12                |        | 12                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 2.0               | 2.8               |        | 2.8               |        | 3.0               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 136.0 |  | 139.0 |  | 140.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 3.8 ~ 4.1   |  | 4.8 ~ 5.3   |  | 8.2 ~ 8.8   |  |  |  |  |
| Average Voltage Gap  | V   |  | 64 ~ 66     |  | 60 ~ 63     |  | 60 ~ 72     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 38.0        |  | 48.0        |  | 82.0        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.20BS             | Graphite      | 20mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 941               | 1911              |        | 1912              |        | 1913              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 6.0               | 6.0               |        | 8.0               |        | 11.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 11                |        | 12                |        | 13                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 8                 | 12                |        | 13                |        | 11                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 60.0<br>(58 ~ 62) | 50.0<br>(47 ~ 53) |        | 60.0<br>(57 ~ 63) |        | 55.0<br>(52 ~ 58) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 6                 | 8                 |        | 8                 |        | 8                 |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 2.0               | 1.8               |        | 1.8               |        | 2.0               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 138.0 |  | 142.0 |  | 141.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 1.7 ~ 2.2   |  | 3.1 ~ 3.5   |  | 5.3 ~ 5.6   |  |  |  |  |
| Average Voltage Gap  | V   |  | 54 ~ 57     |  | 64 ~ 65     |  | 66 ~ 72     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 34.0        |  | 62.0        |  | 106.0       |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.20BS             | Graphite      | 30mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 942               | 1921              |        | 1922              |        | 1923              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 7.0               | 6.0               |        | 8.0               |        | 11.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 11                |        | 12                |        | 13                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 8                 | 12                |        | 13                |        | 11                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 55.0<br>(52 ~ 58) |        | 55.0<br>(52 ~ 58) |        | 55.0<br>(52 ~ 58) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 6                 | 8                 |        | 8                 |        | 8                 |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 1.0               | 1.2               |        | 1.2               |        | 1.3               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 138.0 |  | 143.0 |  | 145.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 1.1 ~ 1.4   |  | 1.6 ~ 2.0   |  | 2.5 ~ 2.8   |  |  |  |  |
| Average Voltage Gap  | V   |  | 55 ~ 58     |  | 51 ~ 60     |  | 53 ~ 61     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 30.0        |  | 48.0        |  | 75.0        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.20BS             | Graphite      | 40mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 942               | 1931              |        | 1932              |        | 1933              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 7.0               | 7.0               |        | 8.0               |        | 11.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 11                |        | 12                |        | 13                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 8                 | 13                |        | 14                |        | 11                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 60.0<br>(57 ~ 63) |        | 50.0<br>(47 ~ 53) |        | 60.0<br>(57 ~ 63) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 6                 | 8                 |        | 8                 |        | 8                 |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 1.0               | 0.9               |        | 0.9               |        | 1.0               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 138.0 |  | 144.0 |  | 148.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.9 ~ 1.1   |  | 1.2 ~ 1.8   |  | 2.3 ~ 2.4   |  |  |  |  |
| Average Voltage Gap  | V   |  | 56 ~ 60     |  | 43 ~ 58     |  | 44 ~ 51     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 36.0        |  | 48.0        |  | 92.0        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.20BS             | Graphite      | 50mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 943               | 1941              |        | 1942              |        | 1943              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 7.0               | 7.0               |        | 8.0               |        | 11.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 11                |        | 12                |        | 13                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 7                 | 13                |        | 14                |        | 12                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 50.0<br>(47 ~ 53) |        | 50.0<br>(47 ~ 53) |        | 55.0<br>(52 ~ 58) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 6                 | 8                 |        | 8                 |        | 8                 |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 0.7               | 0.7               |        | 0.8               |        | 1.0               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 135.0 |  | 144.0 |  | 147.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.7 ~ 1.1   |  | 1.0 ~ 1.5   |  | 1.3 ~ 1.8   |  |  |  |  |
| Average Voltage Gap  | V   |  | 45 ~ 49     |  | 38 ~ 43     |  | 41 ~ 48     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 35.0        |  | 50.0        |  | 65.0        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)



## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.20BS             | Graphite      | 60mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 943               | 1951              |        | 1952              |        | 1953              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 7.0               | 7.0               |        | 8.0               |        | 11.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 12                |        | 12                |        | 13                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 7                 | 14                |        | 15                |        | 13                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 40.0<br>(37 ~ 43) |        | 50.0<br>(47 ~ 53) |        | 50.0<br>(47 ~ 53) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 6                 | 8                 |        | 8                 |        | 8                 |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 0.7               | 0.5               |        | 0.7               |        | 1.0               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 132.0 |  | 144.0 |  | 147.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.6 ~ 0.9   |  | 0.7 ~ 1.1   |  | 1.3 ~ 1.8   |  |  |  |  |
| Average Voltage Gap  | V   |  | 32 ~ 44     |  | 33 ~ 38     |  | 38 ~ 45     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 36.0        |  | 42.0        |  | 78.0        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.20BS             | Graphite      | 70mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 944               | 1961              |        | 1962              |        | 1963              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 7.0               | 7.0               |        | 8.0               |        | 11.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 12                |        | 12                |        | 13                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 7                 | 14                |        | 15                |        | 13                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 45.0<br>(42 ~ 48) |        | 50.0<br>(47 ~ 53) |        | 50.0<br>(47 ~ 53) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 6                 | 8                 |        | 8                 |        | 8                 |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 0.6               | 0.5               |        | 0.6               |        | 0.9               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 137.0 |  | 146.0 |  | 150.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.6 ~ 0.9   |  | 0.6 ~ 1.1   |  | 1.0 ~ 1.5   |  |  |  |  |
| Average Voltage Gap  | V   |  | 40 ~ 45     |  | 44 ~ 54     |  | 42 ~ 50     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 42.0        |  | 42.0        |  | 70.0        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

Version9.0

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.20BS             | Graphite      | 80mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 944               | 1971              |        | 1972              |        | 1973              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 7.0               | 7.0               |        | 8.0               |        | 11.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 12                |        | 13                |        | 13                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 7                 | 15                |        | 15                |        | 13                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 50.0<br>(47 ~ 53) |        | 50.0<br>(47 ~ 53) |        | 50.0<br>(47 ~ 53) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 6                 | 8                 |        | 8                 |        | 8                 |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 0.6               | 0.5               |        | 0.6               |        | 0.8               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 142.0 |  | 148.0 |  | 154.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.5 ~ 0.8   |  | 0.5 ~ 1.1   |  | 0.7 ~ 1.3   |  |  |  |  |
| Average Voltage Gap  | V   |  | 49 ~ 54     |  | 52 ~ 62     |  | 47 ~ 57     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 40.0        |  | 40.0        |  | 56.0        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

Version9.0

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.20BS             | Graphite      | 90mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 945               | 1981              |        | 1982              |        | 1983              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 7.0               | 7.0               |        | 8.0               |        | 11.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 12                |        | 13                |        | 13                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 6                 | 15                |        | 15                |        | 14                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 50.0<br>(47 ~ 53) |        | 50.0<br>(47 ~ 53) |        | 50.0<br>(47 ~ 53) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 10                |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 6                 | 8                 |        | 8                 |        | 8                 |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 0.5               | 0.5               |        | 0.6               |        | 0.6               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 141.0 |  | 146.0 |  | 154.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.5 ~ 0.7   |  | 0.5 ~ 1.0   |  | 0.5 ~ 1.0   |  |  |  |  |
| Average Voltage Gap  | V   |  | 46 ~ 50     |  | 50 ~ 55     |  | 47 ~ 55     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 45.0        |  | 47.0        |  | 47.0        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.20BS             | Graphite      | 100mm              | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 945               | 1991              |        | 1992              |        | 1993              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 7.0               | 7.0               |        | 8.0               |        | 11.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 12                |        | 13                |        | 13                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 4                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 6                 | 15                |        | 15                |        | 15                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 50.0<br>(47 ~ 53) |        | 50.0<br>(47 ~ 53) |        | 50.0<br>(47 ~ 53) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 11                |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 6                 | 8                 |        | 8                 |        | 8                 |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 0.5               | 0.5               |        | 0.5               |        | 0.5               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 141.0 |  | 145.0 |  | 153.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.4 ~ 0.7   |  | 0.4 ~ 0.8   |  | 0.4 ~ 0.8   |  |  |  |  |
| Average Voltage Gap  | V   |  | 46 ~ 48     |  | 46 ~ 48     |  | 49 ~ 54     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 40.0        |  | 40.5        |  | 40.5        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

**5-2 ø0.25 Wire**  
**Machining Characteristics Data**

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.25BS            | STEEL         | STD P1 |

Thickness 5 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 2001            | RH | 7.5  | 156.0  | 192.0 | 203.0 | 205.0 |     |     |     |     | 0.0       |
| 2                 | 2002            | HL | 5.0  | -      | 132.0 | 143.0 | 145.0 |     |     |     |     | 60.0      |
| 3                 | 2003            | LC | 10.0 | -      | -     | 131.0 | 133.0 |     |     |     |     | 12.0      |
| 4                 | 2004            | LA | 10.0 | -      | -     | -     | 130.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 2011            | RH | 5.0  | 154.0  | 190.0 | 203.0 | 208.0 |     |     |     |     | 0.0       |
| 2                 | 2012            | HL | 4.8  | -      | 130.0 | 143.0 | 148.0 |     |     |     |     | 60.0      |
| 3                 | 2013            | LC | 10.0 | -      | -     | 133.0 | 138.0 |     |     |     |     | 10.0      |
| 4                 | 2014            | LA | 10.0 | -      | -     | -     | 132.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 2021            | RH | 3.4 | 161.0  | 196.0 | 209.0 | 212.0 |     |     |     |     | 0.0       |
| 2                 | 2022            | HL | 3.2 | -      | 131.0 | 144.0 | 147.0 |     |     |     |     | 65.0      |
| 3                 | 2023            | LC | 9.0 | -      | -     | 131.0 | 134.0 |     |     |     |     | 13.0      |
| 4                 | 2024            | LA | 9.0 | -      | -     | -     | 130.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | STDP1 |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 2031            | RH | 2.9 | 165.0  | 199.0 | 214.0 | 217.0 |     |     |     |     | 0.0       |
| 2                 | 2032            | HL | 2.8 | -      | 131.0 | 146.0 | 149.0 |     |     |     |     | 68.0      |
| 3                 | 2033            | LC | 8.2 | -      | -     | 132.0 | 135.0 |     |     |     |     | 14.0      |
| 4                 | 2034            | LA | 8.2 | -      | -     | -     | 131.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 2041            | RH | 2.4 | 170.0  | 202.0 | 216.0 | 219.0 |     |     |     |     | 0.0       |
| 2                 | 2042            | HL | 2.4 | -      | 132.0 | 146.0 | 149.0 |     |     |     |     | 70.0      |
| 3                 | 2043            | LC | 7.4 | -      | -     | 132.0 | 135.0 |     |     |     |     | 14.0      |
| 4                 | 2044            | LA | 7.4 | -      | -     | -     | 131.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 953             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 2051            | RH | 1.9 | 171.0  | 202.0 | 217.0 | 220.0 |     |     |     |     | 0.0       |
| 2                 | 2052            | HL | 2.0 | -      | 132.0 | 147.0 | 150.0 |     |     |     |     | 70.0      |
| 3                 | 2053            | LC | 6.6 | -      | -     | 133.0 | 136.0 |     |     |     |     | 14.0      |
| 4                 | 2054            | LA | 6.6 | -      | -     | -     | 132.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.25BS            | STEEL         | STD P1 |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 953             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 2061            | RH | 1.4 | 171.0  | 202.0 | 218.0 | 221.0 |     |     |     |     | 0.0       |
| 2                 | 2062            | HL | 1.6 | -      | 132.0 | 148.0 | 151.0 |     |     |     |     | 70.0      |
| 3                 | 2063            | LC | 5.8 | -      | -     | 134.0 | 137.0 |     |     |     |     | 14.0      |
| 4                 | 2064            | LA | 5.8 | -      | -     | -     | 133.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 2071            | RH | 1.2 | 186.0  | 209.0 | 224.0 | 227.0 |     |     |     |     | 0.0       |
| 2                 | 2072            | HL | 1.5 | -      | 131.0 | 146.0 | 149.0 |     |     |     |     | 78.0      |
| 3                 | 2073            | LC | 5.7 | -      | -     | 133.0 | 136.0 |     |     |     |     | 13.0      |
| 4                 | 2074            | LA | 5.7 | -      | -     | -     | 132.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 2081            | RH | 1.0 | 182.0  | 215.0 | 230.0 | 233.0 |     |     |     |     | 0.0       |
| 2                 | 2082            | HL | 1.4 | -      | 130.0 | 145.0 | 148.0 |     |     |     |     | 85.0      |
| 3                 | 2083            | LC | 5.6 | -      | -     | 133.0 | 136.0 |     |     |     |     | 12.0      |
| 4                 | 2084            | LA | 5.6 | -      | -     | -     | 132.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.25BS            | STEEL         | STD P1 |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 2091            | RH | 0.8 | 182.0  | 219.0 | 234.0 | 237.0 |     |     |     |     | 0.0       |
| 2                 | 2092            | HL | 1.3 | -      | 131.0 | 146.0 | 149.0 |     |     |     |     | 88.0      |
| 3                 | 2093            | LC | 5.5 | -      | -     | 134.0 | 137.0 |     |     |     |     | 12.0      |
| 4                 | 2094            | LA | 5.5 | -      | -     | -     | 133.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 2101            | RH | 0.6 | 183.0  | 221.0 | 237.0 | 240.0 |     |     |     |     | 0.0       |
| 2                 | 2102            | HL | 1.2 | -      | 131.0 | 147.0 | 150.0 |     |     |     |     | 90.0      |
| 3                 | 2103            | LC | 5.4 | -      | -     | 135.0 | 138.0 |     |     |     |     | 12.0      |
| 4                 | 2104            | LA | 5.4 | -      | -     | -     | 134.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 5mm                | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                   | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-------------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 2001                  | 2002                  | 2003                     | 2004                    |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                      |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                      |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 10                       | 10                      |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 12.0                  | 3.0                      | 2.0                     |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 11                    |                          |                         |       |       |       |       |
| Off Time           | OFF | 6                     | 5                     | 13                    | 1                        | 1                       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                       |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 7                     | 13                    | 1                        | 1                       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                       |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(57.0 ~ 63.0) | 80.0<br>(78.0 ~ 82.0) | 140.0<br>(138.0 ~ 142.0) | 100.0<br>(98.0 ~ 102.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                      |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                      | OFF                     |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 9                        | 9                       |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                       | 14                      |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                      |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                      |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 12                    | 4                     | 4                        | 4                       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                      |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                       |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 7.5                   | 5.0                   | 10.0                     | 10.0                    |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                      | 1.0                     |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                      | 1.0                     |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 156.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 192.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 203.0 | 143.0 | 131.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 205.0 | 145.0 | 133.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 60.0  | 12.0  | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 10.3 ~ 13.2 | 8.5 ~ 11.4  | 9.5 ~ 10.5  | 9.5 ~ 10.5  |  |  |  |
| Average Voltage Gap  | V   |  | 47 ~ 67     | 77 ~ 87     | 164 ~ 173   | 110 ~ 121   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 705.0       | 323.3       | 210.1       | 155.6       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 10mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 2011                  | 2012                  | 2013                     | 2014                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                       | 10                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 14.0                  | 3.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 5                     | 11                    | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 11                    | 1                        | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 52.0<br>(49.0 ~ 55.0) | 76.0<br>(74.0 ~ 78.0) | 120.0<br>(118.0 ~ 122.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 9                        | 9                     |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 5.0                   | 4.8                   | 10.0                     | 10.0                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 154.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 190.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 203.0 | 143.0 | 133.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 208.0 | 148.0 | 138.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 60.0  | 10.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 8.1 ~ 10.5  | 7.8 ~ 10.3  | 9.5 ~ 10.5  | 9.5 ~ 10.5  |  |  |  |
| Average Voltage Gap  | V   |  | 45 ~ 62     | 73 ~ 83     | 159 ~ 168   | 91 ~ 102    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 558.0       | 275.2       | 188.7       | 143.5       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 20mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 2021                  | 2022                  | 2023                     | 2024                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 12                       | 10                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 14.0                  | 3.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 10                    | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 10                    | 1                        | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 71.0<br>(69.0 ~ 73.0) | 110.0<br>(108.0 ~ 112.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 9                        | 9                     |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 3.4                   | 3.2                   | 9.0                      | 9.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 161.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 196.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 209.0 | 144.0 | 131.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 212.0 | 147.0 | 134.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 5.1 ~ 6.9   | 4.1 ~ 6.3   | 8.5 ~ 9.5   | 8.5 ~ 9.5   |  |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 56     | 68 ~ 78     | 138 ~ 152   | 92 ~ 105    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 360.0       | 167.1       | 127.6       | 103.2       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 30mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                   | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 952                   | 2031                  | 2032                  | 2033                    | 2034                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                      | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                      | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 13                    | 13                      | 12                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 10.0                  | 14.0                  | 3.0                     | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                         |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                       | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                       | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 3                     | 10                    | 1                       | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                       | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                       | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(42.0 ~ 48.0) | 65.0<br>(63.0 ~ 67.0) | 100.0<br>(98.0 ~ 102.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                      | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                     | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                      | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                      | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                      | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                      | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                       | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                      | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                      | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.9                   | 2.8                   | 8.2                     | 8.2                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 165.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 199.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 214.0 | 146.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 217.0 | 149.0 | 135.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 68.0  | 14.0  | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 4.0 ~ 5.6   | 3.2 ~ 5.3   | 7.7 ~ 8.7   | 7.7 ~ 8.7   |  |  |  |
| Average Voltage Gap  | V   |  | 34 ~ 55     | 62 ~ 72     | 126 ~ 140   | 83 ~ 94     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 288.0       | 135.2       | 106.1       | 87.3        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 40mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 952                   | 2041                  | 2042                  | 2043                  | 2044                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 13                    | 13                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 10.0                  | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 44.0<br>(41.0 ~ 47.0) | 59.0<br>(57.0 ~ 61.0) | 90.0<br>(88.0 ~ 92.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.4                   | 2.4                   | 7.4                   | 7.4                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 170.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 202.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 216.0 | 146.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 219.0 | 149.0 | 135.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 14.0  | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.9 ~ 4.2   | 2.3 ~ 4.2   | 6.9 ~ 7.9   | 6.9 ~ 7.9   |  |  |  |
| Average Voltage Gap  | V   |  | 34 ~ 55     | 56 ~ 66     | 114 ~ 129   | 73 ~ 83     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 213.0       | 101.8       | 82.8        | 69.8        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 50mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 953                   | 2051                  | 2052                  | 2053                  | 2054                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 14                    | 14                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 10.0                  | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 43.0<br>(40.0 ~ 46.0) | 53.0<br>(51.0 ~ 55.0) | 80.0<br>(78.0 ~ 82.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.9                   | 2.0                   | 6.6                   | 6.6                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 171.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 202.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 217.0 | 147.0 | 133.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 220.0 | 150.0 | 136.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 14.0  | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.4 ~ 3.7   | 2.3 ~ 3.9   | 6.1 ~ 7.1   | 6.1 ~ 7.1   |  |  |  |
| Average Voltage Gap  | V   |  | 33 ~ 56     | 50 ~ 60     | 105 ~ 121   | 66 ~ 77     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 183.0       | 92.2        | 74.8        | 62.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 60mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 953                   | 2061                  | 2062                  | 2063                  | 2064                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 14                    | 14                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 42.0<br>(39.0 ~ 45.0) | 47.0<br>(45.0 ~ 49.0) | 70.0<br>(68.0 ~ 72.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.4                   | 1.6                   | 5.8                   | 5.8                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 171.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 202.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 218.0 | 148.0 | 134.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 221.0 | 151.0 | 137.0 | 133.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 14.0  | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.9 ~ 3.0   | 2.3 ~ 3.8   | 5.3 ~ 6.3   | 5.3 ~ 6.3   |  |  |  |
| Average Voltage Gap  | V   |  | 32 ~ 56     | 44 ~ 54     | 96 ~ 113    | 59 ~ 70     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 147.0       | 81.5        | 66.0        | 55.5        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 70mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 954                   | 2071                  | 2072                  | 2073                  | 2074                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 14                    | 15                    | 15                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 43.0<br>(40.0 ~ 46.0) | 42.0<br>(40.0 ~ 44.0) | 65.0<br>(63.0 ~ 67.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.2                   | 1.5                   | 5.7                   | 5.7                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 186.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 209.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 224.0 | 146.0 | 133.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 227.0 | 149.0 | 136.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 78.0  | 13.0  | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.5 ~ 2.6   | 2.1 ~ 3.6   | 5.2 ~ 6.2   | 5.2 ~ 6.2   |  |  |  |
| Average Voltage Gap  | V   |  | 33 ~ 55     | 39 ~ 49     | 90 ~ 104    | 55 ~ 65     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 123.0       | 71.5        | 59.2        | 50.4        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 80mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 954                   | 2081                  | 2082                  | 2083                  | 2084                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 14                    | 15                    | 15                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 8                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 44.0<br>(41.0 ~ 47.0) | 38.0<br>(36.0 ~ 40.0) | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.0                   | 1.4                   | 5.6                   | 5.6                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 182.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 215.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 230.0 | 145.0 | 133.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 233.0 | 148.0 | 136.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 12.0  | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.1 ~ 2.1   | 1.8 ~ 3.0   | 5.1 ~ 6.1   | 5.1 ~ 6.1   |  |  |  |
| Average Voltage Gap  | V   |  | 34 ~ 54     | 35 ~ 45     | 84 ~ 96     | 50 ~ 59     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 96.0        | 57.6        | 49.2        | 42.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 90mm               | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 955                   | 2091                  | 2092                  | 2093                  | 2094                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 14                    | 16                    | 16                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 8                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(42.0 ~ 48.0) | 36.0<br>(34.0 ~ 38.0) | 55.0<br>(53.0 ~ 57.0) | 35.0<br>(33.0 ~ 37.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.8                   | 1.3                   | 5.5                   | 5.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 182.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 219.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 234.0 | 146.0 | 134.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 237.0 | 149.0 | 137.0 | 133.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 88.0  | 12.0  | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.7   | 1.8 ~ 2.8   | 5.0 ~ 6.0   | 5.0 ~ 6.0   |  |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 55     | 33 ~ 43     | 76 ~ 85     | 47 ~ 55     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 75.0        | 48.6        | 42.4        | 37.5        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 100mm              | STDP1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 955                   | 2101                  | 2102                  | 2103                  | 2104                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 14                    | 16                    | 16                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 8                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 46.0<br>(43.0 ~ 49.0) | 35.0<br>(33.0 ~ 37.0) | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.6                   | 1.2                   | 5.4                   | 5.4                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 183.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 221.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 237.0 | 147.0 | 135.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 240.0 | 150.0 | 138.0 | 134.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 12.0  | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 0.5 ~ 1.5   | 1.7 ~ 2.7   | 4.9 ~ 5.9   | 4.9 ~ 5.9   |  |  |  |
| Average Voltage Gap  | V   |  | 36 ~ 57     | 32 ~ 42     | 67 ~ 73     | 45 ~ 51     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 60.0        | 41.3        | 36.6        | 32.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | STDD1 |

Thickness 5 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 12511           | RH | 7.5  | 154.0  | 192.0 | 204.0 | 207.0 |     |     |     |     | 0.0       |
| 2                 | 12512           | HL | 5.0  | -      | 132.0 | 144.0 | 147.0 |     |     |     |     | 60.0      |
| 3                 | 12513           | LC | 10.0 | -      | -     | 132.0 | 135.0 |     |     |     |     | 12.0      |
| 4                 | 12514           | LA | 10.0 | -      | -     | -     | 132.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 12521           | RH | 5.0  | 153.0  | 192.0 | 203.0 | 206.0 |     |     |     |     | 0.0       |
| 2                 | 12522           | HL | 4.8  | -      | 132.0 | 143.0 | 146.0 |     |     |     |     | 60.0      |
| 3                 | 12523           | LC | 10.0 | -      | -     | 133.0 | 136.0 |     |     |     |     | 10.0      |
| 4                 | 12524           | LA | 10.0 | -      | -     | -     | 131.0 |     |     |     |     | 5.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 12531           | RH | 3.4 | 158.0  | 196.0 | 208.0 | 211.0 |     |     |     |     | 0.0       |
| 2                 | 12532           | HL | 3.2 | -      | 131.0 | 143.0 | 146.0 |     |     |     |     | 65.0      |
| 3                 | 12533           | LC | 9.0 | -      | -     | 131.0 | 134.0 |     |     |     |     | 12.0      |
| 4                 | 12534           | LA | 9.0 | -      | -     | -     | 131.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | STDD1 |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 12541           | RH | 2.9 | 161.0  | 200.0 | 211.0 | 215.0 |     |     |     |     | 0.0       |
| 2                 | 12542           | HL | 2.8 | -      | 132.0 | 143.0 | 147.0 |     |     |     |     | 68.0      |
| 3                 | 12543           | LC | 8.2 | -      | -     | 131.0 | 135.0 |     |     |     |     | 12.0      |
| 4                 | 12544           | LA | 8.2 | -      | -     | -     | 132.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 12551           | RH | 2.4 | 165.0  | 204.0 | 214.0 | 219.0 |     |     |     |     | 0.0       |
| 2                 | 12552           | HL | 2.4 | -      | 134.0 | 144.0 | 149.0 |     |     |     |     | 70.0      |
| 3                 | 12553           | LC | 7.4 | -      | -     | 132.0 | 137.0 |     |     |     |     | 12.0      |
| 4                 | 12554           | LA | 7.4 | -      | -     | -     | 134.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 953             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 12561           | RH | 1.9 | 167.0  | 204.0 | 215.0 | 219.0 |     |     |     |     | 0.0       |
| 2                 | 12562           | HL | 2.0 | -      | 134.0 | 145.0 | 149.0 |     |     |     |     | 70.0      |
| 3                 | 12563           | LC | 6.6 | -      | -     | 133.0 | 137.0 |     |     |     |     | 12.0      |
| 4                 | 12564           | LA | 6.6 | -      | -     | -     | 134.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | STDD1 |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 953             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 12571           | RH | 1.4 | 170.0  | 204.0 | 217.0 | 220.0 |     |     |     |     | 0.0       |
| 2                 | 12572           | HL | 1.6 | -      | 134.0 | 147.0 | 150.0 |     |     |     |     | 70.0      |
| 3                 | 12573           | LC | 5.8 | -      | -     | 135.0 | 138.0 |     |     |     |     | 12.0      |
| 4                 | 12574           | LA | 5.8 | -      | -     | -     | 135.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 12581           | RH | 1.2 | 173.0  | 210.0 | 225.0 | 226.0 |     |     |     |     | 0.0       |
| 2                 | 12582           | HL | 1.5 | -      | 132.0 | 147.0 | 148.0 |     |     |     |     | 78.0      |
| 3                 | 12583           | LC | 5.7 | -      | -     | 135.0 | 136.0 |     |     |     |     | 12.0      |
| 4                 | 12584           | LA | 5.7 | -      | -     | -     | 133.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 12591           | RH | 1.0 | 176.0  | 216.0 | 231.0 | 231.0 |     |     |     |     | 0.0       |
| 2                 | 12592           | HL | 1.4 | -      | 131.0 | 146.0 | 146.0 |     |     |     |     | 85.0      |
| 3                 | 12593           | LC | 5.6 | -      | -     | 135.0 | 135.0 |     |     |     |     | 11.0      |
| 4                 | 12594           | LA | 5.6 | -      | -     | -     | 132.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | STDD1 |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 12601           | RH | 0.8 | 178.0  | 219.0 | 232.0 | 234.0 |     |     |     |     | 0.0       |
| 2                 | 12602           | HL | 1.3 | -      | 131.0 | 144.0 | 146.0 |     |     |     |     | 88.0      |
| 3                 | 12603           | LC | 5.5 | -      | -     | 133.0 | 135.0 |     |     |     |     | 11.0      |
| 4                 | 12604           | LA | 5.5 | -      | -     | -     | 132.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 12611           | RH | 0.6 | 181.0  | 221.0 | 233.0 | 236.0 |     |     |     |     | 0.0       |
| 2                 | 12612           | HL | 1.2 | -      | 131.0 | 143.0 | 146.0 |     |     |     |     | 90.0      |
| 3                 | 12613           | LC | 5.4 | -      | -     | 132.0 | 135.0 |     |     |     |     | 11.0      |
| 4                 | 12614           | LA | 5.4 | -      | -     | -     | 132.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   | 2.5   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  | 0.30  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 5mm                | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 12511                 | 12512                 | 12513                    | 12514                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 10                       | 10                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 12.0                  | 3.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 11                    |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 5                     | 13                    | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 7                     | 13                    | 1                        | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(57.0 ~ 63.0) | 75.0<br>(73.0 ~ 77.0) | 135.0<br>(133.0 ~ 137.0) | 95.0<br>(93.0 ~ 97.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 9                        | 9                     |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 12                    | 4                     | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 7.5                   | 5.0                   | 10.0                     | 10.0                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 154.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 192.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 204.0 | 144.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 207.0 | 147.0 | 135.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 60.0  | 12.0  | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 10.3 ~ 13.2 | 8.5 ~ 11.4  | 9.5 ~ 10.5  | 9.5 ~ 10.5  |  |  |  |
| Average Voltage Gap  | V   |  | 47 ~ 67     | 77 ~ 87     | 164 ~ 173   | 110 ~ 121   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 705.0       | 323.3       | 210.1       | 155.6       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 10mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 12521                 | 12522                 | 12523                    | 12524                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                       | 10                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 14.0                  | 3.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 5                     | 11                    | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 11                    | 1                        | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 52.0<br>(49.0 ~ 55.0) | 71.0<br>(69.0 ~ 73.0) | 115.0<br>(113.0 ~ 117.0) | 75.0<br>(73.0 ~ 77.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 9                        | 9                     |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 5.0                   | 4.8                   | 10.0                     | 10.0                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 153.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 192.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 203.0 | 143.0 | 133.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 206.0 | 146.0 | 136.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 60.0  | 10.0  | 5.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 8.1 ~ 10.5  | 7.8 ~ 10.3  | 9.5 ~ 10.5  | 9.5 ~ 10.5  |  |  |  |
| Average Voltage Gap  | V   |  | 45 ~ 62     | 73 ~ 83     | 159 ~ 168   | 91 ~ 102    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 558.0       | 275.2       | 188.7       | 143.5       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 20mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 12531                 | 12532                 | 12533                    | 12534                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 12                       | 10                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 14.0                  | 3.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 10                    | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 10                    | 1                        | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 66.0<br>(64.0 ~ 68.0) | 105.0<br>(103.0 ~ 107.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 9                        | 9                     |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 3.4                   | 3.2                   | 9.0                      | 9.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 158.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 196.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 208.0 | 143.0 | 131.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 211.0 | 146.0 | 134.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 12.0  | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 5.1 ~ 6.9   | 4.1 ~ 6.3   | 8.5 ~ 9.5   | 8.5 ~ 9.5   |  |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 56     | 68 ~ 78     | 138 ~ 152   | 92 ~ 105    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 360.0       | 167.1       | 127.6       | 103.2       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 30mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 952                   | 12541                 | 12542                 | 12543                 | 12544                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 13                    | 13                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 10.0                  | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(42.0 ~ 48.0) | 60.0<br>(58.0 ~ 62.0) | 95.0<br>(93.0 ~ 97.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.9                   | 2.8                   | 8.2                   | 8.2                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 161.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 200.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 211.0 | 143.0 | 131.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 215.0 | 147.0 | 135.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 68.0  | 12.0  | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 4.0 ~ 5.6   | 3.2 ~ 5.3   | 7.7 ~ 8.7   | 7.7 ~ 8.7   |  |  |  |
| Average Voltage Gap  | V   |  | 34 ~ 55     | 62 ~ 72     | 126 ~ 140   | 83 ~ 94     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 288.0       | 135.2       | 106.1       | 87.3        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 40mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 952                   | 12551                 | 12552                 | 12553                 | 12554                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 13                    | 13                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 10.0                  | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 44.0<br>(41.0 ~ 47.0) | 54.0<br>(52.0 ~ 56.0) | 85.0<br>(83.0 ~ 87.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.4                   | 2.4                   | 7.4                   | 7.4                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 165.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 204.0 | 134.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 214.0 | 144.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 219.0 | 149.0 | 137.0 | 134.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 12.0  | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.9 ~ 4.2   | 2.3 ~ 4.2   | 6.9 ~ 7.9   | 6.9 ~ 7.9   |  |  |  |
| Average Voltage Gap  | V   |  | 34 ~ 55     | 56 ~ 66     | 114 ~ 129   | 73 ~ 83     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 213.0       | 101.8       | 82.8        | 69.8        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 50mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 953                   | 12561                 | 12562                 | 12563                 | 12564                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 14                    | 14                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 10.0                  | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 43.0<br>(40.0 ~ 46.0) | 47.0<br>(45.0 ~ 49.0) | 75.0<br>(73.0 ~ 77.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.9                   | 2.0                   | 6.6                   | 6.6                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 167.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 204.0 | 134.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 215.0 | 145.0 | 133.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 219.0 | 149.0 | 137.0 | 134.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 12.0  | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.4 ~ 3.7   | 2.3 ~ 3.9   | 6.1 ~ 7.1   | 6.1 ~ 7.1   |  |  |  |
| Average Voltage Gap  | V   |  | 33 ~ 56     | 50 ~ 60     | 105 ~ 121   | 66 ~ 77     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 183.0       | 92.2        | 74.8        | 62.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 60mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 953                   | 12571                 | 12572                 | 12573                 | 12574                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 14                    | 14                    | 12                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 3                     | 10                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 42.0<br>(39.0 ~ 45.0) | 42.0<br>(40.0 ~ 44.0) | 65.0<br>(63.0 ~ 67.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.4                   | 1.6                   | 5.8                   | 5.8                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 170.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 204.0 | 134.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 217.0 | 147.0 | 135.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 220.0 | 150.0 | 138.0 | 135.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 12.0  | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.9 ~ 3.0   | 2.3 ~ 3.8   | 5.3 ~ 6.3   | 5.3 ~ 6.3   |  |  |  |
| Average Voltage Gap  | V   |  | 32 ~ 56     | 44 ~ 54     | 96 ~ 113    | 59 ~ 70     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 147.0       | 81.5        | 66.0        | 55.5        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 70mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 954                   | 12581                 | 12582                 | 12583                 | 12584                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 14                    | 15                    | 15                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 43.0<br>(40.0 ~ 46.0) | 37.0<br>(35.0 ~ 39.0) | 60.0<br>(58.0 ~ 62.0) | 42.0<br>(40.0 ~ 44.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.2                   | 1.5                   | 5.7                   | 5.7                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 173.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 210.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 225.0 | 147.0 | 135.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 226.0 | 148.0 | 136.0 | 133.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 78.0  | 12.0  | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.5 ~ 2.6   | 2.1 ~ 3.6   | 5.2 ~ 6.2   | 5.2 ~ 6.2   |  |  |  |
| Average Voltage Gap  | V   |  | 33 ~ 55     | 39 ~ 49     | 90 ~ 104    | 55 ~ 65     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 123.0       | 71.5        | 59.2        | 50.4        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 80mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 954                   | 12591                 | 12592                 | 12593                 | 12594                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 14                    | 15                    | 15                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 8                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 44.0<br>(41.0 ~ 47.0) | 33.0<br>(31.0 ~ 35.0) | 55.0<br>(53.0 ~ 57.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.0                   | 1.4                   | 5.6                   | 5.6                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 176.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 216.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 231.0 | 146.0 | 135.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 231.0 | 146.0 | 135.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 11.0  | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.1 ~ 2.1   | 1.8 ~ 3.0   | 5.1 ~ 6.1   | 5.1 ~ 6.1   |  |  |  |
| Average Voltage Gap  | V   |  | 34 ~ 54     | 35 ~ 45     | 84 ~ 96     | 50 ~ 59     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 96.0        | 57.6        | 49.2        | 42.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 90mm               | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 955                   | 12601                 | 12602                 | 12603                 | 12604                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 14                    | 16                    | 16                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 8                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(42.0 ~ 48.0) | 31.0<br>(29.0 ~ 33.0) | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(33.0 ~ 37.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.8                   | 1.3                   | 5.5                   | 5.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 178.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 219.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 232.0 | 144.0 | 133.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 234.0 | 146.0 | 135.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 88.0  | 11.0  | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.7   | 1.8 ~ 2.8   | 5.0 ~ 6.0   | 5.0 ~ 6.0   |  |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 55     | 33 ~ 43     | 76 ~ 85     | 47 ~ 55     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 75.0        | 48.6        | 42.4        | 37.5        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 100mm              | STDD1   | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 955                   | 12611                 | 12612                 | 12613                 | 12614                 |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 14                    | 16                    | 16                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 14.0                  | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 8                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 9                     | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 46.0<br>(43.0 ~ 49.0) | 30.0<br>(28.0 ~ 32.0) | 45.0<br>(43.0 ~ 47.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.6                   | 1.2                   | 5.4                   | 5.4                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 181.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 221.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 233.0 | 143.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 236.0 | 146.0 | 135.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 11.0  | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 0.5 ~ 1.5   | 1.7 ~ 2.7   | 4.9 ~ 5.9   | 4.9 ~ 5.9   |  |  |  |
| Average Voltage Gap  | V   |  | 36 ~ 57     | 32 ~ 42     | 67 ~ 73     | 45 ~ 51     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 60.0        | 41.3        | 36.6        | 32.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   | 2.2 ~ 2.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 | 0.27 ~ 0.45 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.25BS            | STEEL         | STDPO1 |

Thickness 5 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0  |        |       |       |       |       |       |     |     |           |
| 1                 | 17201           | RH | 8.8  | 156.0  | 197.0 | 245.0 | 259.0 | 264.0 | 266.0 |     |     | 0.0       |
| 2                 | 17202           | KH | 9.0  | -      | 126.0 | 174.0 | 188.0 | 193.0 | 195.0 |     |     | 71.0      |
| 3                 | 17203           | KL | 7.0  | -      | -     | 126.0 | 140.0 | 145.0 | 147.0 |     |     | 48.0      |
| 4                 | 17204           | LC | 14.0 | -      | -     | -     | 128.0 | 133.0 | 135.0 |     |     | 12.0      |
| 5                 | 17205           | LC | 12.0 | -      | -     | -     | -     | 131.0 | 133.0 |     |     | 2.0       |
| 6                 | 17206           | LC | 12.0 | -      | -     | -     | -     | -     | 132.0 |     |     | 1.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra   | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 10 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0  |        |       |       |       |       |       |     |     |           |
| 1                 | 17211           | RH | 5.8  | 158.0  | 197.0 | 235.0 | 241.0 | 246.0 | 248.0 |     |     | 0.0       |
| 2                 | 17212           | KH | 9.0  | -      | 126.0 | 164.0 | 170.0 | 175.0 | 177.0 |     |     | 71.0      |
| 3                 | 17213           | KL | 7.0  | -      | -     | 126.0 | 132.0 | 137.0 | 139.0 |     |     | 38.0      |
| 4                 | 17214           | LC | 14.0 | -      | -     | -     | 126.0 | 131.0 | 133.0 |     |     | 6.0       |
| 5                 | 17215           | LC | 12.0 | -      | -     | -     | -     | 129.0 | 131.0 |     |     | 2.0       |
| 6                 | 17216           | LC | 12.0 | -      | -     | -     | -     | -     | 130.0 |     |     | 1.0       |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz   | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra   | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 17221           | RH | 3.6 | 166.0  | 206.0 | 230.0 | 246.0 | 251.0 | 254.0 |     |     | 0.0       |
| 2                 | 17222           | RH | 4.5 | -      | 126.0 | 150.0 | 166.0 | 171.0 | 174.0 |     |     | 80.0      |
| 3                 | 17223           | RH | 4.5 | -      | -     | 128.0 | 144.0 | 149.0 | 152.0 |     |     | 22.0      |
| 4                 | 17224           | LC | 7.0 | -      | -     | -     | 129.0 | 134.0 | 137.0 |     |     | 15.0      |
| 5                 | 17225           | LC | 7.0 | -      | -     | -     | -     | 132.0 | 135.0 |     |     | 2.0       |
| 6                 | 17226           | LC | 6.0 | -      | -     | -     | -     | -     | 133.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.25BS            | STEEL         | STDPO1 |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 17231           | RH | 2.9 | 169.0  | 208.0 | 233.0 | 249.0 | 254.0 | 257.0 |     |     | 0.0       |
| 2                 | 17232           | RH | 3.4 | -      | 128.0 | 153.0 | 169.0 | 174.0 | 177.0 |     |     | 80.0      |
| 3                 | 17233           | RH | 4.0 | -      | -     | 128.0 | 144.0 | 149.0 | 152.0 |     |     | 25.0      |
| 4                 | 17234           | LC | 7.0 | -      | -     | -     | 129.0 | 134.0 | 137.0 |     |     | 15.0      |
| 5                 | 17235           | LC | 7.0 | -      | -     | -     | -     | 132.0 | 135.0 |     |     | 2.0       |
| 6                 | 17236           | LC | 5.8 | -      | -     | -     | -     | -     | 133.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 17241           | RH | 2.2 | 172.0  | 211.0 | 236.0 | 251.0 | 257.0 | 259.0 |     |     | 0.0       |
| 2                 | 17242           | RH | 2.3 | -      | 131.0 | 156.0 | 171.0 | 177.0 | 179.0 |     |     | 80.0      |
| 3                 | 17243           | RH | 3.5 | -      | -     | 128.0 | 143.0 | 149.0 | 151.0 |     |     | 28.0      |
| 4                 | 17244           | LC | 7.0 | -      | -     | -     | 128.0 | 134.0 | 136.0 |     |     | 15.0      |
| 5                 | 17245           | LC | 7.0 | -      | -     | -     | -     | 132.0 | 134.0 |     |     | 2.0       |
| 6                 | 17246           | LC | 5.5 | -      | -     | -     | -     | -     | 132.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 953             | RH | 0.7 |        |       |       |       |       |       |     |     |           |
| 1                 | 17251           | RH | 1.6 | 175.0  | 211.0 | 237.0 | 251.0 | 256.0 | 259.0 |     |     | 0.0       |
| 2                 | 17252           | RH | 2.3 | -      | 131.0 | 157.0 | 171.0 | 176.0 | 179.0 |     |     | 80.0      |
| 3                 | 17253           | RH | 3.5 | -      | -     | 130.0 | 144.0 | 149.0 | 152.0 |     |     | 27.0      |
| 4                 | 17254           | LC | 7.0 | -      | -     | -     | 129.0 | 134.0 | 137.0 |     |     | 15.0      |
| 5                 | 17255           | LC | 7.0 | -      | -     | -     | -     | 132.0 | 135.0 |     |     | 2.0       |
| 6                 | 17256           | LC | 5.3 | -      | -     | -     | -     | -     | 133.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.25BS            | STEEL         | STDPO1 |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 953             | RH | 0.7 |        |       |       |       |       |       |     |     |           |
| 1                 | 17261           | RH | 1.0 | 178.0  | 210.0 | 236.0 | 249.0 | 253.0 | 256.0 |     |     | 0.0       |
| 2                 | 17262           | RH | 2.3 | -      | 130.0 | 156.0 | 169.0 | 173.0 | 176.0 |     |     | 80.0      |
| 3                 | 17263           | RH | 3.5 | -      | -     | 131.0 | 144.0 | 148.0 | 151.0 |     |     | 25.0      |
| 4                 | 17264           | LC | 7.0 | -      | -     | -     | 130.0 | 134.0 | 137.0 |     |     | 14.0      |
| 5                 | 17265           | LC | 7.0 | -      | -     | -     | -     | 132.0 | 135.0 |     |     | 2.0       |
| 6                 | 17266           | LC | 5.0 | -      | -     | -     | -     | -     | 133.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |       |       |     |     |           |
| 1                 | 17271           | RH | 1.0 | 181.0  | 218.0 | 238.0 | 251.0 | 255.0 | 257.0 |     |     | 0.0       |
| 2                 | 17272           | RH | 2.3 | -      | 135.0 | 155.0 | 168.0 | 172.0 | 174.0 |     |     | 83.0      |
| 3                 | 17273           | RH | 3.5 | -      | -     | 131.0 | 144.0 | 148.0 | 150.0 |     |     | 24.0      |
| 4                 | 17274           | LC | 7.0 | -      | -     | -     | 130.0 | 134.0 | 136.0 |     |     | 14.0      |
| 5                 | 17275           | LC | 6.8 | -      | -     | -     | -     | 132.0 | 134.0 |     |     | 2.0       |
| 6                 | 17276           | LC | 5.0 | -      | -     | -     | -     | -     | 132.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |       |       |     |     |           |
| 1                 | 17281           | RH | 1.0 | 183.0  | 224.0 | 237.0 | 249.0 | 254.0 | 255.0 |     |     | 0.0       |
| 2                 | 17282           | RH | 2.3 | -      | 139.0 | 152.0 | 164.0 | 169.0 | 170.0 |     |     | 85.0      |
| 3                 | 17283           | RH | 3.5 | -      | -     | 130.0 | 142.0 | 147.0 | 148.0 |     |     | 22.0      |
| 4                 | 17284           | LC | 7.0 | -      | -     | -     | 129.0 | 134.0 | 135.0 |     |     | 13.0      |
| 5                 | 17285           | LC | 6.5 | -      | -     | -     | -     | 132.0 | 133.0 |     |     | 2.0       |
| 6                 | 17286           | LC | 5.0 | -      | -     | -     | -     | -     | 131.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.25BS            | STEEL         | STDPO1 |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |       |       |     |     |           |
| 1                 | 17291           | RH | 0.8 | 185.0  | 220.0 | 239.0 | 252.0 | 254.0 | 259.0 |     |     | 0.0       |
| 2                 | 17292           | RH | 2.7 | -      | 135.0 | 154.0 | 167.0 | 169.0 | 174.0 |     |     | 85.0      |
| 3                 | 17293           | RH | 3.5 | -      | -     | 132.0 | 145.0 | 147.0 | 152.0 |     |     | 22.0      |
| 4                 | 17294           | LC | 6.3 | -      | -     | -     | 132.0 | 134.0 | 139.0 |     |     | 13.0      |
| 5                 | 17295           | LC | 6.5 | -      | -     | -     | -     | 132.0 | 137.0 |     |     | 2.0       |
| 6                 | 17296           | LC | 5.0 | -      | -     | -     | -     | -     | 135.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |       |       |     |     |           |
| 1                 | 17301           | RH | 0.6 | 187.0  | 216.0 | 240.0 | 254.0 | 258.0 | 261.0 |     |     | 0.0       |
| 2                 | 17302           | RH | 3.0 | -      | 131.0 | 155.0 | 169.0 | 173.0 | 176.0 |     |     | 85.0      |
| 3                 | 17303           | RH | 3.5 | -      | -     | 133.0 | 147.0 | 151.0 | 154.0 |     |     | 22.0      |
| 4                 | 17304           | LC | 5.5 | -      | -     | -     | 135.0 | 139.0 | 142.0 |     |     | 12.0      |
| 5                 | 17305           | LC | 6.5 | -      | -     | -     | -     | 137.0 | 140.0 |     |     | 2.0       |
| 6                 | 17306           | LC | 5.0 | -      | -     | -     | -     | -     | 138.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 125 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |       |       |     |     |           |
| 1                 | 17311           | RH | 0.5 | 189.0  | 220.0 | 248.0 | 263.0 | 268.0 | 269.0 |     |     | 0.0       |
| 2                 | 17312           | RH | 3.3 | -      | 132.0 | 160.0 | 175.0 | 180.0 | 181.0 |     |     | 88.0      |
| 3                 | 17313           | RH | 3.3 | -      | -     | 135.0 | 150.0 | 155.0 | 156.0 |     |     | 25.0      |
| 4                 | 17314           | LC | 5.3 | -      | -     | -     | 135.0 | 140.0 | 141.0 |     |     | 15.0      |
| 5                 | 17315           | LC | 5.8 | -      | -     | -     | -     | 138.0 | 139.0 |     |     | 2.0       |
| 6                 | 17316           | LC | 5.0 | -      | -     | -     | -     | -     | 138.0 |     |     | 1.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 5.0   | 2.5   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.70  | 0.30  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.25BS            | STEEL         | STDPO1 |

Thickness 150 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |       |       |     |     |           |
| 1                 | 17321           | RH | 0.4 | 191.0  | 222.0 | 254.0 | 271.0 | 275.0 | 275.0 |     |     | 0.0       |
| 2                 | 17322           | RH | 3.5 | -      | 132.0 | 164.0 | 181.0 | 185.0 | 185.0 |     |     | 90.0      |
| 3                 | 17323           | RH | 3.0 | -      | -     | 136.0 | 153.0 | 157.0 | 157.0 |     |     | 28.0      |
| 4                 | 17324           | LC | 5.0 | -      | -     | -     | 135.0 | 139.0 | 139.0 |     |     | 18.0      |
| 5                 | 17325           | LC | 5.0 | -      | -     | -     | -     | 138.0 | 138.0 |     |     | 1.0       |
| 6                 | 17326           | LC | 5.0 | -      | -     | -     | -     | -     | 137.0 |     |     | 1.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 6.0   | 5.0   | 2.5   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.80  | 0.70  | 0.30  |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.25BS           | STEEL         | 5mm                | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                   | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 951                   | 17201                 | 17202                 | 17203                 | 17204                 | 17205                   | 17206                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | KH                    | KL                    | LC                    | LC                      | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                      | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 7                     | 5                     | 6                     | 9                       | 9                     |       |       |
| Power Setting      | IP  | 7.0                   | 8.0                   | 5.0                   | 5.0                   | 2.5                   | 2.5                     | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 8                     |                       |                         |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 1                     | 1                     | 8                     | 2                       | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 2                     | 2                     | 2                     | 1                       | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 9                     | 12                    | 9                     | 9                     | 8                       | 7                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                       | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                       | 1                     |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 68.0<br>(65.0 ~ 71.0) | 90.0<br>(88.0 ~ 92.0) | 90.0<br>(88.0 ~ 92.0) | 80.0<br>(78.0 ~ 82.0) | 100.0<br>(98.0 ~ 102.0) | 90.0<br>(88.0 ~ 92.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                      | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                     | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                      | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                      | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                      | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                      | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                       | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                      | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                       | 0                     |       |       |
| Feedrate Address   | FA  | 2.0                   | 8.8                   | 9.0                   | 7.0                   | 14.0                  | 12.0                    | 12.0                  |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 156.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 197.0 | 126.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 245.0 | 174.0 | 126.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 259.0 | 188.0 | 140.0 | 128.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 264.0 | 193.0 | 145.0 | 133.0 | 131.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 266.0 | 195.0 | 147.0 | 135.0 | 133.0 | 132.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 71.0  | 48.0  | 12.0  | 2.0   | 1.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 4.5 ~ 5.7   | 17.2 ~ 21.1 | 11.5 ~ 14.1 | 12.1 ~ 13.4 | 10.7 ~ 11.8 | 10.5 ~ 11.6 |  |
| Average Voltage Gap  | V   |  | 58 ~ 79     | 97 ~ 110    | 87 ~ 97     | 95 ~ 107    | 121 ~ 135   | 117 ~ 131   |  |
| Avg. Linear Feedrate | ALF |  | 306.0       | 241.6       | 183.8       | 148.2       | 121.5       | 102.7       |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.25BS           | STEEL         | 10mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                   | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-------------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 951                   | 17211                 | 17212                   | 17213                 | 17214                 | 17215                 | 17216                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | KH                      | KL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                      | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 8                       | 6                     | 8                     | 10                    | 10                    |       |       |
| Power Setting      | IP  | 7.0                   | 8.0                   | 5.0                     | 5.0                   | 2.5                   | 2.0                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                      | 9                     |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 1                       | 1                     | 8                     | 8                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 2                       | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 9                     | 12                      | 9                     | 9                     | 8                     | 7                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                       | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                       | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 100.0<br>(98.0 ~ 102.0) | 90.0<br>(88.0 ~ 92.0) | 90.0<br>(88.0 ~ 92.0) | 85.0<br>(83.0 ~ 87.0) | 80.0<br>(78.0 ~ 82.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                     | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                     | OFF                   | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                      | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                      | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                      | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                      | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                       | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                      | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                       | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 2.0                   | 5.8                   | 9.0                     | 7.0                   | 14.0                  | 12.0                  | 12.0                  |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                     | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                     | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 158.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 197.0 | 126.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 235.0 | 164.0 | 126.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 241.0 | 170.0 | 132.0 | 126.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 246.0 | 175.0 | 137.0 | 131.0 | 129.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 248.0 | 177.0 | 139.0 | 133.0 | 131.0 | 130.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 71.0  | 38.0  | 6.0   | 2.0   | 1.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 4.1 ~ 5.0   | 15.0 ~ 18.3 | 11.5 ~ 12.9 | 12.3 ~ 13.6 | 10.5 ~ 11.6 | 10.6 ~ 11.7 |  |
| Average Voltage Gap  | V   |  | 37 ~ 51     | 100 ~ 114   | 87 ~ 97     | 98 ~ 111    | 94 ~ 109    | 98 ~ 112    |  |
| Avg. Linear Feedrate | ALF |  | 273.0       | 214.4       | 165.8       | 136.7       | 113.3       | 96.9        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.25BS           | STEEL         | 20mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 951                   | 17221                 | 17222                 | 17223                 | 17224                 | 17225                 | 17226                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 9                     | 11                    | 11                    |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 5.0                   | 2.5                   | 2.0                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 6                     | 6                     | 8                     | 8                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 9                     | 6                     | 6                     | 9                     | 8                     | 7                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 78.0<br>(76.0 ~ 80.0) | 64.0<br>(62.0 ~ 66.0) | 90.0<br>(88.0 ~ 92.0) | 75.0<br>(73.0 ~ 77.0) | 65.0<br>(63.0 ~ 67.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 2.0                   | 3.6                   | 4.5                   | 4.5                   | 7.0                   | 7.0                   | 6.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 166.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 206.0 | 126.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 230.0 | 150.0 | 128.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 246.0 | 166.0 | 144.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 251.0 | 171.0 | 149.0 | 134.0 | 132.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 254.0 | 174.0 | 152.0 | 137.0 | 135.0 | 133.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 80.0  | 22.0  | 15.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 2.8 ~ 3.4   | 8.8 ~ 10.8  | 8.9 ~ 10.8  | 6.2 ~ 6.9   | 6.1 ~ 6.7   | 5.4 ~ 6.0   |  |
| Average Voltage Gap  | V   |  | 37 ~ 63     | 74 ~ 100    | 61 ~ 71     | 98 ~ 111    | 83 ~ 98     | 83 ~ 99     |  |
| Avg. Linear Feedrate | ALF |  | 186.0       | 141.3       | 114.0       | 88.4        | 71.9        | 59.4        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.25BS           | STEEL         | 30mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 952                   | 17231                 | 17232                 | 17233                 | 17234                 | 17235                 | 17236                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 11                    | 10                    | 11                    |       |       |
| Power Setting      | IP  | 8.0                   | 9.0                   | 6.0                   | 5.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 6                     | 6                     | 8                     | 8                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 7                     | 6                     | 6                     | 9                     | 8                     | 7                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(47.0 ~ 53.0) | 78.0<br>(76.0 ~ 80.0) | 62.0<br>(60.0 ~ 64.0) | 88.0<br>(86.0 ~ 90.0) | 65.0<br>(63.0 ~ 67.0) | 60.0<br>(58.0 ~ 62.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.9                   | 3.4                   | 4.0                   | 7.0                   | 7.0                   | 5.8                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 169.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 208.0 | 128.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 233.0 | 153.0 | 128.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 249.0 | 169.0 | 144.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 254.0 | 174.0 | 149.0 | 134.0 | 132.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 257.0 | 177.0 | 152.0 | 137.0 | 135.0 | 133.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 80.0  | 25.0  | 15.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 2.1 ~ 2.6   | 6.6 ~ 8.1   | 7.3 ~ 8.9   | 6.3 ~ 7.0   | 6.1 ~ 6.8   | 5.2 ~ 5.8   |  |
| Average Voltage Gap  | V   |  | 40 ~ 60     | 75 ~ 99     | 59 ~ 69     | 97 ~ 111    | 74 ~ 88     | 77 ~ 92     |  |
| Avg. Linear Feedrate | ALF |  | 141.0       | 106.8       | 87.6        | 71.8        | 60.6        | 51.2        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.25BS           | STEEL         | 40mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 952                   | 17241                 | 17242                 | 17243                 | 17244                 | 17245                 | 17246                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 12                    | 9                     | 11                    |       |       |
| Power Setting      | IP  | 8.0                   | 9.0                   | 6.0                   | 5.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 6                     | 6                     | 8                     | 8                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 6                     | 6                     | 9                     | 8                     | 7                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(47.0 ~ 53.0) | 78.0<br>(76.0 ~ 80.0) | 60.0<br>(58.0 ~ 62.0) | 85.0<br>(83.0 ~ 87.0) | 54.0<br>(52.0 ~ 56.0) | 55.0<br>(53.0 ~ 57.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.2                   | 2.3                   | 3.5                   | 7.0                   | 7.0                   | 5.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 172.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 211.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 236.0 | 156.0 | 128.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 251.0 | 171.0 | 143.0 | 128.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 257.0 | 177.0 | 149.0 | 134.0 | 132.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 259.0 | 179.0 | 151.0 | 136.0 | 134.0 | 132.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 80.0  | 28.0  | 15.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.5 ~ 1.9   | 4.4 ~ 5.4   | 5.7 ~ 7.0   | 6.4 ~ 7.0   | 6.2 ~ 6.8   | 5.0 ~ 5.5   |  |
| Average Voltage Gap  | V   |  | 40 ~ 62     | 76 ~ 98     | 57 ~ 67     | 96 ~ 110    | 64 ~ 77     | 71 ~ 84     |  |
| Avg. Linear Feedrate | ALF |  | 102.0       | 75.7        | 63.2        | 54.6        | 47.9        | 41.6        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.25BS           | STEEL         | 50mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 953                   | 17251                 | 17252                 | 17253                 | 17254                 | 17255                 | 17256                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 12                    | 10                    | 11                    |       |       |
| Power Setting      | IP  | 8.0                   | 9.0                   | 6.0                   | 5.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 6                     | 6                     | 8                     | 8                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 6                     | 6                     | 9                     | 8                     | 7                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(47.0 ~ 53.0) | 73.0<br>(71.0 ~ 75.0) | 57.0<br>(55.0 ~ 59.0) | 79.0<br>(77.0 ~ 81.0) | 51.0<br>(49.0 ~ 53.0) | 50.0<br>(48.0 ~ 52.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.6                   | 2.3                   | 3.5                   | 7.0                   | 7.0                   | 5.3                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 175.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 211.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 237.0 | 157.0 | 130.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 251.0 | 171.0 | 144.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 256.0 | 176.0 | 149.0 | 134.0 | 132.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 259.0 | 179.0 | 152.0 | 137.0 | 135.0 | 133.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 80.0  | 27.0  | 15.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.3 ~ 1.5   | 4.1 ~ 5.0   | 5.0 ~ 6.0   | 6.3 ~ 7.0   | 6.2 ~ 6.8   | 5.0 ~ 5.5   |  |
| Average Voltage Gap  | V   |  | 37 ~ 62     | 69 ~ 93     | 54 ~ 64     | 89 ~ 103    | 60 ~ 72     | 66 ~ 79     |  |
| Avg. Linear Feedrate | ALF |  | 84.0        | 64.2        | 53.8        | 47.4        | 42.3        | 37.3        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.25BS           | STEEL         | 60mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 953                   | 17261                 | 17262                 | 17263                 | 17264                 | 17265                 | 17266                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 12                    | 10                    | 12                    |       |       |
| Power Setting      | IP  | 8.0                   | 10.0                  | 6.0                   | 5.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 6                     | 6                     | 8                     | 8                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 6                     | 6                     | 9                     | 8                     | 7                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(47.0 ~ 53.0) | 68.0<br>(66.0 ~ 70.0) | 54.0<br>(52.0 ~ 56.0) | 72.0<br>(70.0 ~ 74.0) | 48.0<br>(46.0 ~ 50.0) | 45.0<br>(43.0 ~ 47.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.0                   | 2.3                   | 3.5                   | 7.0                   | 7.0                   | 5.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 178.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 210.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 236.0 | 156.0 | 131.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 249.0 | 169.0 | 144.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 253.0 | 173.0 | 148.0 | 134.0 | 132.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 256.0 | 176.0 | 151.0 | 137.0 | 135.0 | 133.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 80.0  | 25.0  | 14.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.1 ~ 1.4   | 3.8 ~ 4.7   | 4.2 ~ 5.1   | 6.3 ~ 7.0   | 6.2 ~ 6.8   | 5.0 ~ 5.5   |  |
| Average Voltage Gap  | V   |  | 37 ~ 62     | 51 ~ 87     | 51 ~ 61     | 81 ~ 95     | 55 ~ 67     | 60 ~ 74     |  |
| Avg. Linear Feedrate | ALF |  | 75.0        | 58.0        | 48.0        | 42.8        | 38.6        | 34.4        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.25BS           | STEEL         | 70mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 954                   | 17271                 | 17272                 | 17273                 | 17274                 | 17275                 | 17276                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 7                     | 12                    | 11                    | 13                    |       |       |
| Power Setting      | IP  | 8.0                   | 10.0                  | 6.0                   | 5.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 7                     | 6                     | 7                     | 7                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 7                     | 6                     | 8                     | 8                     | 7                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(47.0 ~ 53.0) | 63.0<br>(61.0 ~ 65.0) | 51.0<br>(49.0 ~ 53.0) | 73.0<br>(71.0 ~ 75.0) | 49.0<br>(47.0 ~ 51.0) | 44.0<br>(42.0 ~ 46.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.0                   | 2.3                   | 3.5                   | 7.0                   | 6.8                   | 5.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 181.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 218.0 | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 238.0 | 155.0 | 131.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 251.0 | 168.0 | 144.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 255.0 | 172.0 | 148.0 | 134.0 | 132.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 257.0 | 174.0 | 150.0 | 136.0 | 134.0 | 132.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 83.0  | 24.0  | 14.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.0 ~ 1.2   | 3.7 ~ 4.6   | 4.3 ~ 5.3   | 6.3 ~ 7.0   | 6.4 ~ 6.8   | 4.7 ~ 5.3   |  |
| Average Voltage Gap  | V   |  | 37 ~ 62     | 57 ~ 81     | 48 ~ 58     | 82 ~ 96     | 53 ~ 65     | 56 ~ 69     |  |
| Avg. Linear Feedrate | ALF |  | 66.0        | 52.2        | 44.2        | 39.8        | 36.1        | 32.3        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.25BS           | STEEL         | 80mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 954                   | 17281                 | 17282                 | 17283                 | 17284                 | 17285                 | 17286                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 8                     | 12                    | 12                    | 14                    |       |       |
| Power Setting      | IP  | 8.0                   | 10.0                  | 7.0                   | 5.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 8                     | 6                     | 7                     | 6                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 4                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 6                     | 8                     | 6                     | 8                     | 8                     | 7                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(47.0 ~ 53.0) | 58.0<br>(56.0 ~ 60.0) | 48.0<br>(46.0 ~ 50.0) | 74.0<br>(72.0 ~ 76.0) | 50.0<br>(48.0 ~ 52.0) | 42.0<br>(40.0 ~ 44.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.0                   | 2.3                   | 3.5                   | 7.0                   | 6.5                   | 5.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 183.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 224.0 | 139.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 237.0 | 152.0 | 130.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 249.0 | 164.0 | 142.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 254.0 | 169.0 | 147.0 | 134.0 | 132.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 255.0 | 170.0 | 148.0 | 135.0 | 133.0 | 131.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 85.0  | 22.0  | 13.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.0   | 3.6 ~ 4.5   | 4.5 ~ 5.5   | 6.4 ~ 7.0   | 5.4 ~ 6.0   | 4.4 ~ 4.9   |  |
| Average Voltage Gap  | V   |  | 37 ~ 61     | 52 ~ 75     | 45 ~ 55     | 83 ~ 96     | 50 ~ 62     | 52 ~ 64     |  |
| Avg. Linear Feedrate | ALF |  | 54.0        | 44.2        | 38.5        | 35.1        | 31.9        | 28.6        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.25BS           | STEEL         | 90mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 955                   | 17291                 | 17292                 | 17293                 | 17294                 | 17295                 | 17296                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 11                    | 10                    | 12                    | 13                    | 14                    |       |       |
| Power Setting      | IP  | 8.0                   | 10.0                  | 7.0                   | 5.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 8                     | 6                     | 6                     | 5                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 4                     | 2                     | 2                     | 2                     | 1                     |       |       |
| Stabilizer B       | SB  | 6                     | 7                     | 8                     | 6                     | 8                     | 7                     | 6                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(47.0 ~ 53.0) | 59.0<br>(57.0 ~ 61.0) | 47.0<br>(45.0 ~ 49.0) | 75.0<br>(73.0 ~ 77.0) | 53.0<br>(51.0 ~ 55.0) | 38.0<br>(36.0 ~ 40.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.8                   | 2.7                   | 3.5                   | 6.3                   | 6.5                   | 5.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 185.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 220.0 | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 239.0 | 154.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 252.0 | 167.0 | 145.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 254.0 | 169.0 | 147.0 | 134.0 | 132.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 259.0 | 174.0 | 152.0 | 139.0 | 137.0 | 135.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 85.0  | 22.0  | 13.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.7 ~ 0.9   | 3.5 ~ 4.4   | 4.5 ~ 5.5   | 6.1 ~ 6.6   | 6.1 ~ 6.6   | 4.5 ~ 5.0   |  |
| Average Voltage Gap  | V   |  | 32 ~ 55     | 50 ~ 74     | 44 ~ 54     | 76 ~ 89     | 50 ~ 62     | 46 ~ 58     |  |
| Avg. Linear Feedrate | ALF |  | 48.0        | 39.9        | 35.2        | 32.2        | 29.7        | 26.9        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.25BS           | STEEL         | 100mm              | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 955                   | 17301                 | 17302                 | 17303                 | 17304                 | 17305                 | 17306                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 12                    | 12                    | 14                    | 14                    |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 7.0                   | 5.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 5                     | 8                     | 6                     | 6                     | 4                     | 1                     |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 4                     | 2                     | 2                     | 2                     | 1                     |       |       |
| Stabilizer B       | SB  | 6                     | 8                     | 8                     | 6                     | 8                     | 7                     | 4                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(47.0 ~ 53.0) | 60.0<br>(58.0 ~ 62.0) | 45.0<br>(43.0 ~ 47.0) | 76.0<br>(74.0 ~ 78.0) | 56.0<br>(54.0 ~ 58.0) | 34.0<br>(32.0 ~ 36.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.6                   | 3.0                   | 3.5                   | 5.5                   | 6.5                   | 5.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 187.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 216.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 240.0 | 155.0 | 133.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 254.0 | 169.0 | 147.0 | 135.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 258.0 | 173.0 | 151.0 | 139.0 | 137.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 261.0 | 176.0 | 154.0 | 142.0 | 140.0 | 138.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 85.0  | 22.0  | 12.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.6 ~ 0.7   | 3.5 ~ 4.3   | 4.5 ~ 5.5   | 5.1 ~ 5.7   | 5.8 ~ 6.4   | 4.6 ~ 5.1   |  |
| Average Voltage Gap  | V   |  | 32 ~ 49     | 48 ~ 72     | 42 ~ 52     | 68 ~ 81     | 49 ~ 62     | 39 ~ 51     |  |
| Avg. Linear Feedrate | ALF |  | 39.0        | 33.4        | 30.1        | 27.5        | 25.6        | 23.5        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.25BS           | STEEL         | 125mm              | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 955                   | 17311                 | 17312                 | 17313                 | 17314                 | 17315                 | 17316                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                    | 14                    | 15                    | 13                    |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 7.0                   | 5.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 5                     | 7                     | 5                     | 6                     | 3                     | 1                     |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 4                     | 2                     | 2                     | 2                     | 1                     |       |       |
| Stabilizer B       | SB  | 6                     | 8                     | 7                     | 5                     | 8                     | 6                     | 4                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 51.0<br>(48.0 ~ 54.0) | 57.0<br>(55.0 ~ 59.0) | 49.0<br>(47.0 ~ 51.0) | 71.0<br>(69.0 ~ 73.0) | 49.0<br>(47.0 ~ 51.0) | 37.0<br>(35.0 ~ 39.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.5                   | 3.3                   | 3.3                   | 5.3                   | 5.8                   | 5.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 189.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 220.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 248.0 | 160.0 | 135.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 263.0 | 175.0 | 150.0 | 135.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 268.0 | 180.0 | 155.0 | 140.0 | 138.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 269.0 | 181.0 | 156.0 | 141.0 | 139.0 | 138.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 88.0  | 25.0  | 15.0  | 2.0   | 1.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.5 ~ 0.6   | 3.2 ~ 4.1   | 4.0 ~ 5.0   | 4.8 ~ 5.4   | 5.4 ~ 5.8   | 4.6 ~ 5.1   |  |
| Average Voltage Gap  | V   |  | 35 ~ 56     | 45 ~ 70     | 46 ~ 56     | 64 ~ 77     | 44 ~ 57     | 39 ~ 50     |  |
| Avg. Linear Feedrate | ALF |  | 33.0        | 28.7        | 25.9        | 23.9        | 22.3        | 20.7        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 4.5 ~ 5.5   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.63 ~ 1.05 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.25BS           | STEEL         | 150mm              | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 955                   | 17321                 | 17322                 | 17323                 | 17324                 | 17325                 | 17326                 |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 10                    | 16                    | 16                    | 12                    |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 7.0                   | 6.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 6                     | 6                     | 5                     | 6                     | 2                     | 1                     |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 4                     | 3                     | 2                     | 2                     | 1                     |       |       |
| Stabilizer B       | SB  | 6                     | 9                     | 6                     | 5                     | 8                     | 6                     | 4                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 52.0<br>(49.0 ~ 55.0) | 54.0<br>(52.0 ~ 56.0) | 52.0<br>(50.0 ~ 54.0) | 66.0<br>(64.0 ~ 68.0) | 42.0<br>(40.0 ~ 44.0) | 34.0<br>(32.0 ~ 36.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.4                   | 3.5                   | 3.0                   | 5.0                   | 5.0                   | 5.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 191.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 222.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 254.0 | 164.0 | 136.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 271.0 | 181.0 | 153.0 | 135.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 275.0 | 185.0 | 157.0 | 139.0 | 138.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 275.0 | 185.0 | 157.0 | 139.0 | 138.0 | 137.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 28.0  | 18.0  | 1.0   | 1.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.3 ~ 0.4   | 3.0 ~ 3.8   | 3.5 ~ 4.0   | 4.5 ~ 5.0   | 4.5 ~ 5.0   | 4.6 ~ 5.1   |  |
| Average Voltage Gap  | V   |  | 42 ~ 63     | 42 ~ 68     | 49 ~ 59     | 60 ~ 73     | 36 ~ 51     | 35 ~ 48     |  |
| Avg. Linear Feedrate | ALF |  | 21.0        | 19.0        | 17.6        | 16.5        | 15.6        | 14.8        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 4.5 ~ 5.5   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.63 ~ 1.05 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | ACU   |

Thickness 5 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 2221            | RH | 9.0 | 150.0  | 195.0 | 243.0 | 257.0 | 260.0 | 260.0 |     |     | 0.0       |
| 2                 | 2222            | KH | 9.0 | -      | 129.0 | 177.0 | 191.0 | 194.0 | 194.0 |     |     | 66.0      |
| 3                 | 2223            | KL | 7.0 | -      | -     | 131.0 | 145.0 | 148.0 | 148.0 |     |     | 46.0      |
| 4                 | 2224            | LC | 8.0 | -      | -     | -     | 131.0 | 134.0 | 134.0 |     |     | 14.0      |
| 5                 | 2225            | LC | 8.0 | -      | -     | -     | -     | 132.0 | 132.0 |     |     | 2.0       |
| 6                 | 2226            | LC | 8.0 | -      | -     | -     | -     | -     | 130.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 11.0  | 6.0   | 6.0   | 2.8   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.50  | 0.80  | 0.80  | 0.34  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 2231            | RH | 6.0 | 155.0  | 191.0 | 229.0 | 238.0 | 237.0 | 241.0 |     |     | 0.0       |
| 2                 | 2232            | KH | 9.0 | -      | 130.0 | 168.0 | 177.0 | 176.0 | 180.0 |     |     | 61.0      |
| 3                 | 2233            | KL | 7.0 | -      | -     | 132.0 | 141.0 | 140.0 | 144.0 |     |     | 36.0      |
| 4                 | 2234            | LC | 8.0 | -      | -     | -     | 130.0 | 129.0 | 133.0 |     |     | 11.0      |
| 5                 | 2235            | LC | 8.0 | -      | -     | -     | -     | 127.0 | 131.0 |     |     | 2.0       |
| 6                 | 2236            | LC | 8.0 | -      | -     | -     | -     | -     | 130.0 |     |     | 1.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 11.0  | 6.0   | 6.0   | 2.8   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.50  | 0.80  | 0.80  | 0.34  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 2241            | RH | 3.7 | 153.0  | 195.0 | 220.0 | 234.0 | 236.0 | 236.0 |     |     | 0.0       |
| 2                 | 2242            | RH | 9.0 | -      | 130.0 | 155.0 | 169.0 | 171.0 | 171.0 |     |     | 65.0      |
| 3                 | 2243            | HL | 6.5 | -      | -     | 130.0 | 144.0 | 146.0 | 146.0 |     |     | 25.0      |
| 4                 | 2244            | LC | 7.0 | -      | -     | -     | 134.0 | 136.0 | 136.0 |     |     | 10.0      |
| 5                 | 2245            | LC | 7.0 | -      | -     | -     | -     | 133.0 | 133.0 |     |     | 3.0       |
| 6                 | 2246            | LC | 6.0 | -      | -     | -     | -     | -     | 131.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 11.0  | 6.0   | 6.0   | 2.8   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.50  | 0.80  | 0.80  | 0.34  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | ACU   |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 2251            | RH | 3.0 | 156.0  | 195.0 | 220.0 | 234.0 | 236.0 | 236.0 |     |     | 0.0       |
| 2                 | 2252            | RH | 8.0 | -      | 130.0 | 155.0 | 169.0 | 171.0 | 171.0 |     |     | 65.0      |
| 3                 | 2253            | HL | 6.0 | -      | -     | 130.0 | 144.0 | 146.0 | 146.0 |     |     | 25.0      |
| 4                 | 2254            | LC | 7.0 | -      | -     | -     | 134.0 | 136.0 | 136.0 |     |     | 10.0      |
| 5                 | 2255            | LC | 7.0 | -      | -     | -     | -     | 133.0 | 133.0 |     |     | 3.0       |
| 6                 | 2256            | LC | 5.7 | -      | -     | -     | -     | -     | 131.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 2261            | RH | 2.3 | 159.0  | 195.0 | 220.0 | 233.0 | 235.0 | 236.0 |     |     | 0.0       |
| 2                 | 2262            | RH | 7.0 | -      | 130.0 | 155.0 | 168.0 | 170.0 | 171.0 |     |     | 65.0      |
| 3                 | 2263            | HL | 5.5 | -      | -     | 130.0 | 143.0 | 145.0 | 146.0 |     |     | 25.0      |
| 4                 | 2264            | LC | 7.0 | -      | -     | -     | 133.0 | 135.0 | 136.0 |     |     | 10.0      |
| 5                 | 2265            | LC | 7.0 | -      | -     | -     | -     | 132.0 | 133.0 |     |     | 3.0       |
| 6                 | 2266            | LC | 5.5 | -      | -     | -     | -     | -     | 131.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 953             | RH | 0.7 |        |       |       |       |       |       |       |     |           |
| 1                 | 2271            | RH | 2.0 | 164.0  | 195.0 | 220.0 | 232.0 | 235.0 | 235.0 | 237.0 |     | 0.0       |
| 2                 | 2272            | RH | 6.0 | -      | 130.0 | 155.0 | 167.0 | 170.0 | 170.0 | 172.0 |     | 65.0      |
| 3                 | 2273            | HL | 5.0 | -      | -     | 130.0 | 142.0 | 145.0 | 145.0 | 147.0 |     | 25.0      |
| 4                 | 2274            | LC | 6.0 | -      | -     | -     | 132.0 | 135.0 | 135.0 | 137.0 |     | 10.0      |
| 5                 | 2275            | LC | 6.0 | -      | -     | -     | -     | 132.0 | 132.0 | 134.0 |     | 3.0       |
| 6                 | 2276            | LC | 5.2 | -      | -     | -     | -     | -     | 130.0 | 132.0 |     | 2.0       |
| 7                 | 2277            | LC | 5.0 | -      | -     | -     | -     | -     | -     | 131.0 |     | 1.0       |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 2.0   |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.28  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | ACU   |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 953             | RH | 0.7 |        |       |       |       |       |       |       |     |           |
| 1                 | 2281            | RH | 1.7 | 169.0  | 195.0 | 220.0 | 231.0 | 234.0 | 235.0 | 237.0 |     | 0.0       |
| 2                 | 2282            | RH | 5.0 | -      | 130.0 | 155.0 | 166.0 | 169.0 | 170.0 | 172.0 |     | 65.0      |
| 3                 | 2283            | HL | 4.5 | -      | -     | 130.0 | 141.0 | 144.0 | 145.0 | 147.0 |     | 25.0      |
| 4                 | 2284            | LC | 6.0 | -      | -     | -     | 131.0 | 134.0 | 135.0 | 137.0 |     | 10.0      |
| 5                 | 2285            | LC | 6.0 | -      | -     | -     | -     | 131.0 | 132.0 | 134.0 |     | 3.0       |
| 6                 | 2286            | LC | 6.0 | -      | -     | -     | -     | -     | 130.0 | 132.0 |     | 2.0       |
| 7                 | 2287            | LC | 5.0 | -      | -     | -     | -     | -     | -     | 131.0 |     | 1.0       |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 2.0   |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.28  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |       |       |       |     |           |
| 1                 | 2291            | RH | 1.5 | 169.0  | 197.0 | 223.0 | 234.0 | 236.0 | 238.0 | 239.0 |     | 0.0       |
| 2                 | 2292            | RH | 4.9 | -      | 130.0 | 156.0 | 167.0 | 169.0 | 171.0 | 172.0 |     | 67.0      |
| 3                 | 2293            | HL | 4.0 | -      | -     | 131.0 | 142.0 | 144.0 | 146.0 | 147.0 |     | 25.0      |
| 4                 | 2294            | LC | 5.0 | -      | -     | -     | 131.0 | 133.0 | 135.0 | 136.0 |     | 11.0      |
| 5                 | 2295            | LC | 5.0 | -      | -     | -     | -     | 130.0 | 132.0 | 133.0 |     | 3.0       |
| 6                 | 2296            | LC | 5.0 | -      | -     | -     | -     | -     | 130.0 | 131.0 |     | 2.0       |
| 7                 | 2297            | LC | 5.0 | -      | -     | -     | -     | -     | -     | 130.0 |     | 1.0       |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 2.0   |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.28  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |       |       |       |     |           |
| 1                 | 2301            | RH | 1.3 | 169.0  | 200.0 | 226.0 | 239.0 | 242.0 | 244.0 | 245.0 |     | 0.0       |
| 2                 | 2302            | RH | 4.8 | -      | 130.0 | 156.0 | 169.0 | 172.0 | 174.0 | 175.0 |     | 70.0      |
| 3                 | 2303            | HL | 3.5 | -      | -     | 131.0 | 144.0 | 147.0 | 149.0 | 150.0 |     | 25.0      |
| 4                 | 2304            | LC | 5.0 | -      | -     | -     | 131.0 | 134.0 | 136.0 | 137.0 |     | 13.0      |
| 5                 | 2305            | LC | 5.0 | -      | -     | -     | -     | 130.0 | 132.0 | 133.0 |     | 4.0       |
| 6                 | 2306            | LC | 5.0 | -      | -     | -     | -     | -     | 130.0 | 131.0 |     | 2.0       |
| 7                 | 2307            | LC | 5.0 | -      | -     | -     | -     | -     | -     | 130.0 |     | 1.0       |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 2.0   |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.28  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | ACU   |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |       |       |       |     |           |
| 1                 | 2311            | RH | 1.1 | 170.0  | 197.0 | 225.0 | 239.0 | 243.0 | 244.0 | 245.0 |     | 0.0       |
| 2                 | 2312            | RH | 4.5 | -      | 127.0 | 155.0 | 169.0 | 173.0 | 174.0 | 175.0 |     | 70.0      |
| 3                 | 2313            | HL | 3.4 | -      | -     | 130.0 | 144.0 | 148.0 | 149.0 | 150.0 |     | 25.0      |
| 4                 | 2314            | LC | 5.0 | -      | -     | -     | 131.0 | 135.0 | 136.0 | 137.0 |     | 13.0      |
| 5                 | 2315            | LC | 5.0 | -      | -     | -     | -     | 131.0 | 132.0 | 133.0 |     | 4.0       |
| 6                 | 2316            | LC | 5.0 | -      | -     | -     | -     | -     | 130.0 | 131.0 |     | 2.0       |
| 7                 | 2317            | LC | 5.0 | -      | -     | -     | -     | -     | -     | 130.0 |     | 1.0       |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 2.0   |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.28  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |       |       |       |     |           |
| 1                 | 2321            | RH | 1.0 | 171.0  | 197.0 | 227.0 | 241.0 | 245.0 | 247.0 | 248.0 |     | 0.0       |
| 2                 | 2322            | RH | 4.2 | -      | 127.0 | 157.0 | 171.0 | 175.0 | 177.0 | 178.0 |     | 70.0      |
| 3                 | 2323            | HL | 3.3 | -      | -     | 130.0 | 144.0 | 148.0 | 150.0 | 151.0 |     | 27.0      |
| 4                 | 2324            | LC | 5.0 | -      | -     | -     | 131.0 | 135.0 | 137.0 | 138.0 |     | 13.0      |
| 5                 | 2325            | LC | 5.0 | -      | -     | -     | -     | 131.0 | 133.0 | 134.0 |     | 4.0       |
| 6                 | 2326            | LC | 5.0 | -      | -     | -     | -     | -     | 131.0 | 132.0 |     | 2.0       |
| 7                 | 2327            | LC | 5.0 | -      | -     | -     | -     | -     | -     | 131.0 |     | 1.0       |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 2.0   |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.28  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 125 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |       |       |       |     |           |
| 1                 | 2331            | RH | 0.7 | 177.0  | 204.0 | 235.0 | 248.0 | 252.0 | 253.0 | 255.0 |     | 0.0       |
| 2                 | 2332            | RH | 3.5 | -      | 129.0 | 160.0 | 173.0 | 177.0 | 178.0 | 180.0 |     | 75.0      |
| 3                 | 2333            | HL | 2.5 | -      | -     | 130.0 | 143.0 | 147.0 | 148.0 | 150.0 |     | 30.0      |
| 4                 | 2334            | LC | 5.0 | -      | -     | -     | 131.0 | 135.0 | 136.0 | 138.0 |     | 12.0      |
| 5                 | 2335            | LC | 5.0 | -      | -     | -     | -     | 130.0 | 131.0 | 133.0 |     | 5.0       |
| 6                 | 2336            | LC | 5.0 | -      | -     | -     | -     | -     | 130.0 | 132.0 |     | 1.0       |
| 7                 | 2337            | LC | 5.0 | -      | -     | -     | -     | -     | -     | 131.0 |     | 1.0       |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 2.0   |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.28  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | ACU   |

Thickness 150 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |       |       |       |     |           |
| 1                 | 2341            | RH | 0.5 | 183.0  | 205.0 | 240.0 | 252.0 | 257.0 | 258.0 | 255.0 |     | 0.0       |
| 2                 | 2342            | RH | 3.2 | -      | 130.0 | 165.0 | 177.0 | 182.0 | 183.0 | 180.0 |     | 75.0      |
| 3                 | 2343            | HL | 2.2 | -      | -     | 135.0 | 147.0 | 152.0 | 153.0 | 150.0 |     | 30.0      |
| 4                 | 2344            | LC | 5.0 | -      | -     | -     | 135.0 | 140.0 | 141.0 | 138.0 |     | 12.0      |
| 5                 | 2345            | LC | 5.0 | -      | -     | -     | -     | 135.0 | 136.0 | 133.0 |     | 5.0       |
| 6                 | 2346            | LC | 5.0 | -      | -     | -     | -     | -     | 135.0 | 132.0 |     | 1.0       |
| 7                 | 2347            | LC | 5.0 | -      | -     | -     | -     | -     | -     | 131.0 |     | 1.0       |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 2.0   |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.28  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 175 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |       |       |     |     |           |
| 1                 | 2351            | RH | 0.5 | 183.0  | 205.0 | 240.0 | 250.0 | 255.0 | 257.0 |     |     | 0.0       |
| 2                 | 2352            | RH | 3.0 | -      | 130.0 | 165.0 | 175.0 | 180.0 | 182.0 |     |     | 75.0      |
| 3                 | 2353            | HL | 2.0 | -      | -     | 135.0 | 145.0 | 150.0 | 152.0 |     |     | 30.0      |
| 4                 | 2354            | LC | 5.0 | -      | -     | -     | 135.0 | 140.0 | 142.0 |     |     | 10.0      |
| 5                 | 2355            | LC | 5.0 | -      | -     | -     | -     | 135.0 | 137.0 |     |     | 5.0       |
| 6                 | 2356            | LC | 5.0 | -      | -     | -     | -     | -     | 136.0 |     |     | 1.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 12.0  | 6.0   | 2.5   |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.80  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 200 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |       |       |     |     |           |
| 1                 | 2361            | RH | 0.4 | 183.0  | 206.0 | 240.0 | 247.0 | 250.0 | 251.0 |     |     | 0.0       |
| 2                 | 2362            | RH | 3.0 | -      | 131.0 | 165.0 | 172.0 | 175.0 | 176.0 |     |     | 75.0      |
| 3                 | 2363            | HL | 2.0 | -      | -     | 135.0 | 142.0 | 145.0 | 146.0 |     |     | 30.0      |
| 4                 | 2364            | LC | 5.0 | -      | -     | -     | 132.0 | 135.0 | 136.0 |     |     | 10.0      |
| 5                 | 2365            | LC | 5.0 | -      | -     | -     | -     | 134.0 | 135.0 |     |     | 1.0       |
| 6                 | 2366            | LC | 5.0 | -      | -     | -     | -     | -     | 134.0 |     |     | 1.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 12.0  | 6.0   | 2.5   |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.80  | 0.30  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | ACU   |

Thickness 250 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |       |     |     |     |           |
| 1                 | 2371            | RH | 0.3 | 189.0  | 208.0 | 245.0 | 251.0 | 258.0 |     |     |     | 0.0       |
| 2                 | 2372            | RH | 2.5 | -      | 133.0 | 170.0 | 176.0 | 183.0 |     |     |     | 75.0      |
| 3                 | 2373            | HL | 1.5 | -      | -     | 140.0 | 146.0 | 153.0 |     |     |     | 30.0      |
| 4                 | 2374            | LC | 4.0 | -      | -     | -     | 136.0 | 143.0 |     |     |     | 10.0      |
| 5                 | 2375            | LC | 4.0 | -      | -     | -     | -     | 142.0 |     |     |     | 1.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 12.0  | 6.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.80  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 300 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |       |     |     |     |           |
| 1                 | 2381            | RH | 0.2 | 189.0  | 210.0 | 239.0 | 251.0 | 254.0 |     |     |     | 0.0       |
| 2                 | 2382            | RH | 2.0 | -      | 135.0 | 164.0 | 176.0 | 179.0 |     |     |     | 75.0      |
| 3                 | 2383            | HL | 1.5 | -      | -     | 134.0 | 146.0 | 149.0 |     |     |     | 30.0      |
| 4                 | 2384            | LC | 4.0 | -      | -     | -     | 136.0 | 139.0 |     |     |     | 10.0      |
| 5                 | 2385            | LC | 4.0 | -      | -     | -     | -     | 134.0 |     |     |     | 5.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 12.0  | 10.0  |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.60  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 5mm                | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 951                   | 2221                  | 2222                  | 2223                  | 2224                  | 2225                  | 2226                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | KH                    | KL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 7                     | 5                     | 8                     | 8                     | 6                     |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 5.0                   | 5.0                   | 2.0                   | 2.0                   | 1.5                   |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 8                     |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 1                     | 1                     | 8                     | 8                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 2                     | 2                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 11                    | 12                    | 9                     | 8                     | 8                     | 4                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 90.0<br>(88.0 ~ 92.0) | 85.0<br>(83.0 ~ 87.0) | 90.0<br>(88.0 ~ 92.0) | 90.0<br>(88.0 ~ 92.0) | 90.0<br>(88.0 ~ 92.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 12                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 2.0                   | 9.0                   | 9.0                   | 7.0                   | 8.0                   | 8.0                   | 8.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 150.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 195.0 | 129.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 243.0 | 177.0 | 131.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 257.0 | 191.0 | 145.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 260.0 | 194.0 | 148.0 | 134.0 | 132.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 260.0 | 194.0 | 148.0 | 134.0 | 132.0 | 130.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 66.0  | 46.0  | 14.0  | 2.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 8.0 ~ 9.8   | 15.5 ~ 18.9 | 12.4 ~ 15.2 | 7.7 ~ 8.5   | 7.7 ~ 8.5   | 7.7 ~ 8.5   |  |
| Average Voltage Gap  | V   |  | 41 ~ 58     | 96 ~ 110    | 81 ~ 96     | 96 ~ 113    | 104 ~ 116   | 97 ~ 112    |  |
| Avg. Linear Feedrate | ALF |  | 534.0       | 351.9       | 247.0       | 163.7       | 122.5       | 97.8        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 10mm               | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                   | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-------------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 951                   | 2231                  | 2232                    | 2233                  | 2234                  | 2235                  | 2236                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | KH                      | KL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                      | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 8                       | 6                     | 9                     | 9                     | 6                     |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 5.0                     | 5.0                   | 2.0                   | 2.0                   | 1.5                   |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                      | 9                     |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 1                       | 1                     | 8                     | 8                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 2                       | 2                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 9                     | 12                      | 9                     | 8                     | 8                     | 4                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                       | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                       | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 42.0<br>(39.0 ~ 45.0) | 100.0<br>(98.0 ~ 102.0) | 90.0<br>(88.0 ~ 92.0) | 80.0<br>(78.0 ~ 82.0) | 80.0<br>(78.0 ~ 82.0) | 70.0<br>(68.0 ~ 72.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                     | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                      | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                      | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                      | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                      | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                      | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                       | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                      | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                       | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 2.0                   | 6.0                   | 9.0                     | 7.0                   | 8.0                   | 8.0                   | 8.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                     | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                     | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 155.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 191.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 229.0 | 168.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 238.0 | 177.0 | 141.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 237.0 | 176.0 | 140.0 | 129.0 | 127.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 241.0 | 180.0 | 144.0 | 133.0 | 131.0 | 130.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 61.0  | 36.0  | 11.0  | 2.0   | 1.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 6.2 ~ 7.6   | 14.5 ~ 17.7 | 11.8 ~ 14.4 | 7.7 ~ 8.5   | 7.7 ~ 8.5   | 7.7 ~ 8.5   |  |
| Average Voltage Gap  | V   |  | 47 ~ 65     | 100 ~ 112   | 85 ~ 98     | 97 ~ 111    | 100 ~ 113   | 92 ~ 106    |  |
| Avg. Linear Feedrate | ALF |  | 414.0       | 289.8       | 211.7       | 147.5       | 113.1       | 91.8        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 20mm               | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 951                   | 2241                  | 2242                  | 2243                  | 2244                     | 2245                  | 2246                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                       | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 14                       | 9                     | 6                     |       |       |
| Power Setting      | IP  | 7.0                   | 11.0                  | 6.0                   | 14.0                  | 2.5                      | 2.5                   | 1.5                   |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 12                    |                          |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 8                     | 12                    | 8                        | 6                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 1                     | 2                        | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 12                    | 8                        | 6                     | 4                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                        | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 42.0<br>(39.0 ~ 45.0) | 52.0<br>(50.0 ~ 54.0) | 45.0<br>(43.0 ~ 47.0) | 105.0<br>(103.0 ~ 107.0) | 90.0<br>(88.0 ~ 92.0) | 80.0<br>(78.0 ~ 82.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                       | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                        | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 2.0                   | 3.7                   | 9.0                   | 6.5                   | 7.0                      | 7.0                   | 6.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 153.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 195.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 220.0 | 155.0 | 130.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 234.0 | 169.0 | 144.0 | 134.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 236.0 | 171.0 | 146.0 | 136.0 | 133.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 236.0 | 171.0 | 146.0 | 136.0 | 133.0 | 131.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 25.0  | 10.0  | 3.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 4.9 ~ 6.0   | 9.6 ~ 11.7  | 8.1 ~ 9.9   | 6.8 ~ 7.5   | 6.8 ~ 7.5   | 5.8 ~ 6.5   |  |
| Average Voltage Gap  | V   |  | 37 ~ 55     | 42 ~ 61     | 37 ~ 53     | 108 ~ 121   | 108 ~ 121   | 88 ~ 100    |  |
| Avg. Linear Feedrate | ALF |  | 327.0       | 216.3       | 154.4       | 113.6       | 89.8        | 72.2        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.35 ~ 2.25 | 0.72 ~ 1.20 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 30mm               | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 952                   | 2251                  | 2252                  | 2253                  | 2254                  | 2255                  | 2256                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 14                    | 9                     | 10                    |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 1.5                   |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 8                     | 11                    | 8                     | 6                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 11                    | 8                     | 6                     | 4                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(34.0 ~ 40.0) | 50.0<br>(48.0 ~ 52.0) | 43.0<br>(41.0 ~ 45.0) | 90.0<br>(88.0 ~ 92.0) | 80.0<br>(78.0 ~ 82.0) | 70.0<br>(68.0 ~ 72.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 1.0                   | 3.0                   | 8.0                   | 6.0                   | 7.0                   | 7.0                   | 5.7                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 156.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 195.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 220.0 | 155.0 | 130.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 234.0 | 169.0 | 144.0 | 134.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 236.0 | 171.0 | 146.0 | 136.0 | 133.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 236.0 | 171.0 | 146.0 | 136.0 | 133.0 | 131.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 25.0  | 10.0  | 3.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 3.9 ~ 4.8   | 7.8 ~ 9.6   | 6.3 ~ 7.7   | 6.8 ~ 7.5   | 6.8 ~ 7.5   | 5.5 ~ 6.2   |  |
| Average Voltage Gap  | V   |  | 29 ~ 47     | 41 ~ 59     | 36 ~ 51     | 96 ~ 108    | 95 ~ 108    | 79 ~ 91     |  |
| Avg. Linear Feedrate | ALF |  | 261.0       | 174.0       | 123.0       | 95.6        | 78.2        | 63.9        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 40mm               | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 952                   | 2261                  | 2262                  | 2263                  | 2264                  | 2265                  | 2266                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 14                    | 9                     | 10                    |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 1.5                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 8                     | 11                    | 8                     | 6                     | 2                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 8                     | 11                    | 8                     | 6                     | 4                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 32.0<br>(29.0 ~ 35.0) | 48.0<br>(46.0 ~ 50.0) | 41.0<br>(39.0 ~ 43.0) | 75.0<br>(73.0 ~ 77.0) | 70.0<br>(68.0 ~ 72.0) | 60.0<br>(58.0 ~ 62.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.3                   | 7.0                   | 5.5                   | 7.0                   | 7.0                   | 5.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 159.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 195.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 220.0 | 155.0 | 130.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 233.0 | 168.0 | 143.0 | 133.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 235.0 | 170.0 | 145.0 | 135.0 | 132.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 236.0 | 171.0 | 146.0 | 136.0 | 133.0 | 131.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 25.0  | 10.0  | 3.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 2.9 ~ 3.6   | 6.1 ~ 7.5   | 4.5 ~ 5.5   | 6.8 ~ 7.5   | 6.8 ~ 7.5   | 5.3 ~ 5.9   |  |
| Average Voltage Gap  | V   |  | 25 ~ 39     | 39 ~ 57     | 34 ~ 49     | 84 ~ 96     | 83 ~ 95     | 70 ~ 82     |  |
| Avg. Linear Feedrate | ALF |  | 195.0       | 131.9       | 91.6        | 75.5        | 64.2        | 53.9        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 50mm               | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|
| E-pack Number      | Eno | 953                   | 2271                  | 2272                  | 2273                  | 2274                  | 2275                  | 2276                  | 2277                  |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | LC                    |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | SL                    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 14                    | 9                     | 10                    | 10                    |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   | 1.5                   |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 12                    |                       |                       |                       |                       |       |
| Off Time           | OFF | 6                     | 4                     | 8                     | 10                    | 8                     | 6                     | 2                     | 2                     |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 1                     | 2                     | 1                     | 1                     | 1                     |       |
| Stabilizer B       | SB  | 7                     | 4                     | 8                     | 10                    | 8                     | 6                     | 4                     | 4                     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 31.0<br>(28.0 ~ 34.0) | 46.0<br>(44.0 ~ 48.0) | 41.0<br>(39.0 ~ 43.0) | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(38.0 ~ 42.0) |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    | ON                    |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4                     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |
| Feedrate Address   | FA  | 0.7                   | 2.0                   | 6.0                   | 5.0                   | 6.0                   | 6.0                   | 5.2                   | 5.0                   |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 164.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 195.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 220.0 | 155.0 | 130.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 232.0 | 167.0 | 142.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 235.0 | 170.0 | 145.0 | 135.0 | 132.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 235.0 | 170.0 | 145.0 | 135.0 | 132.0 | 130.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 237.0 | 172.0 | 147.0 | 137.0 | 134.0 | 132.0 | 131.0 | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 25.0  | 10.0  | 3.0   | 2.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 2.3 ~ 2.9   | 5.6 ~ 6.8   | 4.7 ~ 5.8   | 5.8 ~ 6.5   | 5.8 ~ 6.5   | 5.0 ~ 5.7   | 4.8 ~ 5.5   |
| Average Voltage Gap  | V   |  | 24 ~ 40     | 36 ~ 55     | 34 ~ 48     | 75 ~ 87     | 75 ~ 88     | 70 ~ 79     | 45 ~ 58     |
| Avg. Linear Feedrate | ALF |  | 156.0       | 109.9       | 81.5        | 66.7        | 56.5        | 48.1        | 41.6        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 60mm               | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|
| E-pack Number      | Eno | 953                   | 2281                  | 2282                  | 2283                  | 2284                  | 2285                  | 2286                  | 2287                  |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | LC                    |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | SL                    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 14                    | 9                     | 10                    | 10                    |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   | 1.5                   |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 12                    |                       |                       |                       |                       |       |
| Off Time           | OFF | 6                     | 4                     | 8                     | 9                     | 8                     | 6                     | 2                     | 2                     |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 1                     | 2                     | 1                     | 1                     | 1                     |       |
| Stabilizer B       | SB  | 7                     | 5                     | 8                     | 9                     | 8                     | 6                     | 4                     | 4                     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(27.0 ~ 33.0) | 44.0<br>(42.0 ~ 46.0) | 41.0<br>(39.0 ~ 43.0) | 50.0<br>(48.0 ~ 52.0) | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(38.0 ~ 42.0) |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    | ON                    |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4                     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |
| Feedrate Address   | FA  | 0.7                   | 1.7                   | 5.0                   | 4.5                   | 6.0                   | 6.0                   | 6.0                   | 5.0                   |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 169.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 195.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 220.0 | 155.0 | 130.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 231.0 | 166.0 | 141.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 234.0 | 169.0 | 144.0 | 134.0 | 131.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 235.0 | 170.0 | 145.0 | 135.0 | 132.0 | 130.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 237.0 | 172.0 | 147.0 | 137.0 | 134.0 | 132.0 | 131.0 | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 25.0  | 10.0  | 3.0   | 2.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.8 ~ 2.2   | 5.1 ~ 6.2   | 5.0 ~ 6.1   | 5.8 ~ 6.5   | 5.8 ~ 6.5   | 5.8 ~ 6.5   | 4.8 ~ 5.5   |
| Average Voltage Gap  | V   |  | 23 ~ 40     | 34 ~ 52     | 34 ~ 48     | 66 ~ 78     | 68 ~ 81     | 69 ~ 76     | 45 ~ 58     |
| Avg. Linear Feedrate | ALF |  | 120.0       | 88.6        | 70.0        | 58.8        | 50.7        | 44.6        | 39.0        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 70mm               | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|
| E-pack Number      | Eno | 954                   | 2291                  | 2292                  | 2293                  | 2294                  | 2295                  | 2296                  | 2297                  |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | LC                    |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | SL                    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 14                    | 9                     | 12                    | 10                    |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   | 1.5                   |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 12                    |                       |                       |                       |                       |       |
| Off Time           | OFF | 6                     | 4                     | 8                     | 9                     | 8                     | 6                     | 2                     | 1                     |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 1                     | 2                     | 1                     | 1                     | 1                     |       |
| Stabilizer B       | SB  | 7                     | 5                     | 8                     | 9                     | 8                     | 6                     | 4                     | 4                     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(27.0 ~ 33.0) | 42.0<br>(40.0 ~ 44.0) | 41.0<br>(39.0 ~ 43.0) | 45.0<br>(43.0 ~ 47.0) | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(43.0 ~ 47.0) | 35.0<br>(33.0 ~ 37.0) |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    | ON                    |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4                     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |
| Feedrate Address   | FA  | 0.6                   | 1.5                   | 4.9                   | 4.0                   | 5.0                   | 5.0                   | 5.0                   | 5.0                   |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 169.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 197.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 223.0 | 156.0 | 131.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 234.0 | 167.0 | 142.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 236.0 | 169.0 | 144.0 | 133.0 | 130.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 238.0 | 171.0 | 146.0 | 135.0 | 132.0 | 130.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 239.0 | 172.0 | 147.0 | 136.0 | 133.0 | 131.0 | 130.0 | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 67.0  | 25.0  | 11.0  | 3.0   | 2.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.5 ~ 2.0   | 4.0 ~ 4.9   | 3.9 ~ 5.1   | 4.8 ~ 5.5   | 4.8 ~ 5.5   | 4.8 ~ 5.5   | 4.8 ~ 5.5   |
| Average Voltage Gap  | V   |  | 22 ~ 40     | 33 ~ 49     | 34 ~ 48     | 61 ~ 74     | 59 ~ 69     | 62 ~ 72     | 42 ~ 56     |
| Avg. Linear Feedrate | ALF |  | 105.0       | 75.4        | 58.9        | 49.5        | 42.7        | 37.5        | 33.4        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 80mm               | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|
| E-pack Number      | Eno | 954                   | 2301                  | 2302                  | 2303                  | 2304                  | 2305                  | 2306                  | 2307                  |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | LC                    |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | SL                    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 14                    | 9                     | 12                    | 10                    |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   | 1.5                   |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 12                    |                       |                       |                       |                       |       |
| Off Time           | OFF | 6                     | 4                     | 8                     | 9                     | 7                     | 6                     | 1                     | 1                     |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 1                     | 2                     | 1                     | 1                     | 1                     |       |
| Stabilizer B       | SB  | 7                     | 5                     | 8                     | 9                     | 7                     | 6                     | 2                     | 4                     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(27.0 ~ 33.0) | 40.0<br>(38.0 ~ 42.0) | 41.0<br>(39.0 ~ 43.0) | 40.0<br>(38.0 ~ 42.0) | 40.0<br>(38.0 ~ 42.0) | 40.0<br>(38.0 ~ 42.0) | 30.0<br>(28.0 ~ 32.0) |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    | ON                    |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4                     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |
| Feedrate Address   | FA  | 0.6                   | 1.3                   | 4.8                   | 3.5                   | 5.0                   | 5.0                   | 5.0                   | 5.0                   |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 169.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 200.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 226.0 | 156.0 | 131.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 239.0 | 169.0 | 144.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 242.0 | 172.0 | 147.0 | 134.0 | 130.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 244.0 | 174.0 | 149.0 | 136.0 | 132.0 | 130.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 245.0 | 175.0 | 150.0 | 137.0 | 133.0 | 131.0 | 130.0 | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 70.0  | 25.0  | 13.0  | 4.0   | 2.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.3 ~ 1.7   | 3.0 ~ 3.7   | 3.3 ~ 4.1   | 4.8 ~ 5.5   | 4.8 ~ 5.5   | 4.8 ~ 5.5   | 4.8 ~ 5.5   |
| Average Voltage Gap  | V   |  | 21 ~ 41     | 33 ~ 48     | 34 ~ 48     | 57 ~ 71     | 51 ~ 63     | 55 ~ 68     | 41 ~ 54     |
| Avg. Linear Feedrate | ALF |  | 90.0        | 62.2        | 48.6        | 42.0        | 37.0        | 33.0        | 29.8        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 90mm               | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|
| E-pack Number      | Eno | 955                   | 2311                  | 2312                  | 2313                  | 2314                  | 2315                  | 2316                  | 2317                  |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | LC                    |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | SL                    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 6                     | 12                    | 14                    | 9                     | 12                    | 10                    |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   | 1.5                   |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 12                    |                       |                       |                       |                       |       |
| Off Time           | OFF | 6                     | 4                     | 7                     | 8                     | 7                     | 6                     | 1                     | 1                     |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                     | 1                     | 2                     | 1                     | 1                     | 1                     |       |
| Stabilizer B       | SB  | 6                     | 6                     | 7                     | 8                     | 7                     | 6                     | 3                     | 4                     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(27.0 ~ 33.0) | 45.0<br>(43.0 ~ 47.0) | 42.0<br>(40.0 ~ 44.0) | 45.0<br>(43.0 ~ 47.0) | 49.0<br>(47.0 ~ 51.0) | 42.0<br>(40.0 ~ 44.0) | 25.0<br>(23.0 ~ 27.0) |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    | ON                    |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4                     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |
| Feedrate Address   | FA  | 0.5                   | 1.1                   | 4.5                   | 3.4                   | 5.0                   | 5.0                   | 5.0                   | 5.0                   |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 170.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 197.0 | 127.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 225.0 | 155.0 | 130.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 239.0 | 169.0 | 144.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 243.0 | 173.0 | 148.0 | 135.0 | 131.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 244.0 | 174.0 | 149.0 | 136.0 | 132.0 | 130.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 245.0 | 175.0 | 150.0 | 137.0 | 133.0 | 131.0 | 130.0 | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 70.0  | 25.0  | 13.0  | 4.0   | 2.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.1 ~ 1.5   | 3.2 ~ 3.9   | 3.1 ~ 3.8   | 4.8 ~ 5.5   | 4.8 ~ 5.5   | 4.8 ~ 5.5   | 4.8 ~ 5.5   |
| Average Voltage Gap  | V   |  | 20 ~ 40     | 35 ~ 50     | 38 ~ 53     | 53 ~ 66     | 49 ~ 61     | 52 ~ 64     | 38 ~ 51     |
| Avg. Linear Feedrate | ALF |  | 78.0        | 57.1        | 44.8        | 39.1        | 34.7        | 31.2        | 28.3        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 100mm              | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|
| E-pack Number      | Eno | 955                   | 2321                  | 2322                  | 2323                  | 2324                  | 2325                  | 2326                  | 2327                  |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | LC                    |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | SL                    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 8                     | 12                    | 14                    | 9                     | 12                    | 10                    |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   | 1.5                   |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 12                    |                       |                       |                       |                       |       |
| Off Time           | OFF | 6                     | 4                     | 7                     | 8                     | 7                     | 6                     | 1                     | 1                     |       |
| Stabilizer A       | SA  | 3                     | 6                     | 4                     | 1                     | 2                     | 1                     | 1                     | 1                     |       |
| Stabilizer B       | SB  | 6                     | 7                     | 7                     | 8                     | 7                     | 6                     | 2                     | 4                     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(27.0 ~ 33.0) | 50.0<br>(48.0 ~ 52.0) | 51.0<br>(49.0 ~ 53.0) | 40.0<br>(38.0 ~ 42.0) | 30.0<br>(28.0 ~ 32.0) | 30.0<br>(28.0 ~ 32.0) | 20.0<br>(18.0 ~ 22.0) |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    | ON                    |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4                     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |
| Feedrate Address   | FA  | 0.5                   | 1.0                   | 4.2                   | 3.3                   | 5.0                   | 5.0                   | 5.0                   | 5.0                   |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 171.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 197.0 | 127.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 227.0 | 157.0 | 130.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 241.0 | 171.0 | 144.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 245.0 | 175.0 | 148.0 | 135.0 | 131.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 247.0 | 177.0 | 150.0 | 137.0 | 133.0 | 131.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 248.0 | 178.0 | 151.0 | 138.0 | 134.0 | 132.0 | 131.0 | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 70.0  | 27.0  | 13.0  | 4.0   | 2.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.9 ~ 1.1   | 3.4 ~ 4.1   | 2.9 ~ 3.6   | 4.8 ~ 5.5   | 4.8 ~ 5.5   | 4.8 ~ 5.5   | 4.8 ~ 5.5   |
| Average Voltage Gap  | V   |  | 20 ~ 38     | 39 ~ 60     | 43 ~ 59     | 49 ~ 62     | 47 ~ 59     | 49 ~ 61     | 36 ~ 48     |
| Avg. Linear Feedrate | ALF |  | 60.0        | 47.4        | 38.1        | 33.9        | 30.6        | 27.8        | 25.5        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 125mm              | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|
| E-pack Number      | Eno | 955                   | 2331                  | 2332                  | 2333                  | 2334                  | 2335                  | 2336                  | 2337                  |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | LC                    |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | SL                    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 12                    | 14                    | 14                    | 14                    | 10                    |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 10.0                  | 14.0                  | 2.5                   | 2.5                   | 2.0                   | 2.0                   |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 12                    |                       |                       |                       |                       |       |
| Off Time           | OFF | 6                     | 4                     | 5                     | 8                     | 7                     | 6                     | 1                     | 1                     |       |
| Stabilizer A       | SA  | 3                     | 6                     | 4                     | 1                     | 2                     | 1                     | 1                     | 1                     |       |
| Stabilizer B       | SB  | 6                     | 9                     | 5                     | 8                     | 7                     | 6                     | 3                     | 4                     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(27.0 ~ 33.0) | 40.0<br>(38.0 ~ 42.0) | 38.0<br>(36.0 ~ 40.0) | 30.0<br>(28.0 ~ 32.0) | 35.0<br>(33.0 ~ 37.0) | 30.0<br>(28.0 ~ 32.0) | 25.0<br>(23.0 ~ 27.0) |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    | ON                    |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4                     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |
| Feedrate Address   | FA  | 0.5                   | 0.7                   | 3.5                   | 2.5                   | 5.0                   | 5.0                   | 5.0                   | 5.0                   |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 177.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 204.0 | 129.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 235.0 | 160.0 | 130.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 248.0 | 173.0 | 143.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 252.0 | 177.0 | 147.0 | 135.0 | 130.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 253.0 | 178.0 | 148.0 | 136.0 | 131.0 | 130.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 255.0 | 180.0 | 150.0 | 138.0 | 133.0 | 132.0 | 131.0 | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 75.0  | 30.0  | 12.0  | 5.0   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.5 ~ 0.7   | 7.8 ~ 9.5   | 1.7 ~ 2.2   | 4.8 ~ 5.5   | 4.8 ~ 5.5   | 4.8 ~ 5.5   | 4.8 ~ 5.5   |
| Average Voltage Gap  | V   |  | 20 ~ 44     | 56 ~ 75     | 31 ~ 45     | 39 ~ 50     | 42 ~ 54     | 46 ~ 58     | 41 ~ 52     |
| Avg. Linear Feedrate | ALF |  | 36.0        | 33.7        | 26.1        | 24.1        | 22.4        | 20.9        | 19.5        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 150mm              | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|
| E-pack Number      | Eno | 955                   | 2341                  | 2342                  | 2343                  | 2344                  | 2345                  | 2346                  | 2347                  |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | LC                    |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | SL                    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 12                    | 14                    | 14                    | 14                    | 10                    |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 10.0                  | 14.0                  | 2.5                   | 2.5                   | 2.0                   | 2.0                   |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 12                    |                       |                       |                       |                       |       |
| Off Time           | OFF | 6                     | 4                     | 5                     | 8                     | 7                     | 6                     | 1                     | 1                     |       |
| Stabilizer A       | SA  | 3                     | 6                     | 4                     | 1                     | 2                     | 1                     | 1                     | 1                     |       |
| Stabilizer B       | SB  | 6                     | 9                     | 5                     | 8                     | 7                     | 6                     | 3                     | 4                     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(27.0 ~ 33.0) | 40.0<br>(38.0 ~ 42.0) | 38.0<br>(36.0 ~ 40.0) | 30.0<br>(28.0 ~ 32.0) | 35.0<br>(33.0 ~ 37.0) | 30.0<br>(28.0 ~ 32.0) | 25.0<br>(23.0 ~ 27.0) |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    | ON                    |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF                   |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4                     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |
| Feedrate Address   | FA  | 0.5                   | 0.5                   | 3.2                   | 2.2                   | 5.0                   | 5.0                   | 5.0                   | 5.0                   |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 183.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 205.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 240.0 | 165.0 | 135.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 252.0 | 177.0 | 147.0 | 135.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 257.0 | 182.0 | 152.0 | 140.0 | 135.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 258.0 | 183.0 | 153.0 | 141.0 | 136.0 | 135.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 255.0 | 180.0 | 150.0 | 138.0 | 133.0 | 132.0 | 131.0 | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 75.0  | 30.0  | 12.0  | 5.0   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.4 ~ 0.6   | 6.0 ~ 7.4   | 1.3 ~ 1.6   | 4.8 ~ 5.5   | 4.8 ~ 5.5   | 4.8 ~ 5.5   | 4.8 ~ 5.5   |
| Average Voltage Gap  | V   |  | 20 ~ 38     | 50 ~ 68     | 31 ~ 45     | 36 ~ 47     | 40 ~ 52     | 38 ~ 51     | 32 ~ 44     |
| Avg. Linear Feedrate | ALF |  | 30.0        | 27.9        | 21.1        | 19.8        | 18.6        | 17.5        | 16.6        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 175mm              | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 955                   | 2351                  | 2352                  | 2353                  | 2354                  | 2355                  | 2356                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 12                    | 14                    | 14                    | 14                    |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 10.0                  | 14.0                  | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 5                     | 8                     | 7                     | 6                     | 1                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 4                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 6                     | 9                     | 5                     | 8                     | 7                     | 6                     | 3                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(27.0 ~ 33.0) | 60.0<br>(58.0 ~ 62.0) | 38.0<br>(36.0 ~ 40.0) | 50.0<br>(48.0 ~ 52.0) | 28.0<br>(26.0 ~ 30.0) | 30.0<br>(28.0 ~ 32.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.5                   | 3.0                   | 2.0                   | 5.0                   | 5.0                   | 5.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 183.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 205.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 240.0 | 165.0 | 135.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 250.0 | 175.0 | 145.0 | 135.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 255.0 | 180.0 | 150.0 | 140.0 | 135.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 257.0 | 182.0 | 152.0 | 142.0 | 137.0 | 136.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 75.0  | 30.0  | 10.0  | 5.0   | 1.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.3 ~ 0.5   | 4.1 ~ 5.0   | 1.3 ~ 1.6   | 4.8 ~ 5.5   | 4.8 ~ 5.5   | 4.8 ~ 5.5   |  |
| Average Voltage Gap  | V   |  | 23 ~ 38     | 54 ~ 71     | 31 ~ 45     | 60 ~ 73     | 35 ~ 47     | 37 ~ 50     |  |
| Avg. Linear Feedrate | ALF |  | 24.0        | 22.1        | 17.6        | 16.6        | 15.8        | 15.0        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 10.8 ~ 13.2 | 5.4 ~ 6.6   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.72 ~ 1.20 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 200mm              | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 955                   | 2361                  | 2362                  | 2363                  | 2364                  | 2365                  | 2366                  |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 12                    | 14                    | 15                    | 15                    |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 10.0                  | 14.0                  | 2.5                   | 3.0                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 5                     | 8                     | 7                     | 1                     | 1                     |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 4                     | 1                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 6                     | 11                    | 5                     | 8                     | 7                     | 4                     | 3                     |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(32.0 ~ 38.0) | 70.0<br>(68.0 ~ 72.0) | 28.0<br>(26.0 ~ 30.0) | 40.0<br>(38.0 ~ 42.0) | 30.0<br>(28.0 ~ 32.0) | 25.0<br>(23.0 ~ 27.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.4                   | 3.0                   | 2.0                   | 5.0                   | 5.0                   | 5.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 183.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 206.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 240.0 | 165.0 | 135.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 247.0 | 172.0 | 142.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 250.0 | 175.0 | 145.0 | 135.0 | 134.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 251.0 | 176.0 | 146.0 | 136.0 | 135.0 | 134.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 75.0  | 30.0  | 10.0  | 1.0   | 1.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.2 ~ 0.4   | 2.6 ~ 3.2   | 3.3 ~ 4.0   | 4.8 ~ 5.5   | 4.8 ~ 5.5   | 4.8 ~ 5.5   |  |
| Average Voltage Gap  | V   |  | 25 ~ 46     | 58 ~ 81     | 25 ~ 34     | 51 ~ 65     | 36 ~ 48     | 35 ~ 48     |  |
| Avg. Linear Feedrate | ALF |  | 18.0        | 16.3        | 15.2        | 14.5        | 13.8        | 13.2        |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 10.8 ~ 13.2 | 5.4 ~ 6.6   | 2.2 ~ 2.8   |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.72 ~ 1.20 | 0.27 ~ 0.45 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 250mm              | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 955                   | 2371                  | 2372                  | 2373                  | 2374                  | 2375                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 12                    | 14                    | 15                    |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 10.0                  | 14.0                  | 3.0                   | 3.0                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 12                    |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 5                     | 8                     | 7                     | 4                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 4                     | 1                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 6                     | 11                    | 5                     | 8                     | 7                     | 6                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(32.0 ~ 38.0) | 45.0<br>(43.0 ~ 47.0) | 28.0<br>(26.0 ~ 30.0) | 40.0<br>(38.0 ~ 42.0) | 25.0<br>(23.0 ~ 27.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.3                   | 2.5                   | 1.5                   | 4.0                   | 4.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 189.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 208.0 | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 245.0 | 170.0 | 140.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 251.0 | 176.0 | 146.0 | 136.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 258.0 | 183.0 | 153.0 | 143.0 | 142.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 75.0  | 30.0  | 10.0  | 1.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.1 ~ 0.3   | 1.2 ~ 1.5   | 2.3 ~ 2.8   | 3.8 ~ 4.5   | 3.8 ~ 4.5   |  |  |
| Average Voltage Gap  | V   |  | 25 ~ 47     | 42 ~ 68     | 34 ~ 50     | 58 ~ 70     | 33 ~ 46     |  |  |
| Avg. Linear Feedrate | ALF |  | 12.0        | 10.5        | 9.8         | 9.4         | 9.1         |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 10.8 ~ 13.2 | 5.4 ~ 6.6   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.72 ~ 1.20 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 300mm              | ACU     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 955                   | 2381                  | 2382                  | 2383                  | 2384                  | 2385                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 12                    | 14                    | 10                    |       |       |       |
| Power Setting      | IP  | 8.0                   | 13.0                  | 10.0                  | 14.0                  | 3.0                   | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 12                    |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 5                     | 5                     | 8                     | 7                     | 4                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 4                     | 1                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 6                     | 9                     | 5                     | 8                     | 7                     | 6                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 46.0<br>(43.0 ~ 49.0) | 45.0<br>(43.0 ~ 47.0) | 23.0<br>(21.0 ~ 25.0) | 40.0<br>(38.0 ~ 42.0) | 25.0<br>(23.0 ~ 27.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.2                   | 2.0                   | 1.5                   | 4.0                   | 4.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 189.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 210.0 | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 239.0 | 164.0 | 134.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 251.0 | 176.0 | 146.0 | 136.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 254.0 | 179.0 | 149.0 | 139.0 | 134.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 75.0  | 30.0  | 10.0  | 5.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.1 ~ 0.2   | 1.2 ~ 1.5   | 2.3 ~ 2.8   | 3.8 ~ 4.5   | 3.8 ~ 4.5   |  |  |
| Average Voltage Gap  | V   |  | 25 ~ 55     | 38 ~ 59     | 20 ~ 30     | 35 ~ 47     | 36 ~ 49     |  |  |
| Avg. Linear Feedrate | ALF |  | 9.0         | 8.1         | 7.7         | 7.5         | 7.2         |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 10.8 ~ 13.2 | 9.0 ~ 11.0  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.54 ~ 0.90 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | SPB   |

Thickness 5 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 2111            | RH | 7.5  | 159.0  | 201.0 | 209.0 | 213.0 |     |     |     |     | 0.0       |
| 2                 | 2112            | MP | 8.0  | -      | 136.0 | 144.0 | 148.0 |     |     |     |     | 65.0      |
| 3                 | 2113            | LC | 13.8 | -      | -     | 132.0 | 136.0 |     |     |     |     | 12.0      |
| 4                 | 2114            | LA | 10.3 | -      | -     | -     | 130.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 2121            | RH | 6.0  | 163.0  | 193.0 | 200.0 | 202.0 |     |     |     |     | 0.0       |
| 2                 | 2122            | MP | 8.0  | -      | 133.0 | 140.0 | 142.0 |     |     |     |     | 60.0      |
| 3                 | 2123            | LC | 11.6 | -      | -     | 132.0 | 134.0 |     |     |     |     | 8.0       |
| 4                 | 2124            | LA | 10.3 | -      | -     | -     | 130.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 2131            | RH | 3.6  | 167.0  | 187.0 | 193.0 | 196.0 |     |     |     |     | 0.0       |
| 2                 | 2132            | MP | 5.5  | -      | 132.0 | 138.0 | 141.0 |     |     |     |     | 55.0      |
| 3                 | 2133            | LC | 11.2 | -      | -     | 132.0 | 135.0 |     |     |     |     | 6.0       |
| 4                 | 2134            | LA | 9.2  | -      | -     | -     | 131.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | SPB   |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 2141            | RH | 3.0 | 164.0  | 189.0 | 197.0 | 199.0 |     |     |     |     | 0.0       |
| 2                 | 2142            | MP | 4.5 | -      | 132.0 | 140.0 | 142.0 |     |     |     |     | 57.0      |
| 3                 | 2143            | LC | 9.7 | -      | -     | 132.0 | 134.0 |     |     |     |     | 8.0       |
| 4                 | 2144            | LA | 8.2 | -      | -     | -     | 130.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 2151            | RH | 2.3 | 163.0  | 193.0 | 201.0 | 203.0 |     |     |     |     | 0.0       |
| 2                 | 2152            | MP | 3.6 | -      | 133.0 | 141.0 | 143.0 |     |     |     |     | 60.0      |
| 3                 | 2153            | LC | 8.2 | -      | -     | 131.0 | 133.0 |     |     |     |     | 10.0      |
| 4                 | 2154            | LA | 7.3 | -      | -     | -     | 129.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 953             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 2161            | RH | 1.8 | 165.0  | 197.0 | 205.0 | 208.0 |     |     |     |     | 0.0       |
| 2                 | 2162            | MP | 3.3 | -      | 132.0 | 140.0 | 143.0 |     |     |     |     | 65.0      |
| 3                 | 2163            | LC | 7.8 | -      | -     | 130.0 | 133.0 |     |     |     |     | 10.0      |
| 4                 | 2164            | LA | 7.4 | -      | -     | -     | 129.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | SPB   |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 953             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 2171            | RH | 1.4 | 169.0  | 202.0 | 209.0 | 212.0 |     |     |     |     | 0.0       |
| 2                 | 2172            | MP | 3.0 | -      | 132.0 | 139.0 | 142.0 |     |     |     |     | 70.0      |
| 3                 | 2173            | LC | 7.5 | -      | -     | 130.0 | 133.0 |     |     |     |     | 9.0       |
| 4                 | 2174            | LA | 7.5 | -      | -     | -     | 130.0 |     |     |     |     | 3.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 2181            | RH | 1.3 | 174.0  | 205.0 | 214.0 | 217.0 |     |     |     |     | 0.0       |
| 2                 | 2182            | MP | 2.9 | -      | 133.0 | 142.0 | 145.0 |     |     |     |     | 72.0      |
| 3                 | 2183            | LC | 6.7 | -      | -     | 132.0 | 135.0 |     |     |     |     | 10.0      |
| 4                 | 2184            | LA | 6.0 | -      | -     | -     | 131.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 2191            | RH | 1.2 | 178.0  | 210.0 | 219.0 | 221.0 |     |     |     |     | 0.0       |
| 2                 | 2192            | MP | 2.8 | -      | 135.0 | 144.0 | 146.0 |     |     |     |     | 75.0      |
| 3                 | 2193            | LC | 6.0 | -      | -     | 134.0 | 136.0 |     |     |     |     | 10.0      |
| 4                 | 2194            | LA | 4.0 | -      | -     | -     | 131.0 |     |     |     |     | 5.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | SPB   |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 2201            | RH | 1.0 | 179.0  | 211.0 | 220.0 | 222.0 |     |     |     |     | 0.0       |
| 2                 | 2202            | MP | 2.7 | -      | 134.0 | 143.0 | 145.0 |     |     |     |     | 77.0      |
| 3                 | 2203            | LC | 5.1 | -      | -     | 134.0 | 136.0 |     |     |     |     | 9.0       |
| 4                 | 2204            | LA | 4.0 | -      | -     | -     | 132.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 2211            | RH | 0.7 | 180.0  | 214.0 | 222.0 | 225.0 |     |     |     |     | 0.0       |
| 2                 | 2212            | MP | 2.6 | -      | 134.0 | 142.0 | 145.0 |     |     |     |     | 80.0      |
| 3                 | 2213            | LC | 4.2 | -      | -     | 134.0 | 137.0 |     |     |     |     | 8.0       |
| 4                 | 2214            | LA | 4.0 | -      | -     | -     | 133.0 |     |     |     |     | 4.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 10.0  | 3.5   | 2.2   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.20  | 0.48  | 0.28  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 5mm                | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                    | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 2111                  | 2112                  | 2113                     | 2114                     |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                       | LA                       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 10                       | 12                       |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 9.0                   | 3.0                      | 1.5                      |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                          |       |       |       |       |
| Off Time           | OFF | 6                     | 5                     | 1                     | 1                        | 1                        |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                        |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 16                    | 1                        | 1                        |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                        |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                        |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 58.0<br>(55.0 ~ 61.0) | 90.0<br>(88.0 ~ 92.0) | 150.0<br>(148.0 ~ 152.0) | 150.0<br>(148.0 ~ 152.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                      | OFF                      |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 9                        | 9                        |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                       | 13                       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 6                     | 4                        | 4                        |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 7.5                   | 8.0                   | 13.8                     | 10.3                     |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 159.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 201.0 | 136.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 209.0 | 144.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 213.0 | 148.0 | 136.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 12.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 10.4 ~ 11.2 | 11.5 ~ 14.1 | 12.3 ~ 13.6 | 9.2 ~ 10.1  |  |  |  |
| Average Voltage Gap  | V   |  | 53 ~ 74     | 93 ~ 108    | 172 ~ 184   | 148 ~ 161   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 648.0       | 351.5       | 242.0       | 170.7       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 10mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                    | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 2121                  | 2122                  | 2123                     | 2124                     |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                       | LA                       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 10                       | 12                       |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 7.0                   | 3.0                      | 1.5                      |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |                          |       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 1                     | 1                        | 1                        |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        | 1                        |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 16                    | 1                        | 1                        |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                        |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                        |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 55.0<br>(52.0 ~ 58.0) | 80.0<br>(78.0 ~ 82.0) | 140.0<br>(138.0 ~ 142.0) | 140.0<br>(138.0 ~ 142.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                      | OFF                      |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 9                        | 9                        |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                       | 13                       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 6                     | 4                        | 4                        |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 6.0                   | 8.0                   | 11.6                     | 10.3                     |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 163.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 193.0 | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 200.0 | 140.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 202.0 | 142.0 | 134.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 60.0  | 8.0   | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 7.4 ~ 7.8   | 11.5 ~ 14.0 | 10.3 ~ 11.4 | 9.1 ~ 10.1  |  |  |  |
| Average Voltage Gap  | V   |  | 48 ~ 65     | 87 ~ 100    | 155 ~ 167   | 127 ~ 140   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 456.0       | 285.7       | 198.6       | 147.7       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 20mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 2131                  | 2132                  | 2133                     | 2134                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                       | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                       | 13                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 11.0                  | 6.0                   | 3.0                      | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 9                     | 16                    | 1                        | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 36.0<br>(33.0 ~ 39.0) | 74.0<br>(72.0 ~ 76.0) | 130.0<br>(128.0 ~ 132.0) | 95.0<br>(93.0 ~ 97.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                       | 13                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 10                    | 5                        | 5                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 3.6                   | 5.5                   | 11.2                     | 9.2                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 167.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 187.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 193.0 | 138.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 196.0 | 141.0 | 135.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 55.0  | 6.0   | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 4.5 ~ 5.1   | 9.3 ~ 11.3  | 10.7 ~ 11.8 | 8.4 ~ 9.3   |  |  |  |
| Average Voltage Gap  | V   |  | 53 ~ 69     | 80 ~ 98     | 143 ~ 159   | 108 ~ 121   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 288.0       | 196.5       | 152.2       | 118.3       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 30mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 952                   | 2141                  | 2142                  | 2143                     | 2144                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                       | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                       | 12                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 7.0                   | 3.0                      | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 16                    | 1                        | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 71.0<br>(69.0 ~ 73.0) | 115.0<br>(113.0 ~ 117.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                       | 13                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 20                    | 10                       | 10                    |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 3.0                   | 4.5                   | 9.7                      | 8.2                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 164.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 189.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 197.0 | 140.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 199.0 | 142.0 | 134.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 57.0  | 8.0   | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.8 ~ 4.4   | 7.4 ~ 9.0   | 9.2 ~ 9.7   | 7.7 ~ 8.2   |  |  |  |
| Average Voltage Gap  | V   |  | 45 ~ 60     | 78 ~ 95     | 122 ~ 137   | 90 ~ 110    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 246.0       | 164.0       | 127.2       | 100.4       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 40mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                   | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 952                   | 2151                  | 2152                  | 2153                    | 2154                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                      | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                      | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                      | 13                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 7.0                   | 3.0                     | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                         |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 1                     | 1                       | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                       | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 16                    | 1                       | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                       | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                       | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 43.0<br>(40.0 ~ 46.0) | 80.0<br>(78.0 ~ 82.0) | 100.0<br>(98.0 ~ 102.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                      | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                     | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                      | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                      | 13                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                      | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                      | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                       | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                      | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 30                    | 10                      | 10                    |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.3                   | 3.6                   | 8.2                     | 7.3                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 163.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 193.0 | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 201.0 | 141.0 | 131.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 203.0 | 143.0 | 133.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 60.0  | 10.0  | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.5 ~ 3.1   | 5.5 ~ 6.7   | 7.2 ~ 8.0   | 6.4 ~ 7.1   |  |  |  |
| Average Voltage Gap  | V   |  | 27 ~ 41     | 76 ~ 91     | 115 ~ 128   | 75 ~ 91     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 168.0       | 115.1       | 91.9        | 74.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 50mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 953                   | 2161                  | 2162                  | 2163                  | 2164                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                    | 13                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 7.0                   | 3.0                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 16                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 39.0<br>(36.0 ~ 42.0) | 70.0<br>(68.0 ~ 72.0) | 90.0<br>(88.0 ~ 92.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                    | 13                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 30                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.8                   | 3.3                   | 7.8                   | 7.4                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 165.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 197.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 205.0 | 140.0 | 130.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 208.0 | 143.0 | 133.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 10.0  | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.8 ~ 3.1   | 4.4 ~ 5.4   | 7.1 ~ 7.8   | 6.9 ~ 7.4   |  |  |  |
| Average Voltage Gap  | V   |  | 25 ~ 41     | 67 ~ 80     | 103 ~ 112   | 72 ~ 85     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 177.0       | 110.5       | 88.6        | 73.4        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 60mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 953                   | 2171                  | 2172                  | 2173                  | 2174                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                    | 13                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 7.0                   | 3.0                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 16                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 34.0<br>(31.0 ~ 37.0) | 67.0<br>(65.0 ~ 69.0) | 85.0<br>(83.0 ~ 87.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                    | 13                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 30                    | 30                    | 30                    |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.4                   | 3.0                   | 7.5                   | 7.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 169.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 202.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 209.0 | 139.0 | 130.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 212.0 | 142.0 | 133.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 9.0   | 3.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.9 ~ 2.2   | 3.4 ~ 4.1   | 7.0 ~ 7.7   | 6.6 ~ 7.3   |  |  |  |
| Average Voltage Gap  | V   |  | 24 ~ 42     | 62 ~ 75     | 94 ~ 107    | 63 ~ 74     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 123.0       | 79.5        | 67.4        | 58.0        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 70mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 954                   | 2181                  | 2182                  | 2183                  | 2184                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                    | 13                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 7.0                   | 3.0                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 16                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 34.0<br>(31.0 ~ 37.0) | 55.0<br>(53.0 ~ 57.0) | 77.0<br>(75.0 ~ 79.0) | 52.0<br>(50.0 ~ 54.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                    | 13                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 40                    | 20                    | 20                    |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.3                   | 2.9                   | 6.7                   | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 174.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 205.0 | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 214.0 | 142.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 217.0 | 145.0 | 135.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 72.0  | 10.0  | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.5 ~ 1.8   | 3.0 ~ 3.7   | 6.2 ~ 6.7   | 5.5 ~ 6.0   |  |  |  |
| Average Voltage Gap  | V   |  | 24 ~ 45     | 50 ~ 70     | 84 ~ 97     | 60 ~ 69     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 99.0        | 66.3        | 56.6        | 48.6        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 80mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 954                   | 2191                  | 2192                  | 2193                  | 2194                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 11                    | 13                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 8.0                   | 3.0                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 16                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(32.0 ~ 38.0) | 50.0<br>(48.0 ~ 52.0) | 70.0<br>(68.0 ~ 72.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 11                    | 11                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                    | 13                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 50                    | 20                    | 10                    |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.2                   | 2.8                   | 6.0                   | 4.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 178.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 210.0 | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 219.0 | 144.0 | 134.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 221.0 | 146.0 | 136.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 75.0  | 10.0  | 5.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.4 ~ 1.7   | 2.7 ~ 3.3   | 5.3 ~ 6.0   | 3.6 ~ 4.0   |  |  |  |
| Average Voltage Gap  | V   |  | 25 ~ 45     | 46 ~ 63     | 79 ~ 92     | 51 ~ 63     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 93.0        | 61.3        | 51.9        | 42.3        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 90mm               | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 955                   | 2201                  | 2202                  | 2203                  | 2204                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 12                    | 15                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 10.0                  | 3.0                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 6                     | 15                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 36.0<br>(33.0 ~ 39.0) | 47.0<br>(45.0 ~ 49.0) | 60.0<br>(58.0 ~ 62.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 11                    | 11                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                    | 13                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 40                    | 20                    | 10                    |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 1.0                   | 2.7                   | 5.1                   | 4.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 179.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 211.0 | 134.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 220.0 | 143.0 | 134.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 222.0 | 145.0 | 136.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 77.0  | 9.0   | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.1 ~ 1.4   | 2.9 ~ 3.6   | 4.5 ~ 5.1   | 3.6 ~ 4.0   |  |  |  |
| Average Voltage Gap  | V   |  | 25 ~ 43     | 42 ~ 52     | 75 ~ 90     | 52 ~ 64     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 75.0        | 54.2        | 45.6        | 38.0        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 100mm              | SPB     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 955                   | 2211                  | 2212                  | 2213                  | 2214                  |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | MP                    | LC                    | LA                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 12                    | 16                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 11.0                  | 3.0                   | 1.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 12                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 8                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 6                     | 15                    | 1                     | 1                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     | 4                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 38.0<br>(35.0 ~ 41.0) | 45.0<br>(43.0 ~ 47.0) | 60.0<br>(58.0 ~ 62.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 11                    | 11                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                    | 13                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 40                    | 20                    | 10                    |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.7                   | 2.6                   | 4.2                   | 4.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 180.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 214.0 | 134.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 222.0 | 142.0 | 134.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 225.0 | 145.0 | 137.0 | 133.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 80.0  | 8.0   | 4.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.0 ~ 1.3   | 3.2 ~ 3.9   | 3.6 ~ 4.3   | 3.6 ~ 4.0   |  |  |  |
| Average Voltage Gap  | V   |  | 25 ~ 42     | 32 ~ 46     | 70 ~ 86     | 52 ~ 65     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 69.0        | 52.1        | 42.7        | 36.0        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 9.0 ~ 11.0  | 3.2 ~ 3.8   | 2.0 ~ 2.4   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.08 ~ 1.80 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | WC-Co         | STD   |

Thickness 5 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 2401            | KL | 6.0 | 154.0  | 190.0 | 199.0 | 204.0 | 207.0 |     |     |     | 0.0       |
| 2                 | 2402            | KL | 5.0 | -      | 135.0 | 144.0 | 149.0 | 152.0 |     |     |     | 55.0      |
| 3                 | 2403            | LC | 8.0 | -      | -     | 132.0 | 137.0 | 140.0 |     |     |     | 12.0      |
| 4                 | 2404            | LC | 8.0 | -      | -     | -     | 131.0 | 134.0 |     |     |     | 6.0       |
| 5                 | 2405            | LC | 7.0 | -      | -     | -     | -     | 131.0 |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 13.0  | 6.0   | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.80  | 0.80  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 2411            | KL | 4.0 | 154.0  | 191.0 | 200.0 | 204.0 | 205.0 |     |     |     | 0.0       |
| 2                 | 2412            | KL | 5.0 | -      | 131.0 | 140.0 | 144.0 | 145.0 |     |     |     | 60.0      |
| 3                 | 2413            | LC | 7.0 | -      | -     | 132.0 | 136.0 | 137.0 |     |     |     | 8.0       |
| 4                 | 2414            | LC | 7.0 | -      | -     | -     | 131.0 | 132.0 |     |     |     | 5.0       |
| 5                 | 2415            | LC | 6.0 | -      | -     | -     | -     | 130.0 |     |     |     | 2.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 13.0  | 6.0   | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.80  | 0.80  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 2421            | KL | 2.5 | 154.0  | 195.0 | 206.0 | 208.0 | 209.0 |     |     |     | 0.0       |
| 2                 | 2422            | KL | 1.8 | -      | 130.0 | 141.0 | 143.0 | 144.0 |     |     |     | 65.0      |
| 3                 | 2423            | LC | 7.0 | -      | -     | 134.0 | 136.0 | 137.0 |     |     |     | 7.0       |
| 4                 | 2424            | LC | 6.0 | -      | -     | -     | 130.0 | 131.0 |     |     |     | 6.0       |
| 5                 | 2425            | LC | 6.0 | -      | -     | -     | -     | 130.0 |     |     |     | 1.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 13.0  | 6.0   | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.80  | 0.80  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | WC-Co         | STD   |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 2431            | RL | 2.0 | 160.0  | 198.0 | 223.0 | 232.0 | 233.0 | 239.0 |     |     | 0.0       |
| 2                 | 2432            | KL | 2.0 | -      | 133.0 | 158.0 | 167.0 | 168.0 | 174.0 |     |     | 65.0      |
| 3                 | 2433            | RL | 2.5 | -      | -     | 138.0 | 147.0 | 148.0 | 154.0 |     |     | 20.0      |
| 4                 | 2434            | LC | 5.5 | -      | -     | -     | 132.0 | 133.0 | 139.0 |     |     | 15.0      |
| 5                 | 2435            | LC | 5.7 | -      | -     | -     | -     | 130.0 | 136.0 |     |     | 3.0       |
| 6                 | 2436            | LC | 5.5 | -      | -     | -     | -     | -     | 135.0 |     |     | 1.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0 |        |       |       |       |       |       |     |     |           |
| 1                 | 2441            | RL | 1.5 | 164.0  | 200.0 | 223.0 | 232.0 | 234.0 | 240.0 |     |     | 0.0       |
| 2                 | 2442            | KL | 2.2 | -      | 135.0 | 158.0 | 167.0 | 169.0 | 175.0 |     |     | 65.0      |
| 3                 | 2443            | RL | 2.5 | -      | -     | 138.0 | 147.0 | 149.0 | 155.0 |     |     | 20.0      |
| 4                 | 2444            | LC | 5.5 | -      | -     | -     | 132.0 | 134.0 | 140.0 |     |     | 15.0      |
| 5                 | 2445            | LC | 5.5 | -      | -     | -     | -     | 130.0 | 136.0 |     |     | 4.0       |
| 6                 | 2446            | LC | 5.5 | -      | -     | -     | -     | -     | 135.0 |     |     | 1.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 953             | RH | 0.7 |        |       |       |       |       |       |     |     |           |
| 1                 | 2451            | RL | 1.2 | 165.0  | 196.0 | 231.0 | 241.0 | 242.0 | 244.0 |     |     | 0.0       |
| 2                 | 2452            | KL | 2.1 | -      | 131.0 | 166.0 | 176.0 | 177.0 | 179.0 |     |     | 65.0      |
| 3                 | 2453            | RL | 1.8 | -      | -     | 140.0 | 150.0 | 151.0 | 153.0 |     |     | 26.0      |
| 4                 | 2454            | LC | 5.2 | -      | -     | -     | 135.0 | 136.0 | 138.0 |     |     | 15.0      |
| 5                 | 2455            | LC | 5.2 | -      | -     | -     | -     | 131.0 | 133.0 |     |     | 5.0       |
| 6                 | 2456            | LC | 5.2 | -      | -     | -     | -     | -     | 131.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | WC-Co         | STD   |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 953             | RH | 0.7 |        |       |       |       |       |       |     |     |           |
| 1                 | 2461            | RL | 1.0 | 166.0  | 192.0 | 239.0 | 247.0 | 248.0 | 247.0 |     |     | 0.0       |
| 2                 | 2462            | KL | 2.0 | -      | 127.0 | 174.0 | 182.0 | 183.0 | 182.0 |     |     | 65.0      |
| 3                 | 2463            | RL | 1.2 | -      | -     | 142.0 | 150.0 | 151.0 | 150.0 |     |     | 32.0      |
| 4                 | 2464            | LC | 5.0 | -      | -     | -     | 136.0 | 137.0 | 136.0 |     |     | 14.0      |
| 5                 | 2465            | LC | 5.0 | -      | -     | -     | -     | 132.0 | 131.0 |     |     | 5.0       |
| 6                 | 2466            | LC | 5.0 | -      | -     | -     | -     | -     | 128.0 |     |     | 3.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |       |       |     |     |           |
| 1                 | 2471            | RL | 0.9 | 170.0  | 197.0 | 237.0 | 246.0 | 248.0 | 247.0 |     |     | 0.0       |
| 2                 | 2472            | KL | 1.7 | -      | 132.0 | 172.0 | 181.0 | 183.0 | 182.0 |     |     | 65.0      |
| 3                 | 2473            | RL | 1.2 | -      | -     | 140.0 | 149.0 | 151.0 | 150.0 |     |     | 32.0      |
| 4                 | 2474            | LC | 4.7 | -      | -     | -     | 135.0 | 137.0 | 136.0 |     |     | 14.0      |
| 5                 | 2475            | LC | 4.7 | -      | -     | -     | -     | 132.0 | 131.0 |     |     | 5.0       |
| 6                 | 2476            | LC | 4.7 | -      | -     | -     | -     | -     | 129.0 |     |     | 2.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |       |       |     |     |           |
| 1                 | 2481            | RL | 0.8 | 173.0  | 201.0 | 235.0 | 244.0 | 247.0 | 247.0 |     |     | 0.0       |
| 2                 | 2482            | KL | 1.5 | -      | 136.0 | 170.0 | 179.0 | 182.0 | 182.0 |     |     | 65.0      |
| 3                 | 2483            | RL | 1.2 | -      | -     | 138.0 | 147.0 | 150.0 | 150.0 |     |     | 32.0      |
| 4                 | 2484            | LC | 4.5 | -      | -     | -     | 133.0 | 136.0 | 136.0 |     |     | 14.0      |
| 5                 | 2485            | LC | 4.5 | -      | -     | -     | -     | 131.0 | 131.0 |     |     | 5.0       |
| 6                 | 2486            | LC | 4.5 | -      | -     | -     | -     | -     | 130.0 |     |     | 1.0       |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -     |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | WC-Co         | STD   |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |       |       |       |     |           |
| 1                 | 2491            | RL | 0.7 | 176.0  | 200.0 | 231.0 | 247.0 | 257.0 | 259.0 | 261.0 |     | 0.0       |
| 2                 | 2492            | KL | 2.2 | -      | 135.0 | 166.0 | 182.0 | 192.0 | 194.0 | 196.0 |     | 65.0      |
| 3                 | 2493            | RL | 1.3 | -      | -     | 137.0 | 153.0 | 163.0 | 165.0 | 167.0 |     | 29.0      |
| 4                 | 2494            | RL | 1.5 | -      | -     | -     | 133.0 | 143.0 | 145.0 | 147.0 |     | 20.0      |
| 5                 | 2495            | LC | 3.5 | -      | -     | -     | -     | 130.0 | 132.0 | 134.0 |     | 13.0      |
| 6                 | 2496            | LC | 4.5 | -      | -     | -     | -     | -     | 130.0 | 132.0 |     | 2.0       |
| 7                 | 2497            | LC | 3.5 | -      | -     | -     | -     | -     | -     | 129.0 |     | 3.0       |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.80  | 1.60  | 0.80  | 0.30  | 0.28  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |       |       |       |     |           |
| 1                 | 2501            | RL | 0.6 | 179.0  | 198.0 | 225.0 | 244.0 | 252.0 | 255.0 | 257.0 |     | 0.0       |
| 2                 | 2502            | KL | 3.0 | -      | 133.0 | 160.0 | 179.0 | 187.0 | 190.0 | 192.0 |     | 65.0      |
| 3                 | 2503            | RL | 1.5 | -      | -     | 135.0 | 154.0 | 162.0 | 165.0 | 167.0 |     | 25.0      |
| 4                 | 2504            | RL | 1.5 | -      | -     | -     | 134.0 | 142.0 | 145.0 | 147.0 |     | 20.0      |
| 5                 | 2505            | LC | 3.5 | -      | -     | -     | -     | 129.0 | 132.0 | 134.0 |     | 13.0      |
| 6                 | 2506            | LC | 4.5 | -      | -     | -     | -     | -     | 130.0 | 132.0 |     | 2.0       |
| 7                 | 2507            | LC | 3.5 | -      | -     | -     | -     | -     | -     | 129.0 |     | 3.0       |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 13.0  | 11.0  | 6.0   | 2.5   | 2.0   |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.80  | 1.60  | 0.80  | 0.30  | 0.28  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                   | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 2401                  | 2402                     | 2403                     | 2404                    | 2405                  |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                       | LC                      | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                       | SL                      | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 8                        | 10                       | 12                      | 14                    |       |       |       |
| Power Setting      | IP  | 7.0                   | 12.0                  | 7.0                      | 2.5                      | 2.0                     | 2.0                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 13                    | 8                        |                          |                         |                       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 10                       | 6                       | 1                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 2                        | 2                        | 1                       | 1                     |       |       |       |
| Stabilizer B       | SB  | 8                     | 9                     | 13                       | 10                       | 8                       | 8                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                        | 1                        | 1                       | 1                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                        | 1                       | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 70.0<br>(67.0 ~ 73.0) | 110.0<br>(108.0 ~ 112.0) | 105.0<br>(103.0 ~ 107.0) | 100.0<br>(98.0 ~ 102.0) | 90.0<br>(88.0 ~ 92.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | ON                      | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                       | OFF                      | OFF                     | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                       | 10                      | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 13                       | 13                      | 13                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                      | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                      | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                        | 4                       | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                      | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                       | 0                     |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 6.0                   | 5.0                      | 8.0                      | 8.0                     | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                     | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                     | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 154.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 190.0 | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 199.0 | 144.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 204.0 | 149.0 | 137.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 207.0 | 152.0 | 140.0 | 134.0 | 131.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 55.0  | 12.0  | 6.0   | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 7.5 ~ 9.2   | 7.8 ~ 9.5   | 7.1 ~ 7.9   | 7.1 ~ 7.9   | 6.4 ~ 7.0   |  |  |
| Average Voltage Gap  | V   |  | 63 ~ 78     | 100 ~ 116   | 106 ~ 121   | 100 ~ 119   | 88 ~ 109    |  |  |
| Avg. Linear Feedrate | ALF |  | 501.0       | 254.9       | 162.7       | 119.5       | 92.1        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 10mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                   | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-------------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 2411                  | 2412                    | 2413                  | 2414                  | 2415                  |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                      | LC                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                      | SL                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 8                       | 10                    | 14                    | 14                    |       |       |       |
| Power Setting      | IP  | 7.0                   | 12.0                  | 7.0                     | 2.5                   | 2.0                   | 2.0                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 13                    | 8                       |                       |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                       | 10                    | 6                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 2                       | 2                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 8                     | 9                     | 13                      | 10                    | 8                     | 8                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                       | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                       | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(57.0 ~ 63.0) | 100.0<br>(98.0 ~ 102.0) | 80.0<br>(78.0 ~ 82.0) | 75.0<br>(73.0 ~ 77.0) | 75.0<br>(73.0 ~ 77.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                     | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                      | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                      | 10                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                      | 13                    | 13                    | 13                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                      | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                      | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                       | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                      | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                       | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 4.0                   | 5.0                     | 7.0                   | 7.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                     | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                     | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 154.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 191.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 200.0 | 140.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 204.0 | 144.0 | 136.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 205.0 | 145.0 | 137.0 | 132.0 | 130.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 8.0   | 5.0   | 2.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 4.6 ~ 5.6   | 7.1 ~ 8.7   | 6.5 ~ 7.2   | 6.3 ~ 7.0   | 5.6 ~ 6.2   |  |  |
| Average Voltage Gap  | V   |  | 52 ~ 67     | 94 ~ 108    | 96 ~ 112    | 93 ~ 115    | 83 ~ 99     |  |  |
| Avg. Linear Feedrate | ALF |  | 306.0       | 186.0       | 128.0       | 96.9        | 76.1        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 2421                  | 2422                  | 2423                  | 2424                  | 2425                  |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                    | LC                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 8                     | 10                    | 14                    | 14                    |       |       |       |
| Power Setting      | IP  | 7.0                   | 12.0                  | 7.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 13                    | 8                     |                       |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                     | 10                    | 6                     | 4                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 2                     | 2                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 13                    | 10                    | 8                     | 8                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 47.0<br>(44.0 ~ 50.0) | 94.0<br>(92.0 ~ 96.0) | 90.0<br>(88.0 ~ 92.0) | 85.0<br>(83.0 ~ 87.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                    | 13                    | 13                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 2.5                   | 1.8                   | 7.0                   | 6.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 154.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 195.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 206.0 | 141.0 | 134.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 208.0 | 143.0 | 136.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 209.0 | 144.0 | 137.0 | 131.0 | 130.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 7.0   | 6.0   | 1.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 3.3 ~ 4.0   | 2.6 ~ 3.1   | 7.2 ~ 7.9   | 6.3 ~ 6.9   | 5.4 ~ 6.0   |  |  |
| Average Voltage Gap  | V   |  | 42 ~ 53     | 90 ~ 102    | 85 ~ 97     | 84 ~ 95     | 62 ~ 74     |  |  |
| Avg. Linear Feedrate | ALF |  | 219.0       | 96.0        | 79.2        | 66.0        | 55.3        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 30mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 952                   | 2431                  | 2432                  | 2433                  | 2434                  | 2435                  | 2436                  |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 8                     | 7                     | 10                    | 14                    | 16                    |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 3                     | 10                    | 10                    | 6                     | 4                     |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 2                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 38.0<br>(35.0 ~ 41.0) | 94.0<br>(92.0 ~ 96.0) | 60.0<br>(58.0 ~ 62.0) | 65.0<br>(63.0 ~ 67.0) | 58.0<br>(56.0 ~ 60.0) | 40.0<br>(38.0 ~ 42.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                    | 13                    | 13                    | 13                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.0                   | 2.0                   | 2.5                   | 5.5                   | 5.7                   | 5.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 160.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 198.0 | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 223.0 | 158.0 | 138.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 232.0 | 167.0 | 147.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 233.0 | 168.0 | 148.0 | 133.0 | 130.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 239.0 | 174.0 | 154.0 | 139.0 | 136.0 | 135.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 20.0  | 15.0  | 3.0   | 1.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 2.5 ~ 3.0   | 2.5 ~ 3.0   | 3.0 ~ 3.7   | 5.0 ~ 5.5   | 5.2 ~ 5.7   | 5.0 ~ 5.5   |  |
| Average Voltage Gap  | V   |  | 32 ~ 45     | 89 ~ 102    | 55 ~ 70     | 72 ~ 84     | 63 ~ 75     | 51 ~ 63     |  |
| Avg. Linear Feedrate | ALF |  | 165.0       | 82.5        | 58.5        | 49.3        | 42.9        | 37.7        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 40mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 952                   | 2441                  | 2442                  | 2443                  | 2444                  | 2445                  | 2446                  |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 8                     | 7                     | 10                    | 14                    | 16                    |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 3                     | 10                    | 10                    | 6                     | 4                     |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 2                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(27.0 ~ 33.0) | 95.0<br>(93.0 ~ 97.0) | 60.0<br>(58.0 ~ 62.0) | 65.0<br>(63.0 ~ 67.0) | 58.0<br>(56.0 ~ 60.0) | 40.0<br>(38.0 ~ 42.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                    | 13                    | 13                    | 13                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.5                   | 2.2                   | 2.5                   | 5.5                   | 5.5                   | 5.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 164.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 200.0 | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 223.0 | 158.0 | 138.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 232.0 | 167.0 | 147.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 234.0 | 169.0 | 149.0 | 134.0 | 130.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 240.0 | 175.0 | 155.0 | 140.0 | 136.0 | 135.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 20.0  | 15.0  | 4.0   | 1.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.7 ~ 2.1   | 2.4 ~ 2.9   | 2.9 ~ 3.5   | 5.0 ~ 5.5   | 5.0 ~ 5.6   | 5.0 ~ 5.6   |  |
| Average Voltage Gap  | V   |  | 22 ~ 38     | 89 ~ 103    | 52 ~ 64     | 72 ~ 84     | 65 ~ 76     | 51 ~ 63     |  |
| Avg. Linear Feedrate | ALF |  | 114.0       | 66.4        | 49.3        | 42.7        | 37.6        | 33.6        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 50mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 953                   | 2451                  | 2452                  | 2453                  | 2454                  | 2455                  | 2456                  |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 8                     | 7                     | 10                    | 14                    | 15                    |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 3                     | 10                    | 10                    | 6                     | 4                     |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 2                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 3                     | 12                    | 10                    | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 29.0<br>(26.0 ~ 32.0) | 90.0<br>(88.0 ~ 92.0) | 51.0<br>(49.0 ~ 53.0) | 67.0<br>(65.0 ~ 69.0) | 51.0<br>(49.0 ~ 53.0) | 35.0<br>(33.0 ~ 37.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                    | 13                    | 13                    | 13                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.2                   | 2.1                   | 1.8                   | 5.2                   | 5.2                   | 5.2                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 165.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 196.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 231.0 | 166.0 | 140.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 241.0 | 176.0 | 150.0 | 135.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 242.0 | 177.0 | 151.0 | 136.0 | 131.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 244.0 | 179.0 | 153.0 | 138.0 | 133.0 | 131.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 26.0  | 15.0  | 5.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.4 ~ 1.7   | 2.3 ~ 2.9   | 2.2 ~ 2.7   | 4.7 ~ 5.2   | 4.7 ~ 5.2   | 4.7 ~ 5.2   |  |
| Average Voltage Gap  | V   |  | 23 ~ 36     | 84 ~ 98     | 42 ~ 57     | 65 ~ 77     | 58 ~ 68     | 38 ~ 50     |  |
| Avg. Linear Feedrate | ALF |  | 93.0        | 58.3        | 41.7        | 36.6        | 32.6        | 29.4        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 60mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 953                   | 2461                  | 2462                  | 2463                  | 2464                  | 2465                  | 2466                  |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 8                     | 7                     | 10                    | 14                    | 14                    |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 3                     | 10                    | 10                    | 6                     | 4                     |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 2                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 3                     | 12                    | 10                    | 10                    | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 28.0<br>(25.0 ~ 31.0) | 86.0<br>(84.0 ~ 88.0) | 43.0<br>(41.0 ~ 45.0) | 70.0<br>(68.0 ~ 72.0) | 45.0<br>(43.0 ~ 47.0) | 30.0<br>(28.0 ~ 32.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                    | 13                    | 13                    | 13                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.0                   | 2.0                   | 1.2                   | 5.0                   | 5.0                   | 5.0                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 166.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 192.0 | 127.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 239.0 | 174.0 | 142.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 247.0 | 182.0 | 150.0 | 136.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 248.0 | 183.0 | 151.0 | 137.0 | 132.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 247.0 | 182.0 | 150.0 | 136.0 | 131.0 | 128.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 32.0  | 14.0  | 5.0   | 3.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 1.1 ~ 1.3   | 2.3 ~ 2.8   | 1.6 ~ 2.0   | 4.2 ~ 4.6   | 4.4 ~ 4.9   | 4.2 ~ 4.6   |  |
| Average Voltage Gap  | V   |  | 24 ~ 35     | 79 ~ 94     | 33 ~ 51     | 58 ~ 71     | 49 ~ 61     | 26 ~ 38     |  |
| Avg. Linear Feedrate | ALF |  | 72.0        | 49.0        | 33.7        | 29.9        | 27.0        | 24.5        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 70mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 954                   | 2471                  | 2472                  | 2473                  | 2474                  | 2475                  | 2476                  |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 8                     | 7                     | 10                    | 14                    | 14                    |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 3                     | 10                    | 10                    | 6                     | 4                     |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 2                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 3                     | 12                    | 10                    | 9                     | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 34.0<br>(31.0 ~ 37.0) | 86.0<br>(84.0 ~ 88.0) | 42.0<br>(40.0 ~ 44.0) | 67.0<br>(65.0 ~ 69.0) | 42.0<br>(40.0 ~ 44.0) | 30.0<br>(28.0 ~ 32.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                    | 13                    | 13                    | 13                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.9                   | 1.7                   | 1.2                   | 4.7                   | 4.7                   | 4.7                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 170.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 197.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 237.0 | 172.0 | 140.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 246.0 | 181.0 | 149.0 | 135.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 248.0 | 183.0 | 151.0 | 137.0 | 132.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 247.0 | 182.0 | 150.0 | 136.0 | 131.0 | 129.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 32.0  | 14.0  | 5.0   | 2.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.9 ~ 1.2   | 2.1 ~ 2.5   | 1.5 ~ 1.8   | 4.1 ~ 4.6   | 4.2 ~ 4.6   | 4.1 ~ 4.6   |  |
| Average Voltage Gap  | V   |  | 27 ~ 40     | 79 ~ 94     | 34 ~ 49     | 52 ~ 74     | 45 ~ 57     | 31 ~ 42     |  |
| Avg. Linear Feedrate | ALF |  | 63.0        | 43.3        | 30.1        | 27.0        | 24.5        | 22.4        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 80mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 954                   | 2481                  | 2482                  | 2483                  | 2484                  | 2485                  | 2486                  |       |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |       |
| Voltage Open       | Vo  | 7                     | 4                     | 8                     | 7                     | 10                    | 14                    | 14                    |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                   | 2.0                   |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 3                     | 10                    | 10                    | 6                     | 4                     |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 2                     | 2                     | 2                     | 1                     | 1                     |       |       |
| Stabilizer B       | SB  | 7                     | 3                     | 12                    | 10                    | 8                     | 8                     | 8                     |       |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 86.0<br>(84.0 ~ 88.0) | 42.0<br>(40.0 ~ 44.0) | 65.0<br>(63.0 ~ 67.0) | 40.0<br>(38.0 ~ 42.0) | 40.0<br>(38.0 ~ 42.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                    | 13                    | 13                    | 13                    |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.8                   | 1.5                   | 1.2                   | 4.5                   | 4.5                   | 4.5                   |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 173.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 201.0 | 136.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 235.0 | 170.0 | 138.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 244.0 | 179.0 | 147.0 | 133.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 247.0 | 182.0 | 150.0 | 136.0 | 131.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 247.0 | 182.0 | 150.0 | 136.0 | 131.0 | 130.0 | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 32.0  | 14.0  | 5.0   | 1.0   |       |       |

| RESULTS              |     |  |             |             |             |             |             |             |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.0   | 1.9 ~ 2.3   | 1.4 ~ 1.7   | 4.1 ~ 4.5   | 4.0 ~ 4.4   | 4.1 ~ 4.5   |  |
| Average Voltage Gap  | V   |  | 30 ~ 46     | 80 ~ 94     | 35 ~ 48     | 66 ~ 78     | 42 ~ 53     | 36 ~ 47     |  |
| Avg. Linear Feedrate | ALF |  | 54.0        | 37.8        | 26.9        | 24.3        | 22.2        | 20.4        |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 90mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|
| E-pack Number      | Eno | 955                   | 2491                  | 2492                  | 2493                  | 2494                  | 2495                  | 2496                  | 2497                  |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | RL                    | LC                    | LC                    | LC                    |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |
| Voltage Open       | Vo  | 7                     | 4                     | 8                     | 7                     | 7                     | 10                    | 14                    | 15                    |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   |       |
| IP adjust          | ΔIP | 11                    | 13                    | 10                    | 8                     | 8                     |                       |                       |                       |       |
| Off Time           | OFF | 6                     | 4                     | 3                     | 10                    | 8                     | 10                    | 6                     | 4                     |       |
| Stabilizer A       | SA  | 3                     | 9                     | 6                     | 5                     | 4                     | 2                     | 1                     | 1                     |       |
| Stabilizer B       | SB  | 6                     | 3                     | 12                    | 10                    | 8                     | 8                     | 8                     | 8                     |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 83.0<br>(81.0 ~ 85.0) | 41.0<br>(39.0 ~ 43.0) | 52.0<br>(50.0 ~ 54.0) | 56.0<br>(54.0 ~ 58.0) | 37.0<br>(35.0 ~ 39.0) | 32.0<br>(30.0 ~ 34.0) |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                    | 13                    | 13                    | 13                    | 13                    |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4                     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |
| Feedrate Address   | FA  | 0.5                   | 0.7                   | 2.2                   | 1.3                   | 1.5                   | 3.5                   | 4.5                   | 3.5                   |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 176.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 200.0 | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 231.0 | 166.0 | 137.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 247.0 | 182.0 | 153.0 | 133.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 257.0 | 192.0 | 163.0 | 143.0 | 130.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 259.0 | 194.0 | 165.0 | 145.0 | 132.0 | 130.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 261.0 | 196.0 | 167.0 | 147.0 | 134.0 | 132.0 | 129.0 | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 29.0  | 20.0  | 13.0  | 2.0   | 3.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.7 ~ 0.9   | 2.3 ~ 2.8   | 1.4 ~ 1.7   | 3.2 ~ 4.0   | 3.5 ~ 3.9   | 4.0 ~ 4.4   | 3.1 ~ 3.5   |
| Average Voltage Gap  | V   |  | 29 ~ 47     | 79 ~ 93     | 32 ~ 48     | 49 ~ 65     | 47 ~ 59     | 36 ~ 47     | 30 ~ 42     |
| Avg. Linear Feedrate | ALF |  | 48.0        | 36.5        | 26.2        | 23.4        | 21.2        | 19.5        | 17.8        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 1.44 ~ 2.40 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 100mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|
| E-pack Number      | Eno | 955                   | 2501                  | 2502                  | 2503                  | 2504                  | 2505                  | 2506                  | 2507                  |       |
| Power Supply       | PS  | RH                    | RL                    | KL                    | RL                    | RL                    | LC                    | LC                    | LC                    |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    |       |
| Voltage Open       | Vo  | 7                     | 4                     | 8                     | 7                     | 7                     | 10                    | 14                    | 15                    |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   |       |
| IP adjust          | ΔIP | 11                    | 14                    | 10                    | 8                     | 8                     |                       |                       |                       |       |
| Off Time           | OFF | 6                     | 4                     | 3                     | 10                    | 8                     | 10                    | 6                     | 4                     |       |
| Stabilizer A       | SA  | 3                     | 9                     | 6                     | 5                     | 4                     | 2                     | 1                     | 1                     |       |
| Stabilizer B       | SB  | 6                     | 3                     | 12                    | 10                    | 8                     | 8                     | 8                     | 8                     |       |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 80.0<br>(78.0 ~ 82.0) | 40.0<br>(38.0 ~ 42.0) | 40.0<br>(38.0 ~ 42.0) | 58.0<br>(56.0 ~ 60.0) | 35.0<br>(33.0 ~ 37.0) | 32.0<br>(30.0 ~ 34.0) |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | ON                    | OFF                   | OFF                   | OFF                   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 13                    | 13                    | 13                    | 13                    | 13                    |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4                     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    |       |
| Feedrate Address   | FA  | 0.5                   | 0.6                   | 3.0                   | 1.5                   | 1.5                   | 3.5                   | 4.5                   | 3.5                   |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 179.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 198.0 | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 225.0 | 160.0 | 135.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 244.0 | 179.0 | 154.0 | 134.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 252.0 | 187.0 | 162.0 | 142.0 | 129.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 255.0 | 190.0 | 165.0 | 145.0 | 132.0 | 130.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 257.0 | 192.0 | 167.0 | 147.0 | 134.0 | 132.0 | 129.0 | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 25.0  | 20.0  | 13.0  | 2.0   | 3.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.6 ~ 0.7   | 2.8 ~ 3.4   | 1.5 ~ 1.8   | 3.0 ~ 3.7   | 3.1 ~ 3.4   | 4.0 ~ 4.4   | 3.1 ~ 3.5   |
| Average Voltage Gap  | V   |  | 28 ~ 49     | 78 ~ 93     | 29 ~ 48     | 33 ~ 52     | 53 ~ 66     | 36 ~ 48     | 30 ~ 42     |
| Avg. Linear Feedrate | ALF |  | 39.0        | 32.2        | 24.3        | 21.7        | 19.5        | 18.1        | 16.6        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 9.9 ~ 12.1  | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 1.44 ~ 2.40 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | Cu            | STD   |

Thickness 5 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 2601            | KH | 7.0  | 178.0  | 205.0 | 222.0 | 232.0 |     |     |     |     | 0.0       |
| 2                 | 2602            | KH | 9.0  | -      | 140.0 | 157.0 | 167.0 |     |     |     |     | 65.0      |
| 3                 | 2603            | LC | 14.0 | -      | -     | 132.0 | 142.0 |     |     |     |     | 25.0      |
| 4                 | 2604            | LC | 13.5 | -      | -     | -     | 130.0 |     |     |     |     | 12.0      |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 2611            | KH | 5.0  | 174.0  | 205.0 | 218.0 | 223.0 |     |     |     |     | 0.0       |
| 2                 | 2612            | KH | 6.0  | -      | 140.0 | 153.0 | 158.0 |     |     |     |     | 65.0      |
| 3                 | 2613            | LC | 13.5 | -      | -     | 131.0 | 136.0 |     |     |     |     | 22.0      |
| 4                 | 2614            | LC | 13.0 | -      | -     | -     | 129.0 |     |     |     |     | 7.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 2621            | KH | 4.0  | 171.0  | 208.0 | 219.0 | 223.0 |     |     |     |     | 0.0       |
| 2                 | 2622            | KH | 4.0  | -      | 138.0 | 149.0 | 153.0 |     |     |     |     | 70.0      |
| 3                 | 2623            | LC | 13.0 | -      | -     | 131.0 | 135.0 |     |     |     |     | 18.0      |
| 4                 | 2624            | LC | 12.5 | -      | -     | -     | 129.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | Cu            | STD   |

Thickness 30 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 2631            | KH | 3.0  | 173.0  | 209.0 | 219.0 | 222.0 |     |     |     |     | 0.0       |
| 2                 | 2632            | KH | 3.5  | -      | 139.0 | 149.0 | 152.0 |     |     |     |     | 70.0      |
| 3                 | 2633            | LC | 11.2 | -      | -     | 132.0 | 135.0 |     |     |     |     | 17.0      |
| 4                 | 2634            | LC | 10.7 | -      | -     | -     | 129.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 2641            | KH | 2.0 | 175.0  | 210.0 | 220.0 | 222.0 |     |     |     |     | 0.0       |
| 2                 | 2642            | KH | 3.0 | -      | 140.0 | 150.0 | 152.0 |     |     |     |     | 70.0      |
| 3                 | 2643            | LC | 9.5 | -      | -     | 134.0 | 136.0 |     |     |     |     | 16.0      |
| 4                 | 2644            | LC | 9.0 | -      | -     | -     | 130.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 953             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 2651            | KH | 2.0 | 176.0  | 212.0 | 221.0 | 223.0 |     |     |     |     | 0.0       |
| 2                 | 2652            | KH | 3.0 | -      | 140.0 | 149.0 | 151.0 |     |     |     |     | 72.0      |
| 3                 | 2653            | LC | 8.5 | -      | -     | 134.0 | 136.0 |     |     |     |     | 15.0      |
| 4                 | 2654            | LC | 8.0 | -      | -     | -     | 130.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | Cu            | STD   |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 953             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 2661            | KH | 1.5 | 177.0  | 215.0 | 224.0 | 226.0 |     |     |     |     | 0.0       |
| 2                 | 2662            | KH | 3.0 | -      | 140.0 | 149.0 | 151.0 |     |     |     |     | 75.0      |
| 3                 | 2663            | LC | 7.5 | -      | -     | 135.0 | 137.0 |     |     |     |     | 14.0      |
| 4                 | 2664            | LC | 7.0 | -      | -     | -     | 131.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 2671            | KH | 1.4 | 182.0  | 216.0 | 225.0 | 227.0 |     |     |     |     | 0.0       |
| 2                 | 2672            | KH | 3.0 | -      | 139.0 | 148.0 | 150.0 |     |     |     |     | 77.0      |
| 3                 | 2673            | LC | 6.7 | -      | -     | 134.0 | 136.0 |     |     |     |     | 14.0      |
| 4                 | 2674            | LC | 6.2 | -      | -     | -     | 130.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 2681            | KH | 1.3 | 187.0  | 218.0 | 228.0 | 230.0 |     |     |     |     | 0.0       |
| 2                 | 2682            | KH | 3.0 | -      | 138.0 | 148.0 | 150.0 |     |     |     |     | 80.0      |
| 3                 | 2683            | LC | 6.0 | -      | -     | 134.0 | 136.0 |     |     |     |     | 14.0      |
| 4                 | 2684            | LC | 5.5 | -      | -     | -     | 130.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | Cu            | STD   |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 2691            | KH | 1.3 | 185.0  | 225.0 | 236.0 | 239.0 |     |     |     |     | 0.0       |
| 2                 | 2692            | KH | 3.0 | -      | 140.0 | 151.0 | 154.0 |     |     |     |     | 85.0      |
| 3                 | 2693            | LC | 5.5 | -      | -     | 133.0 | 136.0 |     |     |     |     | 18.0      |
| 4                 | 2694            | LC | 5.0 | -      | -     | -     | 130.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 2701            | KH | 1.1 | 184.0  | 233.0 | 246.0 | 249.0 |     |     |     |     | 0.0       |
| 2                 | 2702            | KH | 3.0 | -      | 143.0 | 156.0 | 159.0 |     |     |     |     | 90.0      |
| 3                 | 2703            | LC | 5.0 | -      | -     | 133.0 | 136.0 |     |     |     |     | 23.0      |
| 4                 | 2704            | LC | 4.5 | -      | -     | -     | 130.0 |     |     |     |     | 6.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Cu            | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 2601                  | 2602                     | 2603                     | 2604                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | LC                       | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 9                        | 9                        | 11                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 11.0                  | 5.0                      | 3.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                        | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 2                        | 2                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 3                     | 10                       | 9                        | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 78.0<br>(75.0 ~ 81.0) | 120.0<br>(118.0 ~ 122.0) | 105.0<br>(103.0 ~ 107.0) | 85.0<br>(83.0 ~ 87.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 10                       | 9                        | 9                     |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 12                    | 4                        | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 7.0                   | 9.0                      | 14.0                     | 13.5                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 178.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 205.0 | 140.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 222.0 | 157.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 232.0 | 167.0 | 142.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 25.0  | 12.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 12.2 ~ 14.9 | 15.7 ~ 19.1 | 13.6 ~ 15.0 | 12.5 ~ 13.9 |  |  |  |
| Average Voltage Gap  | V   |  | 73 ~ 88     | 113 ~ 127   | 109 ~ 121   | 101 ~ 116   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 813.0       | 457.1       | 298.2       | 216.6       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Cu            | 10mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                   | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 2611                  | 2612                     | 2613                    | 2614                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | LC                      | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                      | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 9                        | 10                      | 11                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 11.0                  | 5.0                      | 3.0                     | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        |                         |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                       | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 2                        | 2                       | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 3                     | 10                       | 9                       | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                       | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                       | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 74.0<br>(71.0 ~ 77.0) | 115.0<br>(113.0 ~ 117.0) | 100.0<br>(98.0 ~ 102.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                     | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                     | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 10                       | 9                       | 9                     |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                      | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                      | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                      | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                       | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                      | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                       | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 5.0                   | 6.0                      | 13.5                    | 13.0                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                     | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                     | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 174.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 205.0 | 140.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 218.0 | 153.0 | 131.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 223.0 | 158.0 | 136.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 22.0  | 7.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 7.9 ~ 9.7   | 11.2 ~ 15.9 | 13.3 ~ 14.7 | 12.4 ~ 13.6 |  |  |  |
| Average Voltage Gap  | V   |  | 66 ~ 80     | 113 ~ 127   | 112 ~ 125   | 102 ~ 119   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 528.0       | 320.1       | 231.8       | 178.7       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Cu            | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 2621                  | 2622                     | 2623                     | 2624                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | LC                       | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 9                        | 11                       | 12                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 11.0                  | 5.0                      | 3.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                        | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 2                        | 2                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 10                       | 9                        | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 66.0<br>(63.0 ~ 69.0) | 105.0<br>(103.0 ~ 107.0) | 105.0<br>(103.0 ~ 107.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 10                       | 9                        | 9                     |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 4.0                   | 4.0                      | 13.0                     | 12.5                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 171.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 208.0 | 138.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 219.0 | 149.0 | 131.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 223.0 | 153.0 | 135.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 18.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 5.6 ~ 6.8   | 8.0 ~ 9.8   | 12.7 ~ 14.1 | 12.0 ~ 13.2 |  |  |  |
| Average Voltage Gap  | V   |  | 59 ~ 73     | 104 ~ 118   | 113 ~ 126   | 97 ~ 113    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 372.0       | 219.3       | 172.3       | 140.3       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Cu            | 30mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 952                   | 2631                  | 2632                     | 2633                     | 2634                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | LC                       | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 9                        | 11                       | 12                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 5.0                      | 3.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        |                          |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                        | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 2                        | 2                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 10                       | 9                        | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 65.0<br>(62.0 ~ 68.0) | 104.0<br>(102.0 ~ 106.0) | 102.0<br>(100.0 ~ 104.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                       | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 3.0                   | 3.5                      | 11.2                     | 10.7                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 173.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 209.0 | 139.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 219.0 | 149.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 222.0 | 152.0 | 135.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 17.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 4.4 ~ 5.5   | 6.9 ~ 8.5   | 11.0 ~ 12.2 | 10.3 ~ 11.3 |  |  |  |
| Average Voltage Gap  | V   |  | 58 ~ 72     | 102 ~ 117   | 111 ~ 124   | 93 ~ 107    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 297.0       | 180.8       | 143.5       | 117.5       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Cu            | 40mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                   | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 952                   | 2641                  | 2642                     | 2643                    | 2644                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | LC                      | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                      | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 9                        | 11                      | 13                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 5.0                      | 3.0                     | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                       |                         |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                       | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 3                        | 2                       | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 10                       | 9                       | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                       | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                       | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 64.0<br>(61.0 ~ 67.0) | 104.0<br>(102.0 ~ 106.0) | 100.0<br>(98.0 ~ 102.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                     | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                     | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                      | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                      | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                      | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                      | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                       | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                      | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                       | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.0                   | 3.0                      | 9.5                     | 9.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                     | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                     | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 175.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 210.0 | 140.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 220.0 | 150.0 | 134.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 222.0 | 152.0 | 136.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 16.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.3 ~ 4.1   | 5.9 ~ 7.2   | 9.3 ~ 10.3  | 8.6 ~ 9.4   |  |  |  |
| Average Voltage Gap  | V   |  | 57 ~ 71     | 100 ~ 116   | 109 ~ 122   | 89 ~ 102    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 222.0       | 141.9       | 114.3       | 94.3        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Cu            | 50mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 953                   | 2651                  | 2652                     | 2653                  | 2654                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 9                        | 11                    | 13                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 5.0                      | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                       |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 3                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 63.0<br>(60.0 ~ 66.0) | 102.0<br>(100.0 ~ 104.0) | 97.0<br>(95.0 ~ 99.0) | 77.0<br>(75.0 ~ 79.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 2.0                   | 3.0                      | 8.5                   | 8.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 176.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 212.0 | 140.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 221.0 | 149.0 | 134.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 223.0 | 151.0 | 136.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 72.0  | 15.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.7 ~ 3.4   | 5.4 ~ 6.5   | 8.3 ~ 9.2   | 7.6 ~ 8.5   |  |  |  |
| Average Voltage Gap  | V   |  | 54 ~ 70     | 94 ~ 115    | 105 ~ 121   | 88 ~ 104    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 183.0       | 121.0       | 98.3        | 81.7        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Cu            | 60mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                   | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 953                   | 2661                  | 2662                    | 2663                  | 2664                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                      | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                      | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 9                       | 12                    | 14                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 5.0                     | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                      |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                       | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 3                       | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                      | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                       | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                       | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 62.0<br>(59.0 ~ 65.0) | 100.0<br>(98.0 ~ 102.0) | 95.0<br>(93.0 ~ 97.0) | 75.0<br>(73.0 ~ 77.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                     | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                     | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                      | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                      | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                      | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                      | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                       | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                      | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                       | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.5                   | 3.0                     | 7.5                   | 7.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                     | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                     | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 177.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 215.0 | 140.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 224.0 | 149.0 | 135.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 226.0 | 151.0 | 137.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 75.0  | 14.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.2 ~ 2.6   | 4.9 ~ 5.9   | 7.3 ~ 8.1   | 6.8 ~ 7.5   |  |  |  |
| Average Voltage Gap  | V   |  | 52 ~ 69     | 92 ~ 113    | 102 ~ 120   | 88 ~ 106    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 144.0       | 99.7        | 82.0        | 68.8        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Cu            | 70mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                  | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 954                   | 2671                  | 2672                   | 2673                  | 2674                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                     | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                     | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 9                      | 12                    | 14                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 5.0                    | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                     |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                      | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 3                      | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                     | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                      | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                      | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 61.0<br>(58.0 ~ 64.0) | 98.0<br>(96.0 ~ 100.0) | 92.0<br>(90.0 ~ 94.0) | 72.0<br>(70.0 ~ 74.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                    | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                     | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                     | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                     | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                     | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                      | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                     | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                      | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.4                   | 3.0                    | 6.7                   | 6.2                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                    | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                    | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 182.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 216.0 | 139.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 225.0 | 148.0 | 134.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 227.0 | 150.0 | 136.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 77.0  | 14.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.9 ~ 2.3   | 4.9 ~ 5.9   | 6.6 ~ 7.3   | 6.0 ~ 6.7   |  |  |  |
| Average Voltage Gap  | V   |  | 52 ~ 69     | 91 ~ 114    | 94 ~ 112    | 80 ~ 96     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 126.0       | 90.7        | 74.5        | 62.3        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Cu            | 80mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 954                   | 2681                  | 2682                  | 2683                  | 2684                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 9                     | 12                    | 14                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 5.0                   | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 11                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                     | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                    | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 60.0<br>(57.0 ~ 63.0) | 96.0<br>(94.0 ~ 98.0) | 90.0<br>(88.0 ~ 92.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.3                   | 3.0                   | 6.0                   | 5.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 187.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 218.0 | 138.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 228.0 | 148.0 | 134.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 230.0 | 150.0 | 136.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 80.0  | 14.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.6 ~ 2.0   | 4.9 ~ 5.9   | 5.8 ~ 6.5   | 5.3 ~ 5.9   |  |  |  |
| Average Voltage Gap  | V   |  | 52 ~ 68     | 91 ~ 106    | 91 ~ 104    | 72 ~ 86     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 108.0       | 81.0        | 66.4        | 55.5        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Cu            | 90mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 955                   | 2691                  | 2692                  | 2693                  | 2694                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 9                     | 13                    | 15                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 5.0                   | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 11                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                     | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 4                     | 10                    | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 59.0<br>(56.0 ~ 62.0) | 96.0<br>(94.0 ~ 98.0) | 82.0<br>(80.0 ~ 84.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 1.3                   | 3.0                   | 5.5                   | 5.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 185.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 225.0 | 140.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 236.0 | 151.0 | 133.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 239.0 | 154.0 | 136.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 18.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.5 ~ 1.9   | 3.6 ~ 4.4   | 5.3 ~ 5.9   | 4.9 ~ 5.4   |  |  |  |
| Average Voltage Gap  | V   |  | 51 ~ 67     | 89 ~ 105    | 86 ~ 100    | 66 ~ 80     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 102.0       | 71.6        | 59.0        | 49.5        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Cu            | 100mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 955                   | 2701                  | 2702                  | 2703                  | 2704                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                    | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 9                     | 14                    | 16                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 5.0                   | 3.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 11                    |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                     | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 7                     | 3                     | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 3                     | 10                    | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 58.0<br>(55.0 ~ 61.0) | 96.0<br>(94.0 ~ 98.0) | 75.0<br>(73.0 ~ 77.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                    | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 1.1                   | 3.0                   | 5.0                   | 4.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 184.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 233.0 | 143.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 246.0 | 156.0 | 133.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 249.0 | 159.0 | 136.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 23.0  | 6.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.4 ~ 1.7   | 2.4 ~ 2.9   | 4.8 ~ 5.4   | 4.4 ~ 4.8   |  |  |  |
| Average Voltage Gap  | V   |  | 51 ~ 66     | 87 ~ 104    | 81 ~ 96     | 60 ~ 74     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 93.0        | 58.7        | 49.2        | 41.8        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | Al            | STD   |

Thickness 5 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 2731            | KL | 13.0 | 162.0  | 206.0 | 222.0 | 232.0 |     |     |     |     | 0.0       |
| 2                 | 2732            | KL | 10.0 | -      | 141.0 | 157.0 | 167.0 |     |     |     |     | 65.0      |
| 3                 | 2733            | LC | 16.0 | -      | -     | 132.0 | 142.0 |     |     |     |     | 25.0      |
| 4                 | 2734            | LC | 15.5 | -      | -     | -     | 130.0 |     |     |     |     | 12.0      |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 2741            | KL | 10.0 | 161.0  | 211.0 | 227.0 | 231.0 |     |     |     |     | 0.0       |
| 2                 | 2742            | KL | 8.0  | -      | 141.0 | 157.0 | 161.0 |     |     |     |     | 70.0      |
| 3                 | 2743            | LC | 16.0 | -      | -     | 132.0 | 136.0 |     |     |     |     | 25.0      |
| 4                 | 2744            | LC | 15.5 | -      | -     | -     | 129.0 |     |     |     |     | 7.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 951             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 2751            | KL | 8.0  | 164.0  | 211.0 | 223.0 | 228.0 |     |     |     |     | 0.0       |
| 2                 | 2752            | KL | 7.0  | -      | 141.0 | 153.0 | 158.0 |     |     |     |     | 70.0      |
| 3                 | 2753            | LC | 14.0 | -      | -     | 133.0 | 138.0 |     |     |     |     | 20.0      |
| 4                 | 2754            | LC | 13.5 | -      | -     | -     | 131.0 |     |     |     |     | 7.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | Al            | STD   |

Thickness 30 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 2761            | KL | 6.5  | 157.0  | 219.0 | 231.0 | 237.0 |     |     |     |     | 0.0       |
| 2                 | 2762            | KL | 6.5  | -      | 142.0 | 154.0 | 160.0 |     |     |     |     | 77.0      |
| 3                 | 2763            | LC | 12.5 | -      | -     | 132.0 | 138.0 |     |     |     |     | 22.0      |
| 4                 | 2764            | LC | 11.7 | -      | -     | -     | 130.0 |     |     |     |     | 8.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 952             | RH | 1.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 2771            | KL | 5.0  | 151.0  | 228.0 | 242.0 | 249.0 |     |     |     |     | 0.0       |
| 2                 | 2772            | KL | 6.0  | -      | 143.0 | 157.0 | 164.0 |     |     |     |     | 85.0      |
| 3                 | 2773            | LC | 11.0 | -      | -     | 132.0 | 139.0 |     |     |     |     | 25.0      |
| 4                 | 2774            | LC | 10.0 | -      | -     | -     | 130.0 |     |     |     |     | 9.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 953             | RH | 0.7  |        |       |       |       |     |     |     |     |           |
| 1                 | 2781            | KL | 4.5  | 167.0  | 228.0 | 243.0 | 249.0 |     |     |     |     | 0.0       |
| 2                 | 2782            | KL | 5.5  | -      | 143.0 | 158.0 | 164.0 |     |     |     |     | 85.0      |
| 3                 | 2783            | LC | 10.0 | -      | -     | 132.0 | 138.0 |     |     |     |     | 26.0      |
| 4                 | 2784            | LC | 9.2  | -      | -     | -     | 130.0 |     |     |     |     | 8.0       |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | Al            | STD   |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 953             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 2791            | KL | 4.0 | 183.0  | 228.0 | 245.0 | 251.0 |     |     |     |     | 0.0       |
| 2                 | 2792            | KL | 5.0 | -      | 143.0 | 160.0 | 166.0 |     |     |     |     | 85.0      |
| 3                 | 2793            | LC | 9.0 | -      | -     | 132.0 | 138.0 |     |     |     |     | 28.0      |
| 4                 | 2794            | LC | 8.5 | -      | -     | -     | 130.0 |     |     |     |     | 8.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 2801            | KL | 3.5 | 175.0  | 229.0 | 248.0 | 254.0 |     |     |     |     | 0.0       |
| 2                 | 2802            | KL | 5.0 | -      | 142.0 | 161.0 | 167.0 |     |     |     |     | 87.0      |
| 3                 | 2803            | LC | 8.5 | -      | -     | 133.0 | 139.0 |     |     |     |     | 28.0      |
| 4                 | 2804            | LC | 8.0 | -      | -     | -     | 131.0 |     |     |     |     | 8.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 954             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 2811            | KH | 3.0 | 187.0  | 232.0 | 252.0 | 258.0 |     |     |     |     | 0.0       |
| 2                 | 2812            | KH | 5.0 | -      | 142.0 | 162.0 | 168.0 |     |     |     |     | 90.0      |
| 3                 | 2813            | LC | 8.0 | -      | -     | 134.0 | 140.0 |     |     |     |     | 28.0      |
| 4                 | 2814            | LC | 7.5 | -      | -     | -     | 132.0 |     |     |     |     | 8.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | Al            | STD   |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 2821            | KH | 3.0 | 186.0  | 234.0 | 254.0 | 260.0 |     |     |     |     | 0.0       |
| 2                 | 2822            | KH | 5.0 | -      | 142.0 | 162.0 | 168.0 |     |     |     |     | 92.0      |
| 3                 | 2823            | LC | 7.5 | -      | -     | 134.0 | 140.0 |     |     |     |     | 28.0      |
| 4                 | 2824            | LC | 7.0 | -      | -     | -     | 132.0 |     |     |     |     | 8.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 2831            | KH | 3.0 | 185.0  | 236.0 | 257.0 | 263.0 |     |     |     |     | 0.0       |
| 2                 | 2832            | KH | 5.0 | -      | 141.0 | 162.0 | 168.0 |     |     |     |     | 95.0      |
| 3                 | 2833            | LC | 7.0 | -      | -     | 134.0 | 140.0 |     |     |     |     | 28.0      |
| 4                 | 2834            | LC | 6.5 | -      | -     | -     | 132.0 |     |     |     |     | 8.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 125 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 2841            | KH | 2.5 | 189.0  | 238.0 | 256.0 | 261.0 |     |     |     |     | 0.0       |
| 2                 | 2842            | KH | 4.5 | -      | 143.0 | 161.0 | 166.0 |     |     |     |     | 95.0      |
| 3                 | 2843            | LC | 6.5 | -      | -     | 133.0 | 138.0 |     |     |     |     | 28.0      |
| 4                 | 2844            | LC | 6.0 | -      | -     | -     | 130.0 |     |     |     |     | 8.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | Al            | STD   |

Thickness 150 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 955             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 2851            | KH | 2.0 | 193.0  | 240.0 | 255.0 | 260.0 |     |     |     |     | 0.0       |
| 2                 | 2852            | KH | 4.0 | -      | 145.0 | 160.0 | 165.0 |     |     |     |     | 95.0      |
| 3                 | 2853            | LC | 6.0 | -      | -     | 132.0 | 137.0 |     |     |     |     | 28.0      |
| 4                 | 2854            | LC | 5.5 | -      | -     | -     | 129.0 |     |     |     |     | 8.0       |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Al            | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                   | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 2731                  | 2732                     | 2733                    | 2734                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                      | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                      | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                       | 6                     |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 5.0                      | 2.0                     | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 8                     | 9                        |                         |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                       | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 2                        | 2                       | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 7                        | 9                       | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                       | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                       | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 72.0<br>(69.0 ~ 75.0) | 130.0<br>(128.0 ~ 132.0) | 100.0<br>(98.0 ~ 102.0) | 90.0<br>(88.0 ~ 92.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                     | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                     | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                      | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                      | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                      | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                      | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 12                    | 4                        | 4                       | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                      | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                       | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 13.0                  | 10.0                     | 16.0                    | 15.5                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                      | 1.0                     | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                      | 1.0                     | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 162.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 206.0 | 141.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 222.0 | 157.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 232.0 | 167.0 | 142.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 25.0  | 12.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 20.2 ~ 24.8 | 15.6 ~ 19.0 | 15.5 ~ 17.1 | 15.3 ~ 16.9 |  |  |  |
| Average Voltage Gap  | V   |  | 64 ~ 82     | 123 ~ 139   | 107 ~ 122   | 99 ~ 114    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 1350.0      | 586.8       | 366.8       | 265.8       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Al            | 10mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 2741                  | 2742                     | 2743                  | 2744                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                     | 6                     |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 5.0                      | 2.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 8                     | 9                        |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 2                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 62.0<br>(59.0 ~ 65.0) | 124.0<br>(122.0 ~ 126.0) | 90.0<br>(88.0 ~ 92.0) | 85.0<br>(83.0 ~ 87.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 10.0                  | 8.0                      | 16.0                  | 15.5                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 161.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 211.0 | 141.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 227.0 | 157.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 231.0 | 161.0 | 136.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 25.0  | 7.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 15.2 ~ 18.6 | 13.4 ~ 16.4 | 15.4 ~ 17.0 | 15.0 ~ 16.6 |  |  |  |
| Average Voltage Gap  | V   |  | 54 ~ 69     | 118 ~ 131   | 97 ~ 110    | 86 ~ 101    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 1014.0      | 475.1       | 319.1       | 238.8       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Al            | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 951                   | 2751                  | 2752                     | 2753                  | 2754                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 9                     | 6                     |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 5.0                      | 2.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                       |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 2                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 56.0<br>(53.0 ~ 59.0) | 120.0<br>(118.0 ~ 122.0) | 95.0<br>(93.0 ~ 97.0) | 90.0<br>(88.0 ~ 92.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 8.0                   | 7.0                      | 14.0                  | 13.5                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 164.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 211.0 | 141.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 223.0 | 153.0 | 133.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 228.0 | 158.0 | 138.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 20.0  | 7.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 12.4 ~ 15.2 | 11.6 ~ 14.2 | 13.6 ~ 15.0 | 13.3 ~ 14.7 |  |  |  |
| Average Voltage Gap  | V   |  | 43 ~ 61     | 114 ~ 129   | 100 ~ 114   | 107 ~ 122   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 828.0       | 400.0       | 272.8       | 205.9       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Al            | 30mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 952                   | 2761                  | 2762                     | 2763                  | 2764                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 9                     | 7                     |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 5.0                      | 2.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 10                       |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 2                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 58.0<br>(55.0 ~ 61.0) | 117.0<br>(115.0 ~ 119.0) | 87.0<br>(85.0 ~ 89.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 6.5                   | 6.5                      | 12.5                  | 11.7                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 157.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 219.0 | 142.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 231.0 | 154.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 237.0 | 160.0 | 138.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 77.0  | 22.0  | 8.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 9.5 ~ 11.8  | 10.0 ~ 12.2 | 12.1 ~ 13.5 | 11.5 ~ 12.7 |  |  |  |
| Average Voltage Gap  | V   |  | 47 ~ 64     | 110 ~ 125   | 92 ~ 106    | 97 ~ 111    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 639.0       | 326.1       | 228.9       | 174.0       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Al            | 40mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 952                   | 2771                  | 2772                     | 2773                  | 2774                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 10                    | 9                     |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 6.0                      | 2.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 9                        |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 60.0<br>(57.0 ~ 63.0) | 114.0<br>(112.0 ~ 116.0) | 80.0<br>(78.0 ~ 82.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 5.0                   | 6.0                      | 11.0                  | 10.0                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 151.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 228.0 | 143.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 242.0 | 157.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 249.0 | 164.0 | 139.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 25.0  | 9.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 6.6 ~ 8.5   | 8.4 ~ 10.2  | 10.7 ~ 11.9 | 9.7 ~ 10.7  |  |  |  |
| Average Voltage Gap  | V   |  | 51 ~ 67     | 107 ~ 121   | 85 ~ 99     | 87 ~ 101    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 453.0       | 250.0       | 182.7       | 140.7       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Al            | 50mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 953                   | 2781                  | 2782                     | 2783                  | 2784                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 11                    | 9                     |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 6.0                      | 2.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 9                        |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 62.0<br>(59.0 ~ 65.0) | 112.0<br>(110.0 ~ 114.0) | 75.0<br>(73.0 ~ 77.0) | 75.0<br>(73.0 ~ 77.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 4.5                   | 5.5                      | 10.0                  | 9.2                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 167.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 228.0 | 143.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 243.0 | 158.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 249.0 | 164.0 | 138.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 26.0  | 8.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 5.0 ~ 6.4   | 8.5 ~ 10.3  | 9.9 ~ 10.9  | 9.0 ~ 10.0  |  |  |  |
| Average Voltage Gap  | V   |  | 53 ~ 70     | 104 ~ 120   | 82 ~ 97     | 84 ~ 98     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 342.0       | 212.9       | 158.7       | 124.2       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Al            | 60mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 953                   | 2791                  | 2792                     | 2793                  | 2794                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 12                    | 10                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 12.0                  | 6.0                      | 2.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 4                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 65.0<br>(62.0 ~ 68.0) | 110.0<br>(108.0 ~ 112.0) | 70.0<br>(68.0 ~ 72.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 4.0                   | 5.0                      | 9.0                   | 8.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 183.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 228.0 | 143.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 245.0 | 160.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 251.0 | 166.0 | 138.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 28.0  | 8.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.5 ~ 4.3   | 8.6 ~ 10.4  | 9.0 ~ 9.8   | 8.4 ~ 9.3   |  |  |  |
| Average Voltage Gap  | V   |  | 56 ~ 74     | 102 ~ 119   | 80 ~ 96     | 81 ~ 96     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 234.0       | 165.9       | 128.2       | 103.3       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Al            | 70mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 954                   | 2801                  | 2802                     | 2803                  | 2804                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KL                    | KL                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 12                    | 10                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 6.0                      | 2.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                       |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 65.0<br>(62.0 ~ 68.0) | 105.0<br>(103.0 ~ 107.0) | 70.0<br>(68.0 ~ 72.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 3.5                   | 5.0                      | 8.5                   | 8.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 175.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 229.0 | 142.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 248.0 | 161.0 | 133.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 254.0 | 167.0 | 139.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 87.0  | 28.0  | 8.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.3 ~ 4.0   | 8.2 ~ 10.0  | 8.3 ~ 9.1   | 7.8 ~ 8.6   |  |  |  |
| Average Voltage Gap  | V   |  | 55 ~ 74     | 97 ~ 113    | 77 ~ 92     | 79 ~ 93     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 219.0       | 156.3       | 120.3       | 96.7        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Al            | 80mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                   | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 954                   | 2811                  | 2812                    | 2813                  | 2814                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                      | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                      | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                      | 12                    | 11                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 6.0                     | 2.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 11                      |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                       | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                       | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                      | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                       | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                       | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 66.0<br>(63.0 ~ 69.0) | 100.0<br>(98.0 ~ 102.0) | 70.0<br>(68.0 ~ 72.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                     | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                     | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                      | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                      | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                      | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                      | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                       | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                      | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                       | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 3.0                   | 5.0                     | 8.0                   | 7.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                     | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                     | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 187.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 232.0 | 142.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 252.0 | 162.0 | 134.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 258.0 | 168.0 | 140.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 28.0  | 8.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.1 ~ 3.8   | 7.9 ~ 9.7   | 7.6 ~ 8.4   | 7.2 ~ 7.9   |  |  |  |
| Average Voltage Gap  | V   |  | 55 ~ 74     | 92 ~ 107    | 74 ~ 88     | 77 ~ 91     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 207.0       | 148.7       | 113.5       | 90.8        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Al            | 90mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 955                   | 2821                  | 2822                     | 2823                  | 2824                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 12                    | 11                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 6.0                      | 2.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 11                       |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 64.0<br>(61.0 ~ 67.0) | 103.0<br>(101.0 ~ 105.0) | 65.0<br>(63.0 ~ 67.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 3.0                   | 5.0                      | 7.5                   | 7.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 186.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 234.0 | 142.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 254.0 | 162.0 | 134.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 260.0 | 168.0 | 140.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 92.0  | 28.0  | 8.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.9 ~ 3.6   | 6.9 ~ 8.9   | 7.2 ~ 7.9   | 6.8 ~ 7.4   |  |  |  |
| Average Voltage Gap  | V   |  | 54 ~ 72     | 95 ~ 110    | 69 ~ 83     | 72 ~ 87     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 195.0       | 138.2       | 105.9       | 84.8        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Al            | 100mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 955                   | 2831                  | 2832                     | 2833                  | 2834                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 12                    | 11                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 6.0                      | 2.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 11                       |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 62.0<br>(59.0 ~ 65.0) | 106.0<br>(104.0 ~ 108.0) | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 3.0                   | 5.0                      | 7.0                   | 6.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 185.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 236.0 | 141.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 257.0 | 162.0 | 134.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 263.0 | 168.0 | 140.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 95.0  | 28.0  | 8.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.8 ~ 3.4   | 6.7 ~ 8.1   | 6.7 ~ 7.4   | 6.3 ~ 6.9   |  |  |  |
| Average Voltage Gap  | V   |  | 54 ~ 70     | 98 ~ 114    | 65 ~ 79     | 68 ~ 83     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 186.0       | 131.1       | 100.1       | 79.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Al            | 125mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 955                   | 2841                  | 2842                     | 2843                  | 2844                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 12                    | 11                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 6.0                      | 2.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 11                       |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 2                        | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 4                     | 10                       | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 61.0<br>(58.0 ~ 64.0) | 102.0<br>(100.0 ~ 104.0) | 52.0<br>(50.0 ~ 54.0) | 52.0<br>(50.0 ~ 54.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 2.5                   | 4.5                      | 6.5                   | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 189.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 238.0 | 143.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 256.0 | 161.0 | 133.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 261.0 | 166.0 | 138.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 95.0  | 28.0  | 8.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.4 ~ 2.8   | 6.3 ~ 7.6   | 6.2 ~ 6.8   | 5.8 ~ 6.4   |  |  |  |
| Average Voltage Gap  | V   |  | 52 ~ 69     | 94 ~ 110    | 57 ~ 71     | 60 ~ 75     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 156.0       | 113.5       | 87.9        | 70.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | Al            | 150mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                  | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 955                   | 2851                  | 2852                   | 2853                  | 2854                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                     | LC                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                     | SL                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                     | 13                    | 11                    |       |       |       |       |
| Power Setting      | IP  | 8.0                   | 11.0                  | 6.0                    | 2.0                   | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 11                     |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                      | 9                     | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 2                      | 2                     | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 4                     | 10                     | 9                     | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                      | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                      | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 60.0<br>(57.0 ~ 63.0) | 98.0<br>(96.0 ~ 100.0) | 45.0<br>(43.0 ~ 47.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                    | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                     | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 10                    | 13                     | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                     | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                     | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                      | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                     | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                      | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 2.0                   | 4.0                    | 6.0                   | 5.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                    | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                    | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 193.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 240.0 | 145.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 255.0 | 160.0 | 132.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 260.0 | 165.0 | 137.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 95.0  | 28.0  | 8.0   |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.9 ~ 2.3   | 5.9 ~ 7.2   | 5.7 ~ 6.3   | 5.3 ~ 5.9   |  |  |  |
| Average Voltage Gap  | V   |  | 50 ~ 69     | 91 ~ 107    | 50 ~ 64     | 53 ~ 67     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 126.0       | 95.4        | 75.4        | 61.6        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R

## Digest

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| 0.25BS             | Graphite      | Class1 |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 951             | RH | 2.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2901            | RL | 2.5 | 179.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 951             | RH | 2.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2911            | RL | 2.0 | 180.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 952             | RH | 1.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2921            | RL | 1.6 | 181.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

|                    |               |        |
|--------------------|---------------|--------|
| Wire Dia. and Type | Material Type | Class  |
| 0.25BS             | Graphite      | Class1 |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 952             | RH | 1.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2931            | RL | 1.5 | 182.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 953             | RH | 0.7 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2941            | RL | 1.2 | 182.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 953             | RH | 0.7 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2951            | RL | 1.0 | 183.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R

## Digest

|                    |               |        |
|--------------------|---------------|--------|
| Wire Dia. and Type | Material Type | Class  |
| 0.25BS             | Graphite      | Class1 |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 954             | RH | 0.6 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2961            | RL | 0.8 | 184.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 954             | RH | 0.6 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2971            | RL | 0.8 | 185.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 955             | RH | 0.5 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2981            | RL | 0.7 | 186.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R

## Digest

|                    |               |        |
|--------------------|---------------|--------|
| Wire Dia. and Type | Material Type | Class  |
| 0.25BS             | Graphite      | Class1 |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 955             | RH | 0.5 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2991            | RL | 0.7 | 186.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 2                 |                 |    |    | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |    | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |    | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |    | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |    | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |    | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 2                 |                 |    |    | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |    | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |    | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |    | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |    | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |    | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| 0.25BS             | Graphite      | Class2 |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 951             | RH | 2.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2902            | RL | 2.7 | 178.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 951             | RH | 2.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2912            | RL | 2.2 | 176.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 952             | RH | 1.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2922            | RL | 1.8 | 178.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| 0.25BS             | Graphite      | Class2 |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 952             | RH | 1.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2932            | RL | 1.7 | 182.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 953             | RH | 0.7 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2942            | RL | 1.4 | 180.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 953             | RH | 0.7 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2952            | RL | 1.2 | 180.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R

## Digest

|                    |               |        |
|--------------------|---------------|--------|
| Wire Dia. and Type | Material Type | Class  |
| 0.25BS             | Graphite      | Class2 |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 954             | RH | 0.6 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2962            | RL | 1.0 | 181.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 954             | RH | 0.6 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2972            | RL | 1.0 | 183.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 955             | RH | 0.5 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2982            | RL | 0.8 | 185.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R

## Digest

|                    |               |        |
|--------------------|---------------|--------|
| Wire Dia. and Type | Material Type | Class  |
| 0.25BS             | Graphite      | Class2 |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 955             | RH | 0.5 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2992            | RL | 0.8 | 187.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 8.0    |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.00   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 2                 |                 |    |    | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |    | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |    | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |    | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |    | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |    | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 2                 |                 |    |    | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |    | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |    | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |    | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |    | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |    | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R

## Digest

|                    |               |        |
|--------------------|---------------|--------|
| Wire Dia. and Type | Material Type | Class  |
| 0.25BS             | Graphite      | Class3 |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 951             | RH | 2.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2903            | RL | 4.0 | 179.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 951             | RH | 2.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2913            | RL | 3.5 | 179.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 952             | RH | 1.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2923            | RL | 2.5 | 180.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| 0.25BS             | Graphite      | Class3 |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 952             | RH | 1.0 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2933            | RL | 2.0 | 181.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 953             | RH | 0.7 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2943            | RL | 1.8 | 180.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 953             | RH | 0.7 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2953            | RL | 1.6 | 180.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R

## Digest

|                    |               |        |
|--------------------|---------------|--------|
| Wire Dia. and Type | Material Type | Class  |
| 0.25BS             | Graphite      | Class3 |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 954             | RH | 0.6 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2963            | RL | 1.4 | 184.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 954             | RH | 0.6 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2973            | RL | 1.4 | 188.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 955             | RH | 0.5 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2983            | RL | 1.2 | 188.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R

## Digest

|                    |               |        |
|--------------------|---------------|--------|
| Wire Dia. and Type | Material Type | Class  |
| 0.25BS             | Graphite      | Class3 |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|-----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA  | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 | 955             | RH | 0.5 |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 | 2993            | RL | 1.2 | 188.0  |     |     |     |     |     |     |     |     |      | 0                 |
| 2                 |                 |    |     | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |     | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |     | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |     | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |     | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |     | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |     | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz  | 11.0   |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra  | 1.50   |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 2                 |                 |    |    | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |    | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |    | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |    | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |    | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |    | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 2                 |                 |    |    | —      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |    | —      | —   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |    | —      | —   | —   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |    | —      | —   | —   | —   |     |     |     |     |     |      |                   |
| 6                 |                 |    |    | —      | —   | —   | —   | —   |     |     |     |     |      |                   |
| 7                 |                 |    |    | —      | —   | —   | —   | —   | —   |     |     |     |      |                   |
| 8                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   |     |     |      |                   |
| 9                 |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   |     |      |                   |
| 10                |                 |    |    | —      | —   | —   | —   | —   | —   | —   | —   | —   |      |                   |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |



## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.25BS             | Graphite      | 10mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 951               | 2901              |        | 2902              |        | 2903              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 7.0               | 9.0               |        | 10.0              |        | 12.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 10                |        | 10                |        | 13                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 8                 | 15                |        | 14                |        | 12                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 60.0<br>(58 ~ 62) | 70.0<br>(67 ~ 73) |        | 70.0<br>(67 ~ 73) |        | 75.0<br>(72 ~ 78) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 9                 | 10                |        | 10                |        | 10                |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 12                |        | 12                |        | 12                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 2.0               | 2.5               |        | 2.7               |        | 4.0               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 179.0 |  | 178.0 |  | 179.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 5.1 ~ 5.4   |  | 5.1 ~ 5.5   |  | 8.5 ~ 8.7   |  |  |  |  |
| Average Voltage Gap  | V   |  | 74 ~ 77     |  | 74 ~ 78     |  | 79 ~ 83     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 51.0        |  | 51.0        |  | 85.0        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.25BS             | Graphite      | 20mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 951               | 2911              |        | 2912              |        | 2913              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 7.0               | 9.0               |        | 10.0              |        | 12.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 11                |        | 11                |        | 14                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 8                 | 15                |        | 14                |        | 12                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 60.0<br>(58 ~ 62) | 70.0<br>(67 ~ 73) |        | 70.0<br>(67 ~ 73) |        | 65.0<br>(62 ~ 68) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 9                 | 10                |        | 10                |        | 10                |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 2.0               | 2.0               |        | 2.2               |        | 3.5               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 180.0 |  | 176.0 |  | 179.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 2.9 ~ 3.3   |  | 4.5 ~ 4.9   |  | 5.9 ~ 6.9   |  |  |  |  |
| Average Voltage Gap  | V   |  | 61 ~ 72     |  | 66 ~ 77     |  | 69 ~ 72     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 58.0        |  | 90.0        |  | 118.0       |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1 = ED-3, Class2 = ED-3, Class3 = Ex70.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.25BS             | Graphite      | 30mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 952               | 2921              |        | 2922              |        | 2923              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 8.0               | 9.0               |        | 10.0              |        | 12.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 11                |        | 12                |        | 14                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 8                 | 15                |        | 14                |        | 12                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 60.0<br>(57 ~ 63) |        | 65.0<br>(62 ~ 68) |        | 60.0<br>(57 ~ 63) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 9                 | 10                |        | 10                |        | 10                |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 1.0               | 1.6               |        | 1.8               |        | 2.5               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 181.0 |  | 178.0 |  | 180.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 1.1 ~ 2.5   |  | 3.3 ~ 3.6   |  | 3.8 ~ 4.7   |  |  |  |  |
| Average Voltage Gap  | V   |  | 58 ~ 63     |  | 60 ~ 67     |  | 62 ~ 65     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 33.0        |  | 99.0        |  | 114.0       |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.25BS             | Graphite      | 40mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 952               | 2931              |        | 2932              |        | 2933              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 8.0               | 9.0               |        | 10.0              |        | 12.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 12                |        | 13                |        | 14                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 8                 | 15                |        | 14                |        | 12                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 50.0<br>(47 ~ 53) |        | 60.0<br>(57 ~ 63) |        | 60.0<br>(57 ~ 63) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 9                 | 10                |        | 10                |        | 10                |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 1.0               | 1.5               |        | 1.7               |        | 2.0               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 182.0 |  | 182.0 |  | 181.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.9 ~ 2.1   |  | 2.2 ~ 2.9   |  | 2.8 ~ 3.4   |  |  |  |  |
| Average Voltage Gap  | V   |  | 44 ~ 50     |  | 53 ~ 56     |  | 57 ~ 64     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 36.0        |  | 88.0        |  | 112.0       |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.25BS             | Graphite      | 50mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 953               | 2941              |        | 2942              |        | 2943              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 8.0               | 9.0               |        | 10.0              |        | 12.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 12                |        | 13                |        | 14                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 7                 | 15                |        | 14                |        | 12                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 45.0<br>(42 ~ 48) |        | 50.0<br>(47 ~ 53) |        | 55.0<br>(52 ~ 58) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 9                 | 10                |        | 10                |        | 10                |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 0.7               | 1.2               |        | 1.4               |        | 1.8               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 182.0 |  | 180.0 |  | 180.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.7   |  | 1.4 ~ 2.3   |  | 2.1 ~ 2.7   |  |  |  |  |
| Average Voltage Gap  | V   |  | 45 ~ 50     |  | 42 ~ 55     |  | 55 ~ 64     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 40.0        |  | 70.0        |  | 105.0       |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.25BS             | Graphite      | 60mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 953               | 2951              |        | 2952              |        | 2953              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 8.0               | 10.0              |        | 11.0              |        | 12.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 12                |        | 13                |        | 14                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 7                 | 15                |        | 14                |        | 12                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 45.0<br>(42 ~ 48) |        | 45.0<br>(42 ~ 48) |        | 50.0<br>(47 ~ 53) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 9                 | 10                |        | 10                |        | 10                |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 0.7               | 1.0               |        | 1.2               |        | 1.6               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 183.0 |  | 180.0 |  | 180.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.7 ~ 1.3   |  | 0.8 ~ 1.6   |  | 1.5 ~ 2.0   |  |  |  |  |
| Average Voltage Gap  | V   |  | 45 ~ 51     |  | 45 ~ 50     |  | 54 ~ 65     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 42.0        |  | 48.0        |  | 90.0        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.25BS             | Graphite      | 70mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 954               | 2961              |        | 2962              |        | 2963              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 8.0               | 10.0              |        | 11.0              |        | 12.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 12                |        | 13                |        | 14                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 7                 | 15                |        | 14                |        | 12                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 45.0<br>(42 ~ 48) |        | 50.0<br>(47 ~ 53) |        | 55.0<br>(52 ~ 58) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 9                 | 10                |        | 10                |        | 10                |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 0.6               | 0.8               |        | 1.0               |        | 1.4               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 184.0 |  | 181.0 |  | 184.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.7 ~ 1.2   |  | 0.8 ~ 1.2   |  | 1.2 ~ 1.6   |  |  |  |  |
| Average Voltage Gap  | V   |  | 46 ~ 52     |  | 48 ~ 55     |  | 52 ~ 61     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 49.0        |  | 56.0        |  | 84.0        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.25BS             | Graphite      | 80mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 954               | 2971              |        | 2972              |        | 2973              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 8.0               | 10.0              |        | 11.0              |        | 12.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 12                |        | 13                |        | 14                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 7                 | 15                |        | 14                |        | 12                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 50.0<br>(47 ~ 53) |        | 60.0<br>(57 ~ 63) |        | 60.0<br>(57 ~ 63) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 9                 | 10                |        | 10                |        | 10                |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 0.6               | 0.8               |        | 1.0               |        | 1.4               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 185.0 |  | 183.0 |  | 188.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.7 ~ 1.2   |  | 0.8 ~ 1.1   |  | 0.9 ~ 1.2   |  |  |  |  |
| Average Voltage Gap  | V   |  | 48 ~ 55     |  | 54 ~ 65     |  | 49 ~ 62     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 56.0        |  | 64.0        |  | 72.0        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)



## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.25BS             | Graphite      | 90mm               | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 955               | 2981              |        | 2982              |        | 2983              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 8.0               | 10.0              |        | 10.0              |        | 11.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 12                |        | 12                |        | 13                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 6                 | 15                |        | 14                |        | 14                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 55.0<br>(52 ~ 58) |        | 60.0<br>(57 ~ 63) |        | 60.0<br>(57 ~ 63) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 9                 | 10                |        | 10                |        | 10                |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 0.5               | 0.7               |        | 0.8               |        | 1.2               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 186.0 |  | 185.0 |  | 188.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.6 ~ 1.2   |  | 0.7 ~ 1.2   |  | 0.9 ~ 1.1   |  |  |  |  |
| Average Voltage Gap  | V   |  | 51 ~ 57     |  | 55 ~ 60     |  | 51 ~ 58     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 54.0        |  | 63.0        |  | 81.0        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|----------|------------|---------------------|--------|
|                    |               |                    |          |            | Upper               | Lower  |
| 0.25BS             | Graphite      | 100mm              | Standard | φ4.0mm     | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   |  |  |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--|--|--|--|
| E-pack Number      | Eno      | 955               | 2991              |        | 2992              |        | 2993              |  |  |  |  |
| Power Supply       | PS       | RH                | RL                |        | RL                |        | RL                |  |  |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 6                 |        | 6                 |        | 6                 |  |  |  |  |
| Power Setting      | IP       | 8.0               | 10.0              |        | 7.0               |        | 11.0              |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 12                |        | 10                |        | 13                |  |  |  |  |
| Off Time           | OFF      | 6                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 1                 |        | 1                 |        | 1                 |  |  |  |  |
| Stabilizer B       | SB       | 6                 | 15                |        | 16                |        | 14                |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                 |        | 3                 |        | 3                 |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 5                 |        | 5                 |        | 5                 |  |  |  |  |
| Voltage Gap        | VG       | 50.0<br>(48 ~ 52) | 60.0<br>(57 ~ 63) |        | 60.0<br>(57 ~ 63) |        | 60.0<br>(57 ~ 63) |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |  |  |  |  |
| Wire Speed         | WS       | 8                 | 9                 |        | 9                 |        | 9                 |  |  |  |  |
| Wire Tension       | WT       | 9                 | 10                |        | 10                |        | 10                |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                |        | NM                |        | NM                |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 14                |        | 14                |        | 14                |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |  |  |  |  |
| Feedrate Address   | FA       | 0.5               | 0.7               |        | 0.8               |        | 1.2               |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 8.0               |        | 8.0               |        | 8.0               |  |  |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |  |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|--|--|--|--|
| Rough Cut       | ----- | 186.0 |  | 187.0 |  | 188.0 |  |  |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |  |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.4 ~ 0.8   |  | 0.6 ~ 1.5   |  | 0.9 ~ 1.3   |  |  |  |  |
| Average Voltage Gap  | V   |  | 55 ~ 61     |  | 55 ~ 65     |  | 55 ~ 62     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 40.0        |  | 60.0        |  | 90.0        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 8.0 ~ 9.0   |  | 8.0 ~ 9.0   |  | 11.0 ~ 13.0 |  |  |  |  |
|                      | Ra  |  | 1.00 ~ 1.20 |  | 1.00 ~ 1.20 |  | 1.50 ~ 1.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -3 or -4 on monitor screen.)  
 (Class1=ED-3,Class2=ED-3,Class3=Ex70.)

**5-3 ø0.30 Wire**  
**Machining Characteristics Data**

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.30BS            | STEEL         | STD   |

Thickness 5 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 961             | RH | 2.0  |        |       |       |       |       |     |     |     |           |
| 1                 | 3001            | RH | 9.0  | 182.0  | 231.0 | 266.0 | 278.0 | 282.0 |     |     |     | 0.0       |
| 2                 | 3002            | RH | 12.0 | -      | 158.0 | 193.0 | 205.0 | 209.0 |     |     |     | 73.0      |
| 3                 | 3003            | RH | 10.0 | -      | -     | 158.0 | 170.0 | 174.0 |     |     |     | 35.0      |
| 4                 | 3004            | LC | 14.0 | -      | -     | -     | 158.0 | 162.0 |     |     |     | 12.0      |
| 5                 | 3005            | LC | 12.0 | -      | -     | -     | -     | 158.0 |     |     |     | 4.0       |
| 6                 |                 |    |      | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |      | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 961             | RH | 2.0  |        |       |       |       |       |     |     |     |           |
| 1                 | 3011            | RH | 6.0  | 188.0  | 238.0 | 270.0 | 285.0 | 288.0 |     |     |     | 0.0       |
| 2                 | 3012            | RH | 10.0 | -      | 158.0 | 190.0 | 205.0 | 208.0 |     |     |     | 80.0      |
| 3                 | 3013            | RH | 8.0  | -      | -     | 155.0 | 170.0 | 173.0 |     |     |     | 35.0      |
| 4                 | 3014            | LC | 14.0 | -      | -     | -     | 158.0 | 161.0 |     |     |     | 12.0      |
| 5                 | 3015            | LC | 12.0 | -      | -     | -     | -     | 157.0 |     |     |     | 4.0       |
| 6                 |                 |    |      | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 961             | RH | 2.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 3021            | RH | 4.0 | 191.0  | 234.0 | 265.0 | 282.0 | 286.0 |     |     |     | 0.0       |
| 2                 | 3022            | RH | 7.0 | -      | 154.0 | 185.0 | 202.0 | 206.0 |     |     |     | 80.0      |
| 3                 | 3023            | RH | 8.0 | -      | -     | 155.0 | 172.0 | 176.0 |     |     |     | 30.0      |
| 4                 | 3024            | LC | 8.0 | -      | -     | -     | 160.0 | 164.0 |     |     |     | 12.0      |
| 5                 | 3025            | LC | 8.0 | -      | -     | -     | -     | 159.0 |     |     |     | 5.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.30BS            | STEEL         | STD   |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 962             | RH | 1.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 3031            | RH | 3.0 | 196.0  | 238.0 | 271.0 | 287.0 | 291.0 |     |     |     | 0.0       |
| 2                 | 3032            | RH | 6.0 | -      | 153.0 | 186.0 | 202.0 | 206.0 |     |     |     | 85.0      |
| 3                 | 3033            | RH | 7.0 | -      | -     | 156.0 | 172.0 | 176.0 |     |     |     | 30.0      |
| 4                 | 3034            | LC | 7.5 | -      | -     | -     | 160.0 | 164.0 |     |     |     | 12.0      |
| 5                 | 3035            | LC | 7.5 | -      | -     | -     | -     | 159.0 |     |     |     | 5.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 962             | RH | 1.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 3041            | RH | 2.0 | 200.0  | 243.0 | 277.0 | 292.0 | 296.0 |     |     |     | 0.0       |
| 2                 | 3042            | RH | 5.0 | -      | 153.0 | 187.0 | 202.0 | 206.0 |     |     |     | 90.0      |
| 3                 | 3043            | RH | 6.0 | -      | -     | 157.0 | 172.0 | 176.0 |     |     |     | 30.0      |
| 4                 | 3044            | LC | 7.0 | -      | -     | -     | 160.0 | 164.0 |     |     |     | 12.0      |
| 5                 | 3045            | LC | 7.0 | -      | -     | -     | -     | 159.0 |     |     |     | 5.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 963             | RH | 0.7 |        |       |       |       |       |     |     |     |           |
| 1                 | 3051            | RH | 1.7 | 201.0  | 243.0 | 277.0 | 292.0 | 296.0 |     |     |     | 0.0       |
| 2                 | 3052            | RH | 4.5 | -      | 153.0 | 187.0 | 202.0 | 206.0 |     |     |     | 90.0      |
| 3                 | 3053            | RH | 5.5 | -      | -     | 157.0 | 172.0 | 176.0 |     |     |     | 30.0      |
| 4                 | 3054            | LC | 7.0 | -      | -     | -     | 158.0 | 162.0 |     |     |     | 14.0      |
| 5                 | 3055            | LC | 7.0 | -      | -     | -     | -     | 157.0 |     |     |     | 5.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.30BS            | STEEL         | STD   |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 963             | RH | 0.7 |        |       |       |       |       |     |     |     |           |
| 1                 | 3061            | RH | 1.5 | 203.0  | 243.0 | 277.0 | 293.0 | 297.0 |     |     |     | 0.0       |
| 2                 | 3062            | RH | 4.0 | -      | 153.0 | 187.0 | 203.0 | 207.0 |     |     |     | 90.0      |
| 3                 | 3063            | RH | 5.0 | -      | -     | 157.0 | 173.0 | 177.0 |     |     |     | 30.0      |
| 4                 | 3064            | LC | 7.0 | -      | -     | -     | 157.0 | 161.0 |     |     |     | 16.0      |
| 5                 | 3065            | LC | 7.0 | -      | -     | -     | -     | 156.0 |     |     |     | 5.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 964             | RH | 0.6 |        |       |       |       |       |     |     |     |           |
| 1                 | 3071            | RH | 1.4 | 204.0  | 245.0 | 279.0 | 295.0 | 299.0 |     |     |     | 0.0       |
| 2                 | 3072            | RH | 4.0 | -      | 155.0 | 189.0 | 205.0 | 209.0 |     |     |     | 90.0      |
| 3                 | 3073            | RH | 4.5 | -      | -     | 159.0 | 175.0 | 179.0 |     |     |     | 30.0      |
| 4                 | 3074            | LC | 7.0 | -      | -     | -     | 159.0 | 163.0 |     |     |     | 16.0      |
| 5                 | 3075            | LC | 7.0 | -      | -     | -     | -     | 158.0 |     |     |     | 5.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 964             | RH | 0.6 |        |       |       |       |       |     |     |     |           |
| 1                 | 3081            | RH | 1.3 | 205.0  | 247.0 | 281.0 | 297.0 | 300.0 |     |     |     | 0.0       |
| 2                 | 3082            | RH | 4.0 | -      | 157.0 | 191.0 | 207.0 | 210.0 |     |     |     | 90.0      |
| 3                 | 3083            | RH | 4.0 | -      | -     | 161.0 | 177.0 | 180.0 |     |     |     | 30.0      |
| 4                 | 3084            | LC | 7.0 | -      | -     | -     | 161.0 | 164.0 |     |     |     | 16.0      |
| 5                 | 3085            | LC | 7.0 | -      | -     | -     | -     | 159.0 |     |     |     | 5.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.30BS            | STEEL         | STD   |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |       |       |     |     |     |           |
| 1                 | 3091            | RH | 1.1 | 207.0  | 248.0 | 281.0 | 297.0 | 300.0 |     |     |     | 0.0       |
| 2                 | 3092            | RH | 4.0 | -      | 158.0 | 191.0 | 207.0 | 210.0 |     |     |     | 90.0      |
| 3                 | 3093            | RH | 4.0 | -      | -     | 161.0 | 177.0 | 180.0 |     |     |     | 30.0      |
| 4                 | 3094            | LC | 6.0 | -      | -     | -     | 161.0 | 164.0 |     |     |     | 16.0      |
| 5                 | 3095            | LC | 6.5 | -      | -     | -     | -     | 159.0 |     |     |     | 5.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |       |       |     |     |     |           |
| 1                 | 3101            | RH | 1.0 | 209.0  | 249.0 | 281.0 | 297.0 | 300.0 |     |     |     | 0.0       |
| 2                 | 3102            | RH | 4.0 | -      | 159.0 | 191.0 | 207.0 | 210.0 |     |     |     | 90.0      |
| 3                 | 3103            | RH | 4.0 | -      | -     | 161.0 | 177.0 | 180.0 |     |     |     | 30.0      |
| 4                 | 3104            | LC | 6.0 | -      | -     | -     | 161.0 | 164.0 |     |     |     | 16.0      |
| 5                 | 3105            | LC | 6.5 | -      | -     | -     | -     | 159.0 |     |     |     | 5.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 125 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |       |       |     |     |     |           |
| 1                 | 3111            | RH | 0.9 | 205.0  | 248.0 | 279.0 | 294.0 | 300.0 |     |     |     | 0.0       |
| 2                 | 3112            | RH | 4.0 | -      | 158.0 | 189.0 | 204.0 | 210.0 |     |     |     | 90.0      |
| 3                 | 3113            | RH | 3.7 | -      | -     | 162.0 | 177.0 | 183.0 |     |     |     | 27.0      |
| 4                 | 3114            | LC | 6.0 | -      | -     | -     | 160.0 | 166.0 |     |     |     | 17.0      |
| 5                 | 3115            | LC | 5.5 | -      | -     | -     | -     | 158.0 |     |     |     | 8.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   | 5.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  | 0.70  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.30BS            | STEEL         | STD   |

Thickness 150 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |       |       |     |     |     |           |
| 1                 | 3121            | RH | 0.8 | 203.0  | 247.0 | 279.0 | 294.0 | 303.0 |     |     |     | 0.0       |
| 2                 | 3122            | RH | 4.0 | -      | 157.0 | 189.0 | 204.0 | 213.0 |     |     |     | 90.0      |
| 3                 | 3123            | RH | 3.5 | -      | -     | 164.0 | 179.0 | 188.0 |     |     |     | 25.0      |
| 4                 | 3124            | LC | 6.0 | -      | -     | -     | 161.0 | 170.0 |     |     |     | 18.0      |
| 5                 | 3125            | LC | 5.5 | -      | -     | -     | -     | 160.0 |     |     |     | 10.0      |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   | 5.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  | 0.70  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 200 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |       |       |     |     |     |           |
| 1                 | 3131            | RH | 0.6 | 200.0  | 246.0 | 276.0 | 293.0 | 303.0 |     |     |     | 0.0       |
| 2                 | 3132            | RH | 4.0 | -      | 156.0 | 186.0 | 203.0 | 213.0 |     |     |     | 90.0      |
| 3                 | 3133            | RH | 3.0 | -      | -     | 161.0 | 178.0 | 188.0 |     |     |     | 25.0      |
| 4                 | 3134            | LC | 6.0 | -      | -     | -     | 160.0 | 170.0 |     |     |     | 18.0      |
| 5                 | 3135            | LC | 5.0 | -      | -     | -     | -     | 160.0 |     |     |     | 10.0      |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   | 5.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  | 0.70  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 250 mm

| No.               | Cutting process |    |     | Offset |       |       |     |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |     |     |     |     |     |           |
| 1                 | 3141            | RH | 0.5 | 216.0  | 279.0 | 303.0 |     |     |     |     |     | 0.0       |
| 2                 | 3142            | RH | 3.0 | -      | 154.0 | 178.0 |     |     |     |     |     | 125.0     |
| 3                 | 3143            | RH | 2.5 | -      | -     | 158.0 |     |     |     |     |     | 20.0      |
| 4                 |                 |    |     | -      | -     | -     |     |     |     |     |     |           |
| 5                 |                 |    |     | -      | -     | -     | -   |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -   | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -   | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  |     |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  |     |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.30BS            | STEEL         | STD   |

Thickness 300 mm

| No.               | Cutting process |    |     | Offset |       |       |     |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |     |     |     |     |     |           |
| 1                 | 3151            | RH | 0.5 | 214.0  | 279.0 | 304.0 |     |     |     |     |     | 0.0       |
| 2                 | 3152            | RH | 2.5 | -      | 154.0 | 179.0 |     |     |     |     |     | 125.0     |
| 3                 | 3153            | RH | 2.5 | -      | -     | 159.0 |     |     |     |     |     | 20.0      |
| 4                 |                 |    |     | -      | -     | -     |     |     |     |     |     |           |
| 5                 |                 |    |     | -      | -     | -     | -   |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -   | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -   | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  |     |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  |     |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 350 mm

| No.               | Cutting process |    |     | Offset |       |       |     |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |     |     |     |     |     |           |
| 1                 | 3161            | RH | 0.4 | 210.0  | 279.0 | 307.0 |     |     |     |     |     | 0.0       |
| 2                 | 3162            | RH | 2.0 | -      | 154.0 | 182.0 |     |     |     |     |     | 125.0     |
| 3                 | 3163            | RH | 2.0 | -      | -     | 162.0 |     |     |     |     |     | 20.0      |
| 4                 |                 |    |     | -      | -     | -     |     |     |     |     |     |           |
| 5                 |                 |    |     | -      | -     | -     | -   |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -   | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -   | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  |     |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  |     |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 400 mm

| No.               | Cutting process |    |     | Offset |       |       |     |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |     |     |     |     |     |           |
| 1                 | 3171            | RH | 0.4 | 210.0  | 279.0 | 307.0 |     |     |     |     |     | 0.0       |
| 2                 | 3172            | RH | 2.0 | -      | 154.0 | 182.0 |     |     |     |     |     | 125.0     |
| 3                 | 3173            | RH | 2.0 | -      | -     | 162.0 |     |     |     |     |     | 20.0      |
| 4                 |                 |    |     | -      | -     | -     |     |     |     |     |     |           |
| 5                 |                 |    |     | -      | -     | -     | -   |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -   | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -   | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  |     |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  |     |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                  | Skim2                 | Skim3                    | Skim4                    | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|------------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|
| E-pack Number      | Eno | 961                   | 3001                  | 3002                   | 3003                  | 3004                     | 3005                     |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                     | RH                    | LC                       | LC                       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                     | NM                    | SL                       | SL                       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                     | 6                     | 15                       | 10                       |       |       |       |
| Power Setting      | IP  | 7.0                   | 10.0                  | 5.0                    | 5.0                   | 2.5                      | 2.5                      |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 9                      | 6                     |                          |                          |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                      | 6                     | 6                        | 4                        |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                      | 2                     | 2                        | 1                        |       |       |       |
| Stabilizer B       | SB  | 8                     | 11                    | 6                      | 6                     | 6                        | 2                        |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                      | 1                     | 4                        | 4                        |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                      | 1                     | 1                        | 1                        |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(57.0 ~ 63.0) | 98.0<br>(96.0 ~ 100.0) | 75.0<br>(73.0 ~ 77.0) | 190.0<br>(188.0 ~ 192.0) | 145.0<br>(143.0 ~ 147.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                    | OFF                   | ON                       | ON                       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                     | ON                    | OFF                      | OFF                      |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                     | 12                    | 10                       | 10                       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                     | 14                    | 14                       | 14                       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                     | 14                    | 14                       | 14                       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                     | NM                    | NM                       | NM                       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 12                    | 4                      | 4                     | 4                        | 4                        |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                     | 10                    | 10                       | 10                       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                      | 0                     | 0                        | 0                        |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 9.0                   | 12.0                   | 10.0                  | 14.0                     | 12.0                     |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                    | 1.0                   | 1.0                      | 1.0                      |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                    | 1.0                   | 1.0                      | 1.0                      |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 182.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 231.0 | 158.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 266.0 | 193.0 | 158.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 278.0 | 205.0 | 170.0 | 158.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 282.0 | 209.0 | 174.0 | 162.0 | 158.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 73.0  | 35.0  | 12.0  | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 12.4 ~ 15.2 | 15.8 ~ 19.3 | 10.1 ~ 12.3 | 12.9 ~ 14.3 | 11.0 ~ 12.1 |  |  |
| Average Voltage Gap  | V   |  | 50 ~ 66     | 88 ~ 108    | 72 ~ 82     | 202 ~ 221   | 152 ~ 170   |  |  |
| Avg. Linear Feedrate | ALF |  | 828.0       | 463.5       | 274.3       | 205.3       | 158.4       |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 10mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                    | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|
| E-pack Number      | Eno | 961                   | 3011                  | 3012                  | 3013                  | 3014                     | 3015                     |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                       | LC                       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 15                       | 10                       |       |       |       |
| Power Setting      | IP  | 7.0                   | 11.0                  | 5.0                   | 5.0                   | 2.5                      | 2.5                      |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 10                    | 7                     |                          |                          |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 6                        | 4                        |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                        | 1                        |       |       |       |
| Stabilizer B       | SB  | 8                     | 10                    | 6                     | 6                     | 6                        | 2                        |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                        |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                        |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(57.0 ~ 63.0) | 85.0<br>(83.0 ~ 87.0) | 55.0<br>(53.0 ~ 57.0) | 150.0<br>(148.0 ~ 152.0) | 130.0<br>(128.0 ~ 132.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                      |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                       | 10                       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                       | 14                       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                       | 14                       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                        | 4                        |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 6.0                   | 10.0                  | 8.0                   | 14.0                     | 12.0                     |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 188.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 238.0 | 158.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 270.0 | 190.0 | 155.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 285.0 | 205.0 | 170.0 | 158.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 288.0 | 208.0 | 173.0 | 161.0 | 157.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 80.0  | 35.0  | 12.0  | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 7.7 ~ 9.5   | 12.5 ~ 15.3 | 11.3 ~ 13.7 | 12.9 ~ 14.3 | 10.3 ~ 11.3 |  |  |
| Average Voltage Gap  | V   |  | 49 ~ 67     | 77 ~ 98     | 52 ~ 62     | 175 ~ 191   | 131 ~ 147   |  |  |
| Avg. Linear Feedrate | ALF |  | 516.0       | 318.8       | 223.7       | 175.6       | 138.1       |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                    | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|
| E-pack Number      | Eno | 961                   | 3021                  | 3022                  | 3023                  | 3024                     | 3025                     |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                       | LC                       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                       | 12                       |       |       |       |
| Power Setting      | IP  | 7.0                   | 12.0                  | 6.0                   | 5.0                   | 2.5                      | 2.5                      |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 8                     |                          |                          |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 6                        | 2                        |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                        | 1                        |       |       |       |
| Stabilizer B       | SB  | 8                     | 8                     | 6                     | 6                     | 6                        | 1                        |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                        |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                        |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 88.0<br>(86.0 ~ 90.0) | 65.0<br>(63.0 ~ 67.0) | 140.0<br>(138.0 ~ 142.0) | 120.0<br>(118.0 ~ 122.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                      |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                       | 10                       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                       | 14                       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                       | 14                       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                        | 4                        |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 4.0                   | 7.0                   | 8.0                   | 8.0                      | 8.0                      |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 191.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 234.0 | 154.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 265.0 | 185.0 | 155.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 282.0 | 202.0 | 172.0 | 160.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 286.0 | 206.0 | 176.0 | 164.0 | 159.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 80.0  | 30.0  | 12.0  | 5.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 6.1 ~ 7.4   | 9.5 ~ 11.7  | 7.2 ~ 8.8   | 7.6 ~ 8.4   | 7.6 ~ 8.4   |  |  |
| Average Voltage Gap  | V   |  | 42 ~ 61     | 78 ~ 96     | 62 ~ 72     | 165 ~ 180   | 127 ~ 142   |  |  |
| Avg. Linear Feedrate | ALF |  | 405.0       | 247.4       | 163.3       | 121.8       | 97.2        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 30mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                    | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|
| E-pack Number      | Eno | 962                   | 3031                  | 3032                  | 3033                  | 3034                     | 3035                     |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                       | LC                       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                       | 12                       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                   | 5.0                   | 2.5                      | 2.5                      |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 9                     |                          |                          |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 6                        | 2                        |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                        | 1                        |       |       |       |
| Stabilizer B       | SB  | 8                     | 7                     | 6                     | 6                     | 6                        | 1                        |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                        |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                        |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 85.0<br>(83.0 ~ 87.0) | 62.0<br>(60.0 ~ 64.0) | 120.0<br>(118.0 ~ 122.0) | 115.0<br>(113.0 ~ 117.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                      |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                       | 10                       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                       | 14                       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                       | 14                       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                        | 4                        |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 3.0                   | 6.0                   | 7.0                   | 7.5                      | 7.5                      |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 196.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 238.0 | 153.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 271.0 | 186.0 | 156.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 287.0 | 202.0 | 172.0 | 160.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 291.0 | 206.0 | 176.0 | 164.0 | 159.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 85.0  | 30.0  | 12.0  | 5.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 5.0 ~ 6.0   | 7.8 ~ 9.6   | 6.0 ~ 7.3   | 7.0 ~ 7.8   | 7.0 ~ 7.7   |  |  |
| Average Voltage Gap  | V   |  | 38 ~ 60     | 73 ~ 93     | 59 ~ 69     | 145 ~ 160   | 113 ~ 128   |  |  |
| Avg. Linear Feedrate | ALF |  | 330.0       | 202.2       | 134.2       | 103.0       | 83.5        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 40mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                   | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 962                   | 3041                  | 3042                  | 3043                  | 3044                    | 3045                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                      | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                      | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                      | 12                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 13.0                  | 6.0                   | 5.0                   | 2.5                     | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                         |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 6                       | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                       | 1                     |       |       |       |
| Stabilizer B       | SB  | 8                     | 6                     | 6                     | 6                     | 6                       | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                       | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                       | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 78.0<br>(76.0 ~ 80.0) | 61.0<br>(59.0 ~ 63.0) | 100.0<br>(98.0 ~ 102.0) | 90.0<br>(88.0 ~ 92.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                      | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                     | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                      | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                      | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                      | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                      | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                       | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                      | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                       | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.0                   | 5.0                   | 6.0                   | 7.0                     | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 200.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 243.0 | 153.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 277.0 | 187.0 | 157.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 292.0 | 202.0 | 172.0 | 160.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 296.0 | 206.0 | 176.0 | 164.0 | 159.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 12.0  | 5.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 3.8 ~ 4.6   | 6.2 ~ 7.6   | 4.8 ~ 5.8   | 6.5 ~ 7.2   | 6.4 ~ 7.0   |  |  |
| Average Voltage Gap  | V   |  | 36 ~ 59     | 68 ~ 88     | 58 ~ 68     | 126 ~ 140   | 101 ~ 116   |  |  |
| Avg. Linear Feedrate | ALF |  | 252.0       | 156.6       | 104.9       | 83.6        | 69.2        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 50mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 963                   | 3051                  | 3052                  | 3053                  | 3054                  | 3055                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                    | 12                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 13.0                  | 6.0                   | 5.0                   | 2.5                   | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 6                     | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 7                     | 5                     | 6                     | 6                     | 6                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 48.0<br>(45.0 ~ 51.0) | 76.0<br>(74.0 ~ 78.0) | 57.0<br>(55.0 ~ 59.0) | 95.0<br>(93.0 ~ 97.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.7                   | 4.5                   | 5.5                   | 7.0                   | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 201.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 243.0 | 153.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 277.0 | 187.0 | 157.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 292.0 | 202.0 | 172.0 | 158.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 296.0 | 206.0 | 176.0 | 162.0 | 157.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 14.0  | 5.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 3.2 ~ 3.9   | 5.6 ~ 6.8   | 4.3 ~ 5.1   | 6.4 ~ 7.1   | 6.2 ~ 6.9   |  |  |
| Average Voltage Gap  | V   |  | 37 ~ 57     | 65 ~ 87     | 54 ~ 64     | 117 ~ 132   | 90 ~ 104    |  |  |
| Avg. Linear Feedrate | ALF |  | 213.0       | 135.4       | 91.5        | 74.6        | 62.7        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 60mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 963                   | 3061                  | 3062                  | 3063                  | 3064                  | 3065                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                    | 12                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 13.0                  | 6.0                   | 5.0                   | 3.0                   | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 6                     | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 6                     | 6                     | 6                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 74.0<br>(72.0 ~ 76.0) | 55.0<br>(53.0 ~ 57.0) | 90.0<br>(88.0 ~ 92.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.5                   | 4.0                   | 5.0                   | 7.0                   | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 203.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 243.0 | 153.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 277.0 | 187.0 | 157.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 293.0 | 203.0 | 173.0 | 157.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 297.0 | 207.0 | 177.0 | 161.0 | 156.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 16.0  | 5.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 2.5 ~ 3.1   | 4.9 ~ 5.9   | 3.7 ~ 4.5   | 6.3 ~ 6.9   | 6.1 ~ 6.8   |  |  |
| Average Voltage Gap  | V   |  | 38 ~ 55     | 63 ~ 86     | 52 ~ 62     | 108 ~ 124   | 79 ~ 92     |  |  |
| Avg. Linear Feedrate | ALF |  | 168.0       | 110.6       | 76.3        | 64.0        | 54.9        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 70mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 964                   | 3071                  | 3072                  | 3073                  | 3074                  | 3075                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                    | 12                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 13.0                  | 6.0                   | 5.0                   | 3.0                   | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 6                     | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 6                     | 6                     | 6                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 44.0<br>(41.0 ~ 47.0) | 74.0<br>(72.0 ~ 76.0) | 55.0<br>(53.0 ~ 57.0) | 87.0<br>(85.0 ~ 89.0) | 67.0<br>(65.0 ~ 69.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.4                   | 4.0                   | 4.5                   | 7.0                   | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 204.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 245.0 | 155.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 279.0 | 189.0 | 159.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 295.0 | 205.0 | 175.0 | 159.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 299.0 | 209.0 | 179.0 | 163.0 | 158.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 16.0  | 5.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 2.1 ~ 2.6   | 4.2 ~ 5.1   | 3.3 ~ 4.0   | 6.3 ~ 7.0   | 6.1 ~ 6.8   |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 56     | 61 ~ 86     | 52 ~ 62     | 101 ~ 117   | 77 ~ 90     |  |  |
| Avg. Linear Feedrate | ALF |  | 141.0       | 93.7        | 65.6        | 56.3        | 49.2        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 80mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 964                   | 3081                  | 3082                  | 3083                  | 3084                  | 3085                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                    | 12                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 13.0                  | 6.0                   | 5.0                   | 3.0                   | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 6                     | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 6                     | 6                     | 6                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 42.0<br>(39.0 ~ 45.0) | 74.0<br>(72.0 ~ 76.0) | 55.0<br>(53.0 ~ 57.0) | 85.0<br>(83.0 ~ 87.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.3                   | 4.0                   | 4.0                   | 7.0                   | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 205.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 247.0 | 157.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 281.0 | 191.0 | 161.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 297.0 | 207.0 | 177.0 | 161.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 300.0 | 210.0 | 180.0 | 164.0 | 159.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 16.0  | 5.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.8 ~ 2.2   | 3.5 ~ 4.3   | 2.8 ~ 3.4   | 6.4 ~ 7.0   | 6.2 ~ 6.8   |  |  |
| Average Voltage Gap  | V   |  | 32 ~ 56     | 60 ~ 86     | 52 ~ 62     | 95 ~ 111    | 76 ~ 89     |  |  |
| Avg. Linear Feedrate | ALF |  | 120.0       | 79.3        | 55.6        | 48.9        | 43.4        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 90mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3091                  | 3092                  | 3093                  | 3094                  | 3095                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                    | 13                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 13.0                  | 6.0                   | 5.0                   | 3.0                   | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 5                     | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 6                     | 4                     | 6                     | 6                     | 6                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 41.0<br>(38.0 ~ 44.0) | 72.0<br>(70.0 ~ 74.0) | 52.0<br>(50.0 ~ 54.0) | 80.0<br>(78.0 ~ 82.0) | 62.0<br>(60.0 ~ 64.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 1.1                   | 4.0                   | 4.0                   | 6.0                   | 6.5                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 207.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 248.0 | 158.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 281.0 | 191.0 | 161.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 297.0 | 207.0 | 177.0 | 161.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 300.0 | 210.0 | 180.0 | 164.0 | 159.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 16.0  | 5.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.6 ~ 2.0   | 3.2 ~ 3.9   | 2.7 ~ 3.3   | 6.0 ~ 6.5   | 5.8 ~ 6.5   |  |  |
| Average Voltage Gap  | V   |  | 32 ~ 52     | 59 ~ 83     | 49 ~ 59     | 92 ~ 107    | 74 ~ 87     |  |  |
| Avg. Linear Feedrate | ALF |  | 108.0       | 71.7        | 51.3        | 45.1        | 40.2        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 100mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3101                  | 3102                  | 3103                  | 3104                  | 3105                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                    | 14                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 13.0                  | 6.0                   | 5.0                   | 3.0                   | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 4                     | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 6                     | 4                     | 6                     | 6                     | 4                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 70.0<br>(68.0 ~ 72.0) | 49.0<br>(47.0 ~ 51.0) | 75.0<br>(73.0 ~ 77.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 1.0                   | 4.0                   | 4.0                   | 6.0                   | 6.5                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 209.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 249.0 | 159.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 281.0 | 191.0 | 161.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 297.0 | 207.0 | 177.0 | 161.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 300.0 | 210.0 | 180.0 | 164.0 | 159.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 16.0  | 5.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.4 ~ 1.8   | 2.9 ~ 3.5   | 2.6 ~ 3.2   | 5.5 ~ 6.1   | 5.5 ~ 6.1   |  |  |
| Average Voltage Gap  | V   |  | 32 ~ 49     | 59 ~ 80     | 46 ~ 56     | 89 ~ 103    | 72 ~ 85     |  |  |
| Avg. Linear Feedrate | ALF |  | 96.0        | 64.0        | 46.8        | 41.2        | 36.9        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 125mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3111                  | 3112                  | 3113                  | 3114                  | 3115                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 11                    | 10                    | 16                    | 15                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 13.0                  | 8.0                   | 5.0                   | 3.0                   | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 7                     | 5                     | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 4                     | 2                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 7                     | 6                     | 8                     | 8                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 43.0<br>(40.0 ~ 46.0) | 72.0<br>(70.0 ~ 74.0) | 60.0<br>(58.0 ~ 62.0) | 85.0<br>(83.0 ~ 87.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.9                   | 4.0                   | 3.7                   | 6.0                   | 5.5                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 205.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 248.0 | 158.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 279.0 | 189.0 | 162.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 294.0 | 204.0 | 177.0 | 160.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 300.0 | 210.0 | 183.0 | 166.0 | 158.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 27.0  | 17.0  | 8.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.1 ~ 1.4   | 4.0 ~ 5.0   | 3.1 ~ 3.8   | 6.0 ~ 6.6   | 5.0 ~ 5.5   |  |  |
| Average Voltage Gap  | V   |  | 32 ~ 53     | 60 ~ 81     | 57 ~ 67     | 91 ~ 105    | 71 ~ 84     |  |  |
| Avg. Linear Feedrate | ALF |  | 75.0        | 58.7        | 45.7        | 40.8        | 36.1        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   | 4.5 ~ 5.5   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 | 0.63 ~ 1.05 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 150mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3121                  | 3122                  | 3123                  | 3124                  | 3125                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 12                    | 16                    | 16                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 14.0                  | 10.0                  | 6.0                   | 3.0                   | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 11                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 4                     | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 6                     | 3                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 8                     | 4                     | 8                     | 8                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 75.0<br>(73.0 ~ 77.0) | 70.0<br>(68.0 ~ 72.0) | 90.0<br>(88.0 ~ 92.0) | 75.0<br>(73.0 ~ 77.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.8                   | 4.0                   | 3.5                   | 6.0                   | 5.5                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 203.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 247.0 | 157.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 279.0 | 189.0 | 164.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 294.0 | 204.0 | 179.0 | 161.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 303.0 | 213.0 | 188.0 | 170.0 | 160.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 25.0  | 18.0  | 10.0  |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.0   | 5.0 ~ 6.0   | 3.7 ~ 4.5   | 6.7 ~ 7.4   | 4.4 ~ 4.9   |  |  |
| Average Voltage Gap  | V   |  | 32 ~ 58     | 62 ~ 83     | 67 ~ 77     | 94 ~ 107    | 70 ~ 83     |  |  |
| Avg. Linear Feedrate | ALF |  | 54.0        | 46.4        | 39.0        | 35.7        | 31.7        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   | 4.5 ~ 5.5   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 | 0.63 ~ 1.05 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 200mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3131                  | 3132                  | 3133                  | 3134                  | 3135                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 12                    | 16                    | 16                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 14.0                  | 10.0                  | 6.0                   | 3.0                   | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 11                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 4                     | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 6                     | 3                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 8                     | 4                     | 8                     | 8                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 60.0<br>(58.0 ~ 62.0) | 55.0<br>(53.0 ~ 57.0) | 70.0<br>(68.0 ~ 72.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 6                     | 6                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.6                   | 4.0                   | 3.0                   | 6.0                   | 5.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 200.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 246.0 | 156.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 276.0 | 186.0 | 161.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 293.0 | 203.0 | 178.0 | 160.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 303.0 | 213.0 | 188.0 | 170.0 | 160.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 25.0  | 18.0  | 10.0  |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.5 ~ 0.6   | 3.5 ~ 4.3   | 2.7 ~ 3.3   | 4.3 ~ 4.7   | 4.6 ~ 5.0   |  |  |
| Average Voltage Gap  | V   |  | 36 ~ 54     | 48 ~ 69     | 52 ~ 62     | 70 ~ 82     | 52 ~ 60     |  |  |
| Avg. Linear Feedrate | ALF |  | 33.0        | 28.9        | 24.9        | 22.8        | 21.1        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   | 4.5 ~ 5.5   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 | 0.63 ~ 1.05 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 250mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3141                  | 3142                  | 3143                  |       |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    |       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    |       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 14                    |       |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 13.0                  | 9.0                   | 6.0                   |       |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 10                    |       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 7                     | 4                     |       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 6                     | 3                     |       |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 9                     | 7                     | 4                     |       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     |       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     |       |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 38.0<br>(35.0 ~ 41.0) | 48.0<br>(46.0 ~ 50.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    |       |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    |       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    |       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    |       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 6                     |       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    |       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     |       |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.5                   | 3.0                   | 2.5                   |       |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 216.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 279.0 | 154.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 303.0 | 178.0 | 158.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 125.0 | 20.0  |       |       |       |       |       |

| RESULTS              |     |  |             |             |             |  |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.3 ~ 0.4   | 2.0 ~ 2.4   | 3.3 ~ 4.1   |  |  |  |  |
| Average Voltage Gap  | V   |  | 28 ~ 45     | 36 ~ 61     | 42 ~ 52     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 21.0        | 18.1        | 16.8        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 |  |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 300mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3151                  | 3152                  | 3153                  |       |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    |       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    |       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 14                    |       |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 13.0                  | 9.0                   | 6.0                   |       |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 10                    |       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 7                     | 4                     |       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 6                     | 3                     |       |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 9                     | 7                     | 4                     |       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     |       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     |       |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 38.0<br>(35.0 ~ 41.0) | 38.0<br>(36.0 ~ 40.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    |       |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    |       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    |       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    |       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 6                     |       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    |       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     |       |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.5                   | 2.5                   | 2.5                   |       |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 214.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 279.0 | 154.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 304.0 | 179.0 | 159.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 125.0 | 20.0  |       |       |       |       |       |

| RESULTS              |     |  |             |             |             |  |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.2 ~ 0.3   | 2.2 ~ 2.8   | 2.3 ~ 2.9   |  |  |  |  |
| Average Voltage Gap  | V   |  | 25 ~ 45     | 27 ~ 50     | 37 ~ 47     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 15.0        | 13.6        | 12.5        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 |  |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 350mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3151                  | 3152                  | 3153                  |       |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    |       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    |       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 14                    |       |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 13.0                  | 9.0                   | 6.0                   |       |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    | 10                    |       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 7                     | 4                     |       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 6                     | 3                     |       |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 11                    | 7                     | 4                     |       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     |       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     |       |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 30.0<br>(27.0 ~ 33.0) | 30.0<br>(28.0 ~ 32.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    |       |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    |       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    |       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    |       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 6                     |       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    |       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     |       |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.4                   | 2.0                   | 2.0                   |       |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 210.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 279.0 | 154.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 307.0 | 182.0 | 162.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 125.0 | 20.0  |       |       |       |       |       |

| RESULTS              |     |  |             |             |             |  |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.2 ~ 0.3   | 3.4 ~ 3.7   | 1.2 ~ 1.4   |  |  |  |  |
| Average Voltage Gap  | V   |  | 24 ~ 38     | 21 ~ 34     | 28 ~ 42     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 15.0        | 14.0        | 11.9        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 |  |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | STEEL         | 400mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3151                  | 3152                  | 3153                  |       |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    |       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    |       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                    | 14                    |       |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 13.0                  | 9.0                   | 6.0                   |       |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    | 10                    |       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 7                     | 4                     |       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 6                     | 3                     |       |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 11                    | 7                     | 4                     |       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     |       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     |       |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 30.0<br>(27.0 ~ 33.0) | 25.0<br>(23.0 ~ 27.0) | 35.0<br>(33.0 ~ 37.0) |       |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    |       |       |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    |       |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    |       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    |       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    |       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 15                    | 6                     | 6                     |       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    |       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     |       |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.4                   | 2.0                   | 2.0                   |       |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 210.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 279.0 | 154.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 307.0 | 182.0 | 162.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- |       |       |       | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 125.0 | 20.0  |       |       |       |       |       |

| RESULTS              |     |  |             |             |             |  |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.1 ~ 0.2   | 1.8 ~ 2.5   | 1.0 ~ 1.5   |  |  |  |  |
| Average Voltage Gap  | V   |  | 23 ~ 36     | 21 ~ 34     | 37 ~ 53     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 9.0         | 8.4         | 7.6         |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 |  |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.30BS            | STEEL         | STDPO1 |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 961             | RH | 2.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 3221            | RH | 3.5 | 191.0  | 233.0 | 264.0 | 275.0 | 280.0 |     |     |     | 0.0       |
| 2                 | 3222            | RH | 7.0 | -      | 153.0 | 184.0 | 195.0 | 200.0 |     |     |     | 80.0      |
| 3                 | 3223            | RH | 6.0 | -      | -     | 154.0 | 165.0 | 170.0 |     |     |     | 30.0      |
| 4                 | 3224            | LC | 8.0 | -      | -     | -     | 157.0 | 162.0 |     |     |     | 8.0       |
| 5                 | 3225            | LC | 8.0 | -      | -     | -     | -     | 159.0 |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 962             | RH | 1.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 3231            | RH | 2.5 | 197.0  | 238.0 | 268.0 | 279.0 | 283.0 |     |     |     | 0.0       |
| 2                 | 3232            | RH | 6.0 | -      | 153.0 | 183.0 | 194.0 | 198.0 |     |     |     | 85.0      |
| 3                 | 3233            | RH | 5.5 | -      | -     | 153.0 | 164.0 | 168.0 |     |     |     | 30.0      |
| 4                 | 3234            | LC | 7.0 | -      | -     | -     | 156.0 | 160.0 |     |     |     | 8.0       |
| 5                 | 3235            | LC | 7.0 | -      | -     | -     | -     | 157.0 |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 962             | RH | 1.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 3241            | RH | 1.5 | 204.0  | 243.0 | 272.0 | 284.0 | 286.0 |     |     |     | 0.0       |
| 2                 | 3242            | RH | 5.0 | -      | 153.0 | 182.0 | 194.0 | 196.0 |     |     |     | 90.0      |
| 3                 | 3243            | RH | 5.0 | -      | -     | 152.0 | 164.0 | 166.0 |     |     |     | 30.0      |
| 4                 | 3244            | LC | 7.0 | -      | -     | -     | 156.0 | 158.0 |     |     |     | 8.0       |
| 5                 | 3245            | LC | 7.0 | -      | -     | -     | -     | 155.0 |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.30BS            | STEEL         | STDPO1 |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 963             | RH | 0.7 |        |       |       |       |       |     |     |     |           |
| 1                 | 3251            | RH | 1.2 | 207.0  | 243.0 | 274.0 | 287.0 | 290.0 |     |     |     | 0.0       |
| 2                 | 3252            | RH | 4.5 | -      | 153.0 | 184.0 | 197.0 | 200.0 |     |     |     | 90.0      |
| 3                 | 3253            | RH | 4.5 | -      | -     | 154.0 | 167.0 | 170.0 |     |     |     | 30.0      |
| 4                 | 3254            | LC | 7.0 | -      | -     | -     | 157.0 | 160.0 |     |     |     | 10.0      |
| 5                 | 3255            | LC | 7.0 | -      | -     | -     | -     | 157.0 |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 963             | RH | 0.7 |        |       |       |       |       |     |     |     |           |
| 1                 | 3261            | RH | 1.0 | 210.0  | 243.0 | 276.0 | 289.0 | 293.0 |     |     |     | 0.0       |
| 2                 | 3262            | RH | 4.0 | -      | 153.0 | 186.0 | 199.0 | 203.0 |     |     |     | 90.0      |
| 3                 | 3263            | RH | 4.0 | -      | -     | 156.0 | 169.0 | 173.0 |     |     |     | 30.0      |
| 4                 | 3264            | LC | 7.0 | -      | -     | -     | 157.0 | 161.0 |     |     |     | 12.0      |
| 5                 | 3265            | LC | 7.0 | -      | -     | -     | -     | 158.0 |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 964             | RH | 0.6 |        |       |       |       |       |     |     |     |           |
| 1                 | 3271            | RH | 0.9 | 212.0  | 247.0 | 280.0 | 293.0 | 296.0 |     |     |     | 0.0       |
| 2                 | 3272            | RH | 4.0 | -      | 157.0 | 190.0 | 203.0 | 206.0 |     |     |     | 90.0      |
| 3                 | 3273            | RH | 3.5 | -      | -     | 160.0 | 173.0 | 176.0 |     |     |     | 30.0      |
| 4                 | 3274            | LC | 7.0 | -      | -     | -     | 161.0 | 164.0 |     |     |     | 12.0      |
| 5                 | 3275            | LC | 7.0 | -      | -     | -     | -     | 160.0 |     |     |     | 4.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.30BS            | STEEL         | STDPO1 |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 964             | RH | 0.6 |        |       |       |       |       |     |     |     |           |
| 1                 | 3281            | RH | 0.8 | 215.0  | 251.0 | 284.0 | 297.0 | 300.0 |     |     |     | 0.0       |
| 2                 | 3282            | RH | 4.0 | -      | 161.0 | 194.0 | 207.0 | 210.0 |     |     |     | 90.0      |
| 3                 | 3283            | RH | 3.0 | -      | -     | 164.0 | 177.0 | 180.0 |     |     |     | 30.0      |
| 4                 | 3284            | LC | 7.0 | -      | -     | -     | 165.0 | 168.0 |     |     |     | 12.0      |
| 5                 | 3285            | LC | 7.0 | -      | -     | -     | -     | 163.0 |     |     |     | 5.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |       |       |     |     |     |           |
| 1                 | 3291            | RH | 0.7 | 216.0  | 243.0 | 285.0 | 297.0 | 300.0 |     |     |     | 0.0       |
| 2                 | 3292            | RH | 4.0 | -      | 153.0 | 195.0 | 207.0 | 210.0 |     |     |     | 90.0      |
| 3                 | 3293            | RH | 2.5 | -      | -     | 165.0 | 177.0 | 180.0 |     |     |     | 30.0      |
| 4                 | 3294            | LC | 7.0 | -      | -     | -     | 165.0 | 168.0 |     |     |     | 12.0      |
| 5                 | 3295            | LC | 7.0 | -      | -     | -     | -     | 163.0 |     |     |     | 5.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |       |       |     |     |     |           |
| 1                 | 3301            | RH | 0.6 | 218.0  | 255.0 | 286.0 | 297.0 | 301.0 |     |     |     | 0.0       |
| 2                 | 3302            | RH | 4.0 | -      | 165.0 | 196.0 | 207.0 | 211.0 |     |     |     | 90.0      |
| 3                 | 3303            | RH | 2.0 | -      | -     | 166.0 | 177.0 | 181.0 |     |     |     | 30.0      |
| 4                 | 3304            | LC | 6.0 | -      | -     | -     | 165.0 | 169.0 |     |     |     | 12.0      |
| 5                 | 3305            | LC | 6.5 | -      | -     | -     | -     | 164.0 |     |     |     | 5.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 5.0   | 2.8   |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 0.70  | 0.34  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 20.00mm |
| Lower      | 20.00mm |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.30BS           | STEEL         | 20mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                    | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|
| E-pack Number      | Eno | 961                   | 3221                  | 3222                  | 3223                  | 3224                     | 3225                     |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                       | LC                       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                       | 12                       |       |       |       |
| Power Setting      | IP  | 7.0                   | 11.0                  | 6.0                   | 5.0                   | 2.5                      | 2.5                      |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                    | 8                     |                          |                          |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 6                        | 2                        |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                        | 1                        |       |       |       |
| Stabilizer B       | SB  | 8                     | 10                    | 6                     | 6                     | 6                        | 1                        |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                        |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                        |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 95.0<br>(93.0 ~ 97.0) | 65.0<br>(63.0 ~ 67.0) | 140.0<br>(138.0 ~ 142.0) | 130.0<br>(128.0 ~ 132.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                      |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                       | 10                       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                       | 14                       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                       | 14                       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                        | 4                        |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 3.5                   | 7.0                   | 6.0                   | 8.0                      | 8.0                      |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 191.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 233.0 | 153.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 264.0 | 184.0 | 154.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 275.0 | 195.0 | 165.0 | 157.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 280.0 | 200.0 | 170.0 | 162.0 | 159.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 80.0  | 30.0  | 8.0   | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 3.7 ~ 4.6   | 9.6 ~ 11.7  | 6.4 ~ 7.8   | 7.5 ~ 8.3   | 7.3 ~ 8.1   |  |  |
| Average Voltage Gap  | V   |  | 40 ~ 59     | 85 ~ 106    | 62 ~ 72     | 154 ~ 168   | 129 ~ 141   |  |  |
| Avg. Linear Feedrate | ALF |  | 249.0       | 179.2       | 126.1       | 99.6        | 81.9        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.30BS           | STEEL         | 30mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                    | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|
| E-pack Number      | Eno | 962                   | 3231                  | 3232                  | 3233                  | 3234                     | 3235                     |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                       | LC                       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                       | 12                       |       |       |       |
| Power Setting      | IP  | 9.0                   | 11.0                  | 6.0                   | 5.0                   | 2.5                      | 2.5                      |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 9                     |                          |                          |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 6                        | 2                        |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                        | 1                        |       |       |       |
| Stabilizer B       | SB  | 8                     | 9                     | 6                     | 6                     | 6                        | 1                        |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                        |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                        |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 90.0<br>(88.0 ~ 92.0) | 63.0<br>(61.0 ~ 65.0) | 125.0<br>(123.0 ~ 127.0) | 110.0<br>(108.0 ~ 112.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                      |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                       | 10                       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                       | 14                       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                       | 14                       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                        | 4                        |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.5                   | 6.0                   | 5.5                   | 7.0                      | 7.0                      |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 197.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 238.0 | 153.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 268.0 | 183.0 | 153.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 279.0 | 194.0 | 164.0 | 156.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 283.0 | 198.0 | 168.0 | 160.0 | 157.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 85.0  | 30.0  | 8.0   | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 2.9 ~ 3.6   | 8.2 ~ 10.1  | 5.6 ~ 7.0   | 6.5 ~ 7.3   | 6.5 ~ 7.0   |  |  |
| Average Voltage Gap  | V   |  | 39 ~ 61     | 80 ~ 99     | 60 ~ 70     | 135 ~ 149   | 112 ~ 125   |  |  |
| Avg. Linear Feedrate | ALF |  | 195.0       | 143.9       | 104.2       | 83.3        | 69.1        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.30BS           | STEEL         | 40mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 962                   | 3241                  | 3242                  | 3243                  | 3244                     | 3245                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                       | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                       | 12                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                   | 5.0                   | 2.5                      | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                          |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 6                        | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                        | 1                     |       |       |       |
| Stabilizer B       | SB  | 8                     | 9                     | 6                     | 6                     | 6                        | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 85.0<br>(83.0 ~ 87.0) | 61.0<br>(59.0 ~ 63.0) | 110.0<br>(108.0 ~ 112.0) | 90.0<br>(88.0 ~ 92.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                       | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                       | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                        | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.5                   | 5.0                   | 5.0                   | 7.0                      | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 204.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 243.0 | 153.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 272.0 | 182.0 | 152.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 284.0 | 194.0 | 164.0 | 156.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 286.0 | 196.0 | 166.0 | 158.0 | 155.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 8.0   | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 2.1 ~ 2.6   | 6.9 ~ 8.5   | 5.1 ~ 6.3   | 6.4 ~ 7.0   | 5.9 ~ 6.5   |  |  |
| Average Voltage Gap  | V   |  | 39 ~ 62     | 75 ~ 93     | 58 ~ 68     | 116 ~ 130   | 95 ~ 108    |  |  |
| Avg. Linear Feedrate | ALF |  | 141.0       | 108.0       | 82.1        | 68.2        | 57.6        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.30BS           | STEEL         | 50mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 963                   | 3251                  | 3252                  | 3253                  | 3254                     | 3255                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                       | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                       | 12                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                   | 5.0                   | 3.0                      | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                          |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 6                        | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                        | 1                     |       |       |       |
| Stabilizer B       | SB  | 7                     | 9                     | 6                     | 6                     | 6                        | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 48.0<br>(45.0 ~ 51.0) | 83.0<br>(81.0 ~ 85.0) | 60.0<br>(58.0 ~ 62.0) | 105.0<br>(103.0 ~ 107.0) | 85.0<br>(83.0 ~ 87.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                       | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                       | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                       | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                        | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.2                   | 4.5                   | 4.5                   | 7.0                      | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 207.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 243.0 | 153.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 274.0 | 184.0 | 154.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 287.0 | 197.0 | 167.0 | 157.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 290.0 | 200.0 | 170.0 | 160.0 | 157.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 10.0  | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.8 ~ 2.1   | 5.8 ~ 7.1   | 4.1 ~ 4.6   | 6.5 ~ 7.2   | 6.0 ~ 6.7   |  |  |
| Average Voltage Gap  | V   |  | 37 ~ 59     | 73 ~ 93     | 57 ~ 67     | 115 ~ 129   | 92 ~ 105    |  |  |
| Avg. Linear Feedrate | ALF |  | 117.0       | 89.8        | 66.8        | 57.5        | 49.9        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.30BS           | STEEL         | 60mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                   | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 963                   | 3261                  | 3262                  | 3263                  | 3264                    | 3265                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                      | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                      | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                      | 12                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                   | 5.0                   | 3.0                     | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                         |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 6                       | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                       | 1                     |       |       |       |
| Stabilizer B       | SB  | 7                     | 9                     | 6                     | 6                     | 6                       | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                       | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                       | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 81.0<br>(79.0 ~ 83.0) | 60.0<br>(58.0 ~ 62.0) | 100.0<br>(98.0 ~ 102.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                      | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                     | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                      | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                      | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                      | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                      | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                       | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                      | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                       | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.0                   | 4.0                   | 4.0                   | 7.0                     | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 210.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 243.0 | 153.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 276.0 | 186.0 | 156.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 289.0 | 199.0 | 169.0 | 157.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 293.0 | 203.0 | 173.0 | 161.0 | 158.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 12.0  | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.5 ~ 1.8   | 4.6 ~ 5.6   | 2.9 ~ 3.6   | 6.5 ~ 7.2   | 6.1 ~ 6.8   |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 57     | 71 ~ 93     | 57 ~ 67     | 114 ~ 128   | 89 ~ 101    |  |  |
| Avg. Linear Feedrate | ALF |  | 99.0        | 74.8        | 54.1        | 47.8        | 42.5        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.30BS           | STEEL         | 70mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 964                   | 3271                  | 3272                  | 3273                  | 3274                  | 3275                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                    | 12                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                   | 5.0                   | 3.0                   | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 6                     | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 7                     | 9                     | 6                     | 6                     | 6                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 81.0<br>(79.0 ~ 83.0) | 60.0<br>(58.0 ~ 62.0) | 95.0<br>(93.0 ~ 97.0) | 77.0<br>(75.0 ~ 79.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.9                   | 4.0                   | 3.5                   | 7.0                   | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 212.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 247.0 | 157.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 280.0 | 190.0 | 160.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 293.0 | 203.0 | 173.0 | 161.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 296.0 | 206.0 | 176.0 | 164.0 | 160.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 12.0  | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.2 ~ 1.5   | 3.8 ~ 4.8   | 2.7 ~ 3.0   | 6.4 ~ 7.1   | 6.1 ~ 6.8   |  |  |
| Average Voltage Gap  | V   |  | 34 ~ 55     | 71 ~ 93     | 57 ~ 67     | 108 ~ 122   | 84 ~ 96     |  |  |
| Avg. Linear Feedrate | ALF |  | 81.0        | 61.6        | 45.3        | 40.8        | 36.9        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.30BS           | STEEL         | 80mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 964                   | 3281                  | 3282                  | 3283                  | 3284                  | 3285                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                    | 12                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                   | 5.0                   | 3.0                   | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 6                     | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 7                     | 9                     | 6                     | 6                     | 6                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 81.0<br>(79.0 ~ 83.0) | 60.0<br>(58.0 ~ 62.0) | 90.0<br>(88.0 ~ 92.0) | 75.0<br>(73.0 ~ 77.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.8                   | 4.0                   | 3.0                   | 7.0                   | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 215.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 251.0 | 161.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 284.0 | 194.0 | 164.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 297.0 | 207.0 | 177.0 | 165.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 300.0 | 210.0 | 180.0 | 168.0 | 163.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 12.0  | 5.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.1 ~ 1.3   | 3.1 ~ 3.8   | 2.2 ~ 2.6   | 6.4 ~ 7.1   | 6.1 ~ 6.8   |  |  |
| Average Voltage Gap  | V   |  | 33 ~ 53     | 70 ~ 93     | 57 ~ 67     | 102 ~ 116   | 80 ~ 92     |  |  |
| Avg. Linear Feedrate | ALF |  | 72.0        | 53.4        | 39.0        | 35.5        | 32.6        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.30BS           | STEEL         | 90mm               | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3291                  | 3292                  | 3293                  | 3294                  | 3295                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                    | 13                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                   | 5.0                   | 3.0                   | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 5                     | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 6                     | 9                     | 6                     | 6                     | 5                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 79.0<br>(77.0 ~ 81.0) | 57.0<br>(55.0 ~ 59.0) | 85.0<br>(83.0 ~ 87.0) | 72.0<br>(70.0 ~ 74.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.7                   | 4.0                   | 2.5                   | 7.0                   | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 216.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 243.0 | 153.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 285.0 | 195.0 | 165.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 297.0 | 207.0 | 177.0 | 165.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 300.0 | 210.0 | 180.0 | 168.0 | 163.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 12.0  | 5.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.0 ~ 1.2   | 2.8 ~ 3.5   | 2.2 ~ 2.7   | 6.4 ~ 7.1   | 5.7 ~ 6.8   |  |  |
| Average Voltage Gap  | V   |  | 36 ~ 56     | 68 ~ 91     | 54 ~ 64     | 98 ~ 112    | 76 ~ 88     |  |  |
| Avg. Linear Feedrate | ALF |  | 66.0        | 48.9        | 36.7        | 33.7        | 30.9        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|---------|------------|---------------------|---------|
|                    |               |                    |         |            | Upper               | Lower   |
| φ 0.30BS           | STEEL         | 100mm              | STDPO1  | φ 4.0mm    | 20.00mm             | 20.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3301                  | 3302                  | 3303                  | 3304                  | 3305                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | RH                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 6                     | 16                    | 14                    |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                   | 5.0                   | 3.0                   | 2.5                   |       |       |       |
| IP adjust          | ΔIP | 11                    | 12                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 6                     | 6                     | 4                     | 2                     |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                     | 2                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 6                     | 9                     | 6                     | 6                     | 4                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 77.0<br>(75.0 ~ 79.0) | 54.0<br>(52.0 ~ 56.0) | 80.0<br>(78.0 ~ 82.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.6                   | 4.0                   | 2.0                   | 6.0                   | 6.5                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 218.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 255.0 | 165.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 286.0 | 196.0 | 166.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 297.0 | 207.0 | 177.0 | 165.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 301.0 | 211.0 | 181.0 | 169.0 | 164.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 12.0  | 5.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.8 ~ 0.9   | 2.5 ~ 3.1   | 2.2 ~ 2.7   | 5.5 ~ 6.1   | 5.5 ~ 6.1   |  |  |
| Average Voltage Gap  | V   |  | 39 ~ 59     | 67 ~ 90     | 51 ~ 61     | 94 ~ 108    | 72 ~ 84     |  |  |
| Avg. Linear Feedrate | ALF |  | 51.0        | 39.1        | 30.9        | 28.4        | 26.2        |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 4.5 ~ 5.5   | 2.5 ~ 3.1   |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.63 ~ 1.05 | 0.31 ~ 0.51 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.30BS            | Al            | STD   |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 961             | RH | 2.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 3421            | KH | 8.5 | 199.0  | 255.0 | 291.0 | 312.0 |     |     |     |     | 0.0       |
| 2                 | 3422            | KH | 8.0 | -      | 170.0 | 206.0 | 227.0 |     |     |     |     | 85.0      |
| 3                 | 3423            | KH | 8.0 | -      | -     | 166.0 | 187.0 |     |     |     |     | 40.0      |
| 4                 | 3424            | LC | 8.0 | -      | -     | -     | 157.0 |     |     |     |     | 30.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 962             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 3431            | KH | 7.2 | 204.0  | 255.0 | 291.0 | 312.0 |     |     |     |     | 0.0       |
| 2                 | 3432            | KH | 7.0 | -      | 170.0 | 206.0 | 227.0 |     |     |     |     | 85.0      |
| 3                 | 3433            | KH | 6.4 | -      | -     | 166.0 | 187.0 |     |     |     |     | 40.0      |
| 4                 | 3434            | LC | 7.0 | -      | -     | -     | 157.0 |     |     |     |     | 30.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 962             | RH | 1.0 |        |       |       |       |     |     |     |     |           |
| 1                 | 3441            | KH | 6.0 | 209.0  | 255.0 | 291.0 | 312.0 |     |     |     |     | 0.0       |
| 2                 | 3442            | KH | 6.0 | -      | 170.0 | 206.0 | 227.0 |     |     |     |     | 85.0      |
| 3                 | 3443            | KH | 4.8 | -      | -     | 166.0 | 187.0 |     |     |     |     | 40.0      |
| 4                 | 3444            | LC | 6.0 | -      | -     | -     | 157.0 |     |     |     |     | 30.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.30BS            | Al            | STD   |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 963             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 3451            | KH | 5.5 | 209.0  | 260.0 | 292.0 | 309.0 |     |     |     |     | 0.0       |
| 2                 | 3452            | KH | 5.5 | -      | 175.0 | 207.0 | 224.0 |     |     |     |     | 85.0      |
| 3                 | 3453            | KH | 4.1 | -      | -     | 165.0 | 182.0 |     |     |     |     | 42.0      |
| 4                 | 3454            | LC | 6.0 | -      | -     | -     | 157.0 |     |     |     |     | 25.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 963             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 3461            | KH | 5.0 | 209.0  | 256.0 | 294.0 | 312.0 |     |     |     |     | 0.0       |
| 2                 | 3462            | KH | 5.0 | -      | 171.0 | 209.0 | 227.0 |     |     |     |     | 85.0      |
| 3                 | 3463            | KH | 3.5 | -      | -     | 164.0 | 182.0 |     |     |     |     | 45.0      |
| 4                 | 3464            | LC | 6.0 | -      | -     | -     | 157.0 |     |     |     |     | 25.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 964             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 3471            | KH | 4.5 | 211.0  | 256.0 | 294.0 | 313.0 |     |     |     |     | 0.0       |
| 2                 | 3472            | KH | 5.0 | -      | 171.0 | 209.0 | 228.0 |     |     |     |     | 85.0      |
| 3                 | 3473            | KH | 3.2 | -      | -     | 164.0 | 183.0 |     |     |     |     | 45.0      |
| 4                 | 3474            | LC | 5.5 | -      | -     | -     | 158.0 |     |     |     |     | 25.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.30BS            | Al            | STD   |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 964             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 3481            | KH | 4.0 | 213.0  | 256.0 | 295.0 | 314.0 |     |     |     |     | 0.0       |
| 2                 | 3482            | KH | 5.0 | -      | 171.0 | 210.0 | 229.0 |     |     |     |     | 85.0      |
| 3                 | 3483            | KH | 3.0 | -      | -     | 165.0 | 184.0 |     |     |     |     | 45.0      |
| 4                 | 3484            | LC | 5.0 | -      | -     | -     | 159.0 |     |     |     |     | 25.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 3491            | KH | 3.2 | 216.0  | 258.0 | 298.0 | 316.0 |     |     |     |     | 0.0       |
| 2                 | 3492            | KH | 4.5 | -      | 171.0 | 211.0 | 229.0 |     |     |     |     | 87.0      |
| 3                 | 3493            | KH | 2.9 | -      | -     | 166.0 | 184.0 |     |     |     |     | 45.0      |
| 4                 | 3494            | LC | 4.7 | -      | -     | -     | 159.0 |     |     |     |     | 25.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 3501            | KH | 2.4 | 219.0  | 261.0 | 302.0 | 319.0 |     |     |     |     | 0.0       |
| 2                 | 3502            | KH | 4.0 | -      | 171.0 | 212.0 | 229.0 |     |     |     |     | 90.0      |
| 3                 | 3503            | KH | 2.8 | -      | -     | 167.0 | 184.0 |     |     |     |     | 45.0      |
| 4                 | 3504            | LC | 4.5 | -      | -     | -     | 159.0 |     |     |     |     | 25.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.30BS            | Al            | STD   |

Thickness 125 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 3511            | KH | 1.9 | 219.0  | 263.0 | 301.0 | 318.0 |     |     |     |     | 0.0       |
| 2                 | 3512            | KH | 4.0 | -      | 173.0 | 211.0 | 228.0 |     |     |     |     | 90.0      |
| 3                 | 3513            | KH | 2.8 | -      | -     | 166.0 | 183.0 |     |     |     |     | 45.0      |
| 4                 | 3514            | LC | 4.5 | -      | -     | -     | 158.0 |     |     |     |     | 25.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 150 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 3521            | KH | 1.4 | 219.0  | 265.0 | 301.0 | 317.0 |     |     |     |     | 0.0       |
| 2                 | 3522            | KH | 4.0 | -      | 175.0 | 211.0 | 227.0 |     |     |     |     | 90.0      |
| 3                 | 3523            | KH | 2.8 | -      | -     | 166.0 | 182.0 |     |     |     |     | 45.0      |
| 4                 | 3524            | LC | 4.5 | -      | -     | -     | 157.0 |     |     |     |     | 25.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 200 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 3531            | KH | 1.0 | 221.0  | 272.0 | 312.0 | 327.0 |     |     |     |     | 0.0       |
| 2                 | 3532            | KH | 4.0 | -      | 172.0 | 212.0 | 227.0 |     |     |     |     | 100.0     |
| 3                 | 3533            | KH | 2.8 | -      | -     | 167.0 | 182.0 |     |     |     |     | 45.0      |
| 4                 | 3534            | LC | 4.0 | -      | -     | -     | 157.0 |     |     |     |     | 25.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.30BS            | Al            | STD   |

Thickness 250 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 3541            | KH | 1.0 | 224.0  | 276.0 | 325.0 | 337.0 |     |     |     |     | 0.0       |
| 2                 | 3542            | KH | 4.0 | -      | 171.0 | 220.0 | 232.0 |     |     |     |     | 105.0     |
| 3                 | 3543            | KH | 2.6 | -      | -     | 170.0 | 182.0 |     |     |     |     | 50.0      |
| 4                 | 3544            | LC | 4.0 | -      | -     | -     | 157.0 |     |     |     |     | 25.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 15.0  | 13.0  | 8.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 2.50  | 1.80  | 1.00  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Al            | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                   | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-------------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 961                   | 3421                  | 3422                     | 3423                     | 3424                    |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                       | LC                      |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                       | SL                      |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                       | 8                        | 8                       |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 11.0                  | 6.0                      | 5.0                      | 2.5                     |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                        |                         |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                        | 1                       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 4                     | 3                        | 2                        | 2                       |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 12                    | 3                        | 4                        | 9                       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                        | 1                       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                        | 1                        | 1                       |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 58.0<br>(55.0 ~ 61.0) | 135.0<br>(133.0 ~ 137.0) | 111.0<br>(109.0 ~ 113.0) | 100.0<br>(98.0 ~ 102.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | OFF                     |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                      | OFF                     |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                       | 10                      |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                       | 14                      |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                      |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                      |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                        | 4                       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                      |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                       |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 8.5                   | 8.0                      | 8.0                      | 8.0                     |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                     |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                     |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 199.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 255.0 | 170.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 291.0 | 206.0 | 166.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 312.0 | 227.0 | 187.0 | 157.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 40.0  | 30.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 15.3 ~ 18.7 | 10.4 ~ 12.8 | 9.5 ~ 11.6  | 7.9 ~ 8.8   |  |  |  |
| Average Voltage Gap  | V   |  | 53 ~ 70     | 127 ~ 142   | 103 ~ 118   | 106 ~ 123   |  |  |  |
| Avg. Linear Feedrate | ALF |  | 1020.0      | 413.7       | 250.2       | 166.9       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Al            | 30mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 962                   | 3431                  | 3432                     | 3433                     | 3434                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                       | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                       | 8                        | 8                     |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 11.0                  | 6.0                      | 5.0                      | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                        |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                        | 2                        | 2                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 11                    | 3                        | 4                        | 9                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                        | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 57.0<br>(54.0 ~ 60.0) | 132.0<br>(130.0 ~ 134.0) | 108.0<br>(106.0 ~ 110.0) | 85.0<br>(83.0 ~ 87.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                       | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 7.2                   | 7.0                      | 6.4                      | 7.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 204.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 255.0 | 170.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 291.0 | 206.0 | 166.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 312.0 | 227.0 | 187.0 | 157.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 40.0  | 30.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 13.2 ~ 16.1 | 10.1 ~ 12.4 | 8.7 ~ 10.7  | 7.0 ~ 7.7   |  |  |  |
| Average Voltage Gap  | V   |  | 51 ~ 67     | 125 ~ 140   | 101 ~ 115   | 98 ~ 115    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 879.0       | 381.8       | 230.6       | 151.4       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Al            | 40mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 962                   | 3441                  | 3442                     | 3443                     | 3444                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                       | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                       | 8                        | 8                     |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                      | 5.0                      | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                        |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                        | 2                        | 2                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 10                    | 3                        | 4                        | 9                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                        | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 57.0<br>(54.0 ~ 60.0) | 130.0<br>(128.0 ~ 132.0) | 105.0<br>(103.0 ~ 107.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                       | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 6.0                   | 6.0                      | 4.8                      | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 209.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 255.0 | 170.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 291.0 | 206.0 | 166.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 312.0 | 227.0 | 187.0 | 157.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 40.0  | 30.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 11.0 ~ 13.4 | 9.9 ~ 12.1  | 8.0 ~ 9.7   | 6.0 ~ 6.6   |  |  |  |
| Average Voltage Gap  | V   |  | 49 ~ 64     | 123 ~ 137   | 99 ~ 112    | 91 ~ 107    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 732.0       | 347.1       | 209.9       | 135.0       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Al            | 50mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                   | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 963                   | 3451                  | 3452                     | 3453                    | 3454                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                      | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                      | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                       | 8                       | 8                     |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                      | 5.0                     | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                       | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                        | 2                       | 2                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 9                     | 3                        | 4                       | 9                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                       | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                        | 1                       | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 56.0<br>(53.0 ~ 59.0) | 127.0<br>(125.0 ~ 129.0) | 100.0<br>(98.0 ~ 102.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                     | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                     | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                      | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                      | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                      | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                      | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                       | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                      | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                       | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 5.5                   | 5.5                      | 4.1                     | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                     | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                     | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 209.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 260.0 | 175.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 292.0 | 207.0 | 165.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 309.0 | 224.0 | 182.0 | 157.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 42.0  | 25.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 9.0 ~ 10.9  | 9.2 ~ 11.2  | 7.4 ~ 9.0   | 6.0 ~ 6.6   |  |  |  |
| Average Voltage Gap  | V   |  | 49 ~ 63     | 120 ~ 135   | 95 ~ 108    | 85 ~ 100    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 597.0       | 302.2       | 187.2       | 125.2       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Al            | 60mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 963                   | 3461                  | 3462                     | 3463                  | 3464                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                       | 8                     | 8                     |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                      | 5.0                   | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                     |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                        | 2                     | 2                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 8                     | 3                        | 4                     | 9                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 55.0<br>(52.0 ~ 58.0) | 125.0<br>(123.0 ~ 127.0) | 95.0<br>(93.0 ~ 97.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 5.0                   | 5.0                      | 3.5                   | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 209.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 256.0 | 171.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 294.0 | 209.0 | 164.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 312.0 | 227.0 | 182.0 | 157.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 45.0  | 25.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 6.9 ~ 8.4   | 8.5 ~ 10.3  | 6.8 ~ 8.3   | 5.9 ~ 6.5   |  |  |  |
| Average Voltage Gap  | V   |  | 49 ~ 63     | 118 ~ 133   | 92 ~ 105    | 79 ~ 94     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 459.0       | 253.1       | 162.4       | 113.0       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Al            | 70mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 964                   | 3471                  | 3472                     | 3473                  | 3474                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                       | 8                     | 8                     |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                      | 5.0                   | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                     |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                        | 2                     | 2                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 8                     | 3                        | 4                     | 9                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 55.0<br>(52.0 ~ 58.0) | 124.0<br>(122.0 ~ 126.0) | 95.0<br>(93.0 ~ 97.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 4.5                   | 5.0                      | 3.2                   | 5.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 211.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 256.0 | 171.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 294.0 | 209.0 | 164.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 313.0 | 228.0 | 183.0 | 158.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 45.0  | 25.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 6.0 ~ 7.3   | 8.2 ~ 10.0  | 6.3 ~ 7.7   | 5.5 ~ 6.0   |  |  |  |
| Average Voltage Gap  | V   |  | 48 ~ 62     | 117 ~ 132   | 90 ~ 104    | 77 ~ 93     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 399.0       | 230.5       | 148.8       | 104.0       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Al            | 80mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 964                   | 3481                  | 3482                     | 3483                  | 3484                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                       | 8                     | 8                     |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                      | 5.0                   | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                     |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                        | 2                     | 2                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 8                     | 3                        | 4                     | 9                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 55.0<br>(52.0 ~ 58.0) | 123.0<br>(121.0 ~ 125.0) | 95.0<br>(93.0 ~ 97.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 4.0                   | 5.0                      | 3.0                   | 5.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 213.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 256.0 | 171.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 295.0 | 210.0 | 165.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 314.0 | 229.0 | 184.0 | 159.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 85.0  | 45.0  | 25.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 5.0 ~ 6.2   | 8.0 ~ 9.8   | 5.8 ~ 7.1   | 5.1 ~ 5.6   |  |  |  |
| Average Voltage Gap  | V   |  | 47 ~ 62     | 116 ~ 131   | 89 ~ 103    | 76 ~ 91     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 336.0       | 206.2       | 134.5       | 94.8        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Al            | 90mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3491                  | 3492                     | 3493                  | 3494                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                       | 8                     | 8                     |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                      | 5.0                   | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                     |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                        | 2                     | 2                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 8                     | 3                        | 4                     | 9                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 54.0<br>(51.0 ~ 57.0) | 121.0<br>(119.0 ~ 123.0) | 94.0<br>(92.0 ~ 96.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 3.2                   | 4.5                      | 2.9                   | 4.7                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 216.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 258.0 | 171.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 298.0 | 211.0 | 166.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 316.0 | 229.0 | 184.0 | 159.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 87.0  | 45.0  | 25.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 4.5 ~ 5.6   | 7.2 ~ 8.9   | 5.3 ~ 6.5   | 4.8 ~ 5.3   |  |  |  |
| Average Voltage Gap  | V   |  | 46 ~ 61     | 113 ~ 127   | 87 ~ 104    | 73 ~ 87     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 303.0       | 186.2       | 122.0       | 87.0        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Al            | 100mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3501                  | 3502                     | 3503                  | 3504                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                       | 8                     | 8                     |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                      | 5.0                   | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                     |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                        | 2                     | 2                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 8                     | 3                        | 4                     | 9                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 53.0<br>(50.0 ~ 56.0) | 119.0<br>(117.0 ~ 121.0) | 94.0<br>(92.0 ~ 96.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 2.4                   | 4.0                      | 2.8                   | 4.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 219.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 261.0 | 171.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 302.0 | 212.0 | 167.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 319.0 | 229.0 | 184.0 | 159.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 45.0  | 25.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 4.1 ~ 5.0   | 6.5 ~ 8.0   | 4.9 ~ 6.0   | 4.6 ~ 5.0   |  |  |  |
| Average Voltage Gap  | V   |  | 46 ~ 61     | 111 ~ 124   | 86 ~ 100    | 70 ~ 84     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 273.0       | 167.7       | 110.9       | 80.1        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Al            | 125mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3511                  | 3512                     | 3513                  | 3514                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                       | 8                     | 9                     |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                      | 5.0                   | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                     |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                        | 2                     | 2                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 8                     | 3                        | 4                     | 8                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 53.0<br>(50.0 ~ 56.0) | 116.0<br>(114.0 ~ 118.0) | 90.0<br>(88.0 ~ 92.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 1.9                   | 4.0                      | 2.8                   | 4.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 219.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 263.0 | 173.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 301.0 | 211.0 | 166.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 318.0 | 228.0 | 183.0 | 158.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 45.0  | 25.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.3 ~ 4.0   | 5.7 ~ 7.0   | 5.0 ~ 6.0   | 4.6 ~ 5.0   |  |  |  |
| Average Voltage Gap  | V   |  | 45 ~ 61     | 108 ~ 123   | 82 ~ 97     | 66 ~ 80     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 219.0       | 139.1       | 97.8        | 73.0        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Al            | 150mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3521                  | 3522                     | 3523                  | 3524                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                       | 8                     | 10                    |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                      | 5.0                   | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                     |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 6                     | 3                        | 2                     | 2                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 8                     | 3                        | 4                     | 7                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 53.0<br>(50.0 ~ 56.0) | 113.0<br>(111.0 ~ 115.0) | 86.0<br>(84.0 ~ 88.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 1.4                   | 4.0                      | 2.8                   | 4.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 219.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 265.0 | 175.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 301.0 | 211.0 | 166.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 317.0 | 227.0 | 182.0 | 157.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 45.0  | 25.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.5 ~ 3.0   | 4.9 ~ 6.0   | 5.0 ~ 6.1   | 4.6 ~ 5.1   |  |  |  |
| Average Voltage Gap  | V   |  | 45 ~ 61     | 106 ~ 122   | 79 ~ 94     | 63 ~ 87     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 165.0       | 109.7       | 82.5        | 64.3        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Al            | 200mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3531                  | 3532                     | 3533                  | 3534                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                       | 8                     | 10                    |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                      | 5.0                   | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                     |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                        | 2                     | 2                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 8                     | 3                        | 4                     | 7                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                        | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 55.0<br>(52.0 ~ 58.0) | 103.0<br>(101.0 ~ 105.0) | 81.0<br>(79.0 ~ 83.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 1.0                   | 4.0                      | 2.8                   | 4.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 221.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 272.0 | 172.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 312.0 | 212.0 | 167.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 327.0 | 227.0 | 182.0 | 157.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 100.0 | 45.0  | 25.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.1 ~ 1.4   | 4.1 ~ 5.1   | 3.5 ~ 4.2   | 4.0 ~ 4.4   |  |  |  |
| Average Voltage Gap  | V   |  | 47 ~ 63     | 95 ~ 111    | 72 ~ 88     | 52 ~ 69     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 75.0        | 59.0        | 47.0        | 39.6        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Al            | 250mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                  | Skim2                 | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|------------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3541                  | 3542                   | 3543                  | 3544                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                     | KH                    | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                     | NM                    | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 12                     | 8                     | 10                    |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                    | 5.0                   | 2.5                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                      | 8                     |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                      | 1                     | 1                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                      | 2                     | 2                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 8                     | 3                      | 4                     | 7                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                      | 1                     | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 5                     | 1                      | 1                     | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 57.0<br>(54.0 ~ 60.0) | 98.0<br>(96.0 ~ 100.0) | 78.0<br>(76.0 ~ 80.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                    | OFF                   | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                    | OFF                   | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                     | 10                    | 10                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                     | 14                    | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                     | 14                    | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                     | NM                    | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                      | 4                     | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                     | 10                    | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                      | 0                     | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 1.0                   | 4.0                    | 2.6                   | 4.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                    | 1.0                   | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                    | 1.0                   | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 224.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 276.0 | 171.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 325.0 | 220.0 | 170.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 337.0 | 232.0 | 182.0 | 157.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 105.0 | 50.0  | 25.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.0   | 3.9 ~ 4.7   | 2.3 ~ 2.8   | 4.0 ~ 4.4   |  |  |  |
| Average Voltage Gap  | V   |  | 48 ~ 69     | 89 ~ 109    | 69 ~ 87     | 46 ~ 64     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 54.0        | 44.7        | 34.6        | 30.4        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 7.2 ~ 8.8   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.90 ~ 1.50 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.30BS            | Cu            | STD   |

Thickness 20 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 961             | RH | 2.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 3621            | KH | 4.0  | 205.0  | 255.0 | 282.0 | 290.0 |     |     |     |     | 0.0       |
| 2                 | 3622            | KH | 8.0  | -      | 165.0 | 192.0 | 200.0 |     |     |     |     | 90.0      |
| 3                 | 3623            | KH | 6.0  | -      | -     | 162.0 | 170.0 |     |     |     |     | 30.0      |
| 4                 | 3624            | LC | 14.0 | -      | -     | -     | 155.0 |     |     |     |     | 15.0      |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 30 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 962             | RH | 1.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 3631            | KH | 3.0  | 206.0  | 255.0 | 283.0 | 291.0 |     |     |     |     | 0.0       |
| 2                 | 3632            | KH | 7.5  | -      | 165.0 | 193.0 | 201.0 |     |     |     |     | 90.0      |
| 3                 | 3633            | KH | 5.5  | -      | -     | 163.0 | 171.0 |     |     |     |     | 30.0      |
| 4                 | 3634            | LC | 12.0 | -      | -     | -     | 156.0 |     |     |     |     | 15.0      |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |      | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 962             | RH | 1.0  |        |       |       |       |     |     |     |     |           |
| 1                 | 3641            | KH | 2.0  | 208.0  | 256.0 | 285.0 | 292.0 |     |     |     |     | 0.0       |
| 2                 | 3642            | KH | 7.0  | -      | 166.0 | 195.0 | 202.0 |     |     |     |     | 90.0      |
| 3                 | 3643            | KH | 5.0  | -      | -     | 165.0 | 172.0 |     |     |     |     | 30.0      |
| 4                 | 3644            | LC | 10.0 | -      | -     | -     | 157.0 |     |     |     |     | 15.0      |
| 5                 |                 |    |      | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |      | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |      | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |      | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra   | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.30BS            | Cu            | STD   |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 963             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 3651            | KH | 2.0 | 210.0  | 258.0 | 286.0 | 292.0 |     |     |     |     | 0.0       |
| 2                 | 3652            | KH | 6.0 | -      | 168.0 | 196.0 | 202.0 |     |     |     |     | 90.0      |
| 3                 | 3653            | KH | 4.5 | -      | -     | 166.0 | 172.0 |     |     |     |     | 30.0      |
| 4                 | 3654            | LC | 8.5 | -      | -     | -     | 157.0 |     |     |     |     | 15.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 963             | RH | 0.7 |        |       |       |       |     |     |     |     |           |
| 1                 | 3661            | KH | 2.0 | 212.0  | 261.0 | 287.0 | 293.0 |     |     |     |     | 0.0       |
| 2                 | 3662            | KH | 5.0 | -      | 171.0 | 197.0 | 203.0 |     |     |     |     | 90.0      |
| 3                 | 3663            | KH | 4.0 | -      | -     | 167.0 | 173.0 |     |     |     |     | 30.0      |
| 4                 | 3664            | LC | 7.0 | -      | -     | -     | 158.0 |     |     |     |     | 15.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 964             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 3671            | KH | 1.6 | 213.0  | 262.0 | 287.0 | 293.0 |     |     |     |     | 0.0       |
| 2                 | 3672            | KH | 4.5 | -      | 172.0 | 197.0 | 203.0 |     |     |     |     | 90.0      |
| 3                 | 3673            | KH | 4.0 | -      | -     | 167.0 | 173.0 |     |     |     |     | 30.0      |
| 4                 | 3674            | LC | 6.5 | -      | -     | -     | 158.0 |     |     |     |     | 15.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.30BS            | Cu            | STD   |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 964             | RH | 0.6 |        |       |       |       |     |     |     |     |           |
| 1                 | 3681            | KH | 1.3 | 215.0  | 264.0 | 288.0 | 294.0 |     |     |     |     | 0.0       |
| 2                 | 3682            | KH | 4.0 | -      | 174.0 | 198.0 | 204.0 |     |     |     |     | 90.0      |
| 3                 | 3683            | KH | 4.0 | -      | -     | 168.0 | 174.0 |     |     |     |     | 30.0      |
| 4                 | 3684            | LC | 6.0 | -      | -     | -     | 159.0 |     |     |     |     | 15.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 3691            | KH | 1.1 | 214.0  | 266.0 | 297.0 | 304.0 |     |     |     |     | 0.0       |
| 2                 | 3692            | KH | 3.5 | -      | 174.0 | 205.0 | 212.0 |     |     |     |     | 92.0      |
| 3                 | 3693            | KH | 3.5 | -      | -     | 170.0 | 177.0 |     |     |     |     | 35.0      |
| 4                 | 3694            | LC | 5.5 | -      | -     | -     | 160.0 |     |     |     |     | 17.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |       |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th | 6th | 7th | 8th | Increment |
| A                 | 965             | RH | 0.5 |        |       |       |       |     |     |     |     |           |
| 1                 | 3701            | KH | 0.9 | 214.0  | 270.0 | 308.0 | 317.0 |     |     |     |     | 0.0       |
| 2                 | 3702            | KH | 3.0 | -      | 175.0 | 213.0 | 222.0 |     |     |     |     | 95.0      |
| 3                 | 3703            | KH | 3.0 | -      | -     | 173.0 | 182.0 |     |     |     |     | 40.0      |
| 4                 | 3704            | LC | 5.0 | -      | -     | -     | 162.0 |     |     |     |     | 20.0      |
| 5                 |                 |    |     | -      | -     | -     | -     |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -     | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 6.0   | 5.0   |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.80  | 0.70  |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Cu            | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 961                   | 3621                  | 3622                     | 3623                     | 3624                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                       | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                        | 12                    |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 12.0                  | 6.0                      | 5.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                        |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                        | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                        | 2                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 12                    | 10                       | 10                       | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 1                     | 1                        | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 64.0<br>(61.0 ~ 67.0) | 117.0<br>(115.0 ~ 119.0) | 106.0<br>(104.0 ~ 108.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 9                        | 9                        | 9                     |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 4.0                   | 8.0                      | 6.0                      | 14.0                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 205.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 255.0 | 165.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 282.0 | 192.0 | 162.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 290.0 | 200.0 | 170.0 | 155.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 15.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 7.1 ~ 8.6   | 9.9 ~ 12.1  | 8.7 ~ 10.7  | 14.0 ~ 15.4 |  |  |  |
| Average Voltage Gap  | V   |  | 57 ~ 72     | 111 ~ 125   | 99 ~ 112    | 93 ~ 107    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 471.0       | 274.9       | 186.7       | 154.1       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Cu            | 30mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 962                   | 3631                  | 3632                     | 3633                     | 3634                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                       | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                        | 13                    |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                      | 5.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                        |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                        | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                        | 2                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 10                    | 10                       | 10                       | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 1                     | 1                        | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 63.0<br>(60.0 ~ 66.0) | 116.0<br>(114.0 ~ 118.0) | 105.0<br>(103.0 ~ 107.0) | 85.0<br>(83.0 ~ 87.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 9                        | 10                       | 11                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 3.0                   | 7.5                      | 5.5                      | 12.0                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 206.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 255.0 | 165.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 283.0 | 193.0 | 163.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 291.0 | 201.0 | 171.0 | 156.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 15.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 5.6 ~ 6.8   | 8.1 ~ 9.9   | 7.3 ~ 9.0   | 11.6 ~ 12.6 |  |  |  |
| Average Voltage Gap  | V   |  | 57 ~ 72     | 109 ~ 123   | 97 ~ 111    | 93 ~ 107    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 372.0       | 220.3       | 151.9       | 125.6       |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Cu            | 40mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 962                   | 3641                  | 3642                     | 3643                     | 3644                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                       | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                        | 14                    |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                      | 5.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                        |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                        | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                        | 2                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 8                     | 10                       | 10                       | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 1                     | 1                        | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 62.0<br>(59.0 ~ 65.0) | 115.0<br>(113.0 ~ 117.0) | 104.0<br>(102.0 ~ 106.0) | 90.0<br>(88.0 ~ 92.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 12                       | 12                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.0                   | 7.0                      | 5.0                      | 10.0                  |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 208.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 256.0 | 166.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 285.0 | 195.0 | 165.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 292.0 | 202.0 | 172.0 | 157.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 15.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 4.1 ~ 5.0   | 6.3 ~ 7.7   | 5.9 ~ 7.3   | 9.6 ~ 10.6  |  |  |  |
| Average Voltage Gap  | V   |  | 57 ~ 72     | 107 ~ 122   | 96 ~ 111    | 94 ~ 108    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 273.0       | 165.5       | 116.7       | 97.9        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Cu            | 50mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 963                   | 3651                  | 3652                     | 3653                     | 3654                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                       | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                        | 14                    |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                      | 5.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 8                        |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                        | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                        | 2                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 6                     | 10                       | 10                       | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 1                     | 1                        | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 62.0<br>(59.0 ~ 65.0) | 115.0<br>(113.0 ~ 117.0) | 103.0<br>(101.0 ~ 105.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 12                       | 12                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 2.0                   | 6.0                      | 4.5                      | 8.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 210.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 258.0 | 168.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 286.0 | 196.0 | 166.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 292.0 | 202.0 | 172.0 | 157.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 15.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 3.4 ~ 4.1   | 5.9 ~ 7.2   | 5.7 ~ 7.0   | 8.5 ~ 9.5   |  |  |  |
| Average Voltage Gap  | V   |  | 55 ~ 71     | 106 ~ 123   | 94 ~ 109    | 86 ~ 100    |  |  |  |
| Avg. Linear Feedrate | ALF |  | 225.0       | 143.1       | 104.0       | 87.2        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Cu            | 60mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 963                   | 3661                  | 3662                     | 3663                     | 3664                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                       | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                        | 14                    |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                      | 5.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 9                        |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                        | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                        | 2                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                       | 10                       | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 1                     | 1                        | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 62.0<br>(59.0 ~ 65.0) | 115.0<br>(113.0 ~ 117.0) | 102.0<br>(100.0 ~ 104.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 12                       | 12                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 2.0                   | 5.0                      | 4.0                      | 7.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 212.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 261.0 | 171.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 287.0 | 197.0 | 167.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 293.0 | 203.0 | 173.0 | 158.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 15.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.7 ~ 3.3   | 5.5 ~ 6.8   | 5.5 ~ 6.8   | 7.0 ~ 7.8   |  |  |  |
| Average Voltage Gap  | V   |  | 54 ~ 70     | 106 ~ 124   | 93 ~ 108    | 79 ~ 93     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 180.0       | 121.0       | 91.1        | 75.6        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Cu            | 70mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 964                   | 3671                  | 3672                     | 3673                     | 3674                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                       | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                        | 14                    |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 6.0                      | 5.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 9                        | 9                        |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                        | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 3                        | 2                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                       | 10                       | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 1                     | 1                        | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 61.0<br>(58.0 ~ 64.0) | 115.0<br>(113.0 ~ 117.0) | 103.0<br>(101.0 ~ 105.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 12                       | 12                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.6                   | 4.5                      | 4.0                      | 6.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 213.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 262.0 | 172.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 287.0 | 197.0 | 167.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 293.0 | 203.0 | 173.0 | 158.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 15.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.4 ~ 3.0   | 4.7 ~ 5.8   | 5.7 ~ 6.6   | 6.5 ~ 7.5   |  |  |  |
| Average Voltage Gap  | V   |  | 52 ~ 68     | 107 ~ 123   | 94 ~ 109    | 75 ~ 90     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 162.0       | 107.0       | 82.9        | 69.3        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Cu            | 80mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 964                   | 3681                  | 3682                     | 3683                     | 3684                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                       | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                        | 14                    |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 7.0                      | 6.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                       | 10                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                        | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 4                        | 3                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                       | 10                       | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 1                     | 1                        | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(57.0 ~ 63.0) | 115.0<br>(113.0 ~ 117.0) | 104.0<br>(102.0 ~ 106.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 12                       | 12                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.3                   | 4.0                      | 4.0                      | 6.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 215.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 264.0 | 174.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 288.0 | 198.0 | 168.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 294.0 | 204.0 | 174.0 | 159.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 90.0  | 30.0  | 15.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.2 ~ 2.7   | 3.9 ~ 4.7   | 6.1 ~ 6.4   | 6.1 ~ 6.8   |  |  |  |
| Average Voltage Gap  | V   |  | 51 ~ 67     | 108 ~ 123   | 95 ~ 111    | 71 ~ 87     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 147.0       | 93.6        | 74.9        | 62.8        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Cu            | 90mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3691                  | 3692                     | 3693                     | 3694                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                       | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                        | 14                    |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 7.0                      | 6.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                       | 10                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                        | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 4                        | 3                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 4                     | 10                       | 10                       | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 1                     | 1                        | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 59.0<br>(56.0 ~ 62.0) | 114.0<br>(112.0 ~ 116.0) | 104.0<br>(102.0 ~ 106.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 12                       | 12                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 1.1                   | 3.5                      | 3.5                      | 5.5                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 214.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 266.0 | 174.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 297.0 | 205.0 | 170.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 304.0 | 212.0 | 177.0 | 160.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 92.0  | 35.0  | 17.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 2.0 ~ 2.5   | 3.5 ~ 4.3   | 4.4 ~ 4.9   | 5.5 ~ 6.5   |  |  |  |
| Average Voltage Gap  | V   |  | 50 ~ 66     | 106 ~ 122   | 95 ~ 111    | 69 ~ 84     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 135.0       | 85.6        | 65.5        | 55.4        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.30BS           | Cu            | 100mm              | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                    | Skim3                 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|--------------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 965                   | 3701                  | 3702                     | 3703                     | 3704                  |       |       |       |       |
| Power Supply       | PS  | RH                    | KH                    | KH                       | KH                       | LC                    |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                       | SL                    |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                       | 8                        | 14                    |       |       |       |       |
| Power Setting      | IP  | 9.0                   | 12.0                  | 7.0                      | 6.0                      | 2.0                   |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 10                       | 10                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 1                     | 1                        | 1                        | 6                     |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 9                     | 4                        | 3                        | 1                     |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 4                     | 10                       | 10                       | 6                     |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                        | 1                        | 1                     |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 1                     | 1                        | 1                        | 1                     |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 58.0<br>(55.0 ~ 61.0) | 113.0<br>(111.0 ~ 115.0) | 104.0<br>(102.0 ~ 106.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                      | OFF                   |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                       | 12                       | 12                    |       |       |       |       |
| Wire Tension       | WT  | 9                     | 13                    | 14                       | 14                       | 14                    |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                       | 14                    |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                       | NM                    |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                        | 4                     |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                       | 10                    |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                        | 0                     |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.9                   | 3.0                      | 3.0                      | 5.0                   |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                      | 1.0                   |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 214.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 270.0 | 175.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 308.0 | 213.0 | 173.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 317.0 | 222.0 | 182.0 | 162.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 95.0  | 40.0  | 20.0  |       |       |       |       |

| RESULTS              |     |  |             |             |             |             |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|--|--|--|
| Feedrate Cutting     | FC  |  | 1.8 ~ 2.2   | 3.2 ~ 3.9   | 2.7 ~ 3.3   | 4.8 ~ 5.3   |  |  |  |
| Average Voltage Gap  | V   |  | 50 ~ 66     | 105 ~ 121   | 96 ~ 111    | 68 ~ 83     |  |  |  |
| Avg. Linear Feedrate | ALF |  | 120.0       | 76.8        | 53.8        | 45.7        |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 4.5 ~ 5.5   |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.63 ~ 1.05 |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**5-4 ø0.10 Wire**  
**Machining Characteristics Data**

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.10BS            | STEEL         | STD   |

Thickness 5 mm

| No.               | Cutting process |    |      | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 931             | KL | 1.0  |        |      |       |       |       |     |     |     |           |
| 1                 | 4011            | RH | 2.4  | 57.0   | 94.0 | 116.0 | 127.0 | 131.0 |     |     |     | 0.0       |
| 2                 | 4012            | RL | 5.4  | -      | 54.0 | 76.0  | 87.0  | 91.0  |     |     |     | 40.0      |
| 3                 | 4013            | RL | 5.4  | -      | -    | 56.0  | 67.0  | 71.0  |     |     |     | 20.0      |
| 4                 | 4014            | LC | 12.5 | -      | -    | -     | 61.0  | 65.0  |     |     |     | 6.0       |
| 5                 | 4015            | LA | 9.0  | -      | -    | -     | -     | 57.0  |     |     |     | 8.0       |
| 6                 |                 |    |      | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |      | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |      | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra   | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |      | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 931             | KL | 1.0  |        |      |       |       |       |     |     |     |           |
| 1                 | 4021            | RH | 1.3  | 62.0   | 94.0 | 116.0 | 127.0 | 131.0 |     |     |     | 0.0       |
| 2                 | 4022            | RL | 4.8  | -      | 54.0 | 76.0  | 87.0  | 91.0  |     |     |     | 40.0      |
| 3                 | 4023            | RL | 4.8  | -      | -    | 56.0  | 67.0  | 71.0  |     |     |     | 20.0      |
| 4                 | 4024            | LC | 11.0 | -      | -    | -     | 61.0  | 65.0  |     |     |     | 6.0       |
| 5                 | 4025            | LA | 8.0  | -      | -    | -     | -     | 59.0  |     |     |     | 6.0       |
| 6                 |                 |    |      | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |      | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |      | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra   | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |      | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 931             | KL | 1.0  |        |      |       |       |       |     |     |     |           |
| 1                 | 4031            | RL | 0.9  | 62.0   | 95.0 | 115.0 | 126.0 | 129.0 |     |     |     | 0.0       |
| 2                 | 4032            | RL | 4.2  | -      | 55.0 | 75.0  | 86.0  | 89.0  |     |     |     | 40.0      |
| 3                 | 4033            | RL | 4.2  | -      | -    | 55.0  | 66.0  | 69.0  |     |     |     | 20.0      |
| 4                 | 4034            | LC | 11.0 | -      | -    | -     | 61.0  | 64.0  |     |     |     | 5.0       |
| 5                 | 4035            | LA | 7.4  | -      | -    | -     | -     | 56.0  |     |     |     | 8.0       |
| 6                 |                 |    |      | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |      | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |      | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra   | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.10BS            | STEEL         | STD   |

Thickness 30 mm

| No,               | Cutting process |    |     | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 932             | KL | 0.6 |        |      |       |       |       |     |     |     |           |
| 1                 | 4041            | RL | 0.7 | 67.0   | 92.0 | 113.0 | 124.0 | 128.0 |     |     |     | 0.0       |
| 2                 | 4042            | RL | 3.9 | -      | 55.0 | 76.0  | 87.0  | 91.0  |     |     |     | 37.0      |
| 3                 | 4043            | RL | 3.9 | -      | -    | 56.0  | 67.0  | 71.0  |     |     |     | 20.0      |
| 4                 | 4044            | LC | 9.5 | -      | -    | -     | 60.0  | 64.0  |     |     |     | 7.0       |
| 5                 | 4045            | LA | 6.2 | -      | -    | -     | -     | 57.0  |     |     |     | 7.0       |
| 6                 |                 |    |     | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No,               | Cutting process |    |     | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 932             | KL | 0.6 |        |      |       |       |       |     |     |     |           |
| 1                 | 4051            | RL | 0.5 | 73.0   | 99.0 | 123.0 | 134.0 | 139.0 |     |     |     | 0.0       |
| 2                 | 4052            | RL | 3.6 | -      | 54.0 | 78.0  | 89.0  | 94.0  |     |     |     | 45.0      |
| 3                 | 4053            | RL | 3.6 | -      | -    | 58.0  | 69.0  | 74.0  |     |     |     | 20.0      |
| 4                 | 4054            | LC | 8.0 | -      | -    | -     | 60.0  | 65.0  |     |     |     | 9.0       |
| 5                 | 4055            | LA | 5.0 | -      | -    | -     | -     | 59.0  |     |     |     | 6.0       |
| 6                 |                 |    |     | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No,               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | STEEL         | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                    | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 4011                  | 4012                  | 4013                  | 4014                     | 4015                     |       |       |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                       | LA                       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 10                       | 10                       |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 3.0                      | 2.0                      |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                          |                          |       |       |       |
| Off Time           | OFF | 1                     | 3                     | 10                    | 10                    | 1                        | 1                        |       |       |       |
| Stabilizer A       | SA  | 1                     | 2                     | 1                     | 1                     | 1                        | 1                        |       |       |       |
| Stabilizer B       | SB  | 16                    | 12                    | 10                    | 10                    | 1                        | 1                        |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                        |       |       |       |
| Stabilizer E       | SE  | 5                     | 4                     | 1                     | 1                     | 1                        | 1                        |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 50.0<br>(47.0 ~ 53.0) | 44.0<br>(42.0 ~ 46.0) | 54.0<br>(52.0 ~ 56.0) | 150.0<br>(148.0 ~ 152.0) | 105.0<br>(103.0 ~ 107.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                      |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 11                    | 11                    | 10                       | 10                       |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                        | 3                        |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                       | 13                       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 6                     | 4                        | 4                        |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.4                   | 5.4                   | 5.4                   | 12.5                     | 9.0                      |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 57.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 94.0  | 54.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 116.0 | 76.0  | 56.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 127.0 | 87.0  | 67.0  | 61.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 131.0 | 91.0  | 71.0  | 65.0  | 57.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 20.0  | 6.0   | 8.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 4.5 ~ 5.6   | 7.4 ~ 9.0   | 8.7 ~ 10.6  | 11.7 ~ 13.0 | 8.4 ~ 9.3   |  |  |
| Average Voltage Gap  | V   |  | 43 ~ 64     | 33 ~ 56     | 51 ~ 61     | 164 ~ 177   | 116 ~ 129   |  |  |
| Avg. Linear Feedrate | ALF |  | 303.0       | 187.5       | 141.6       | 118.9       | 97.2        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | STEEL         | 10mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                   | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-------------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 4021                  | 4022                  | 4023                  | 4024                     | 4025                    |       |       |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                       | LA                      |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                      |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 10                       | 10                      |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 3.0                      | 2.0                     |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                          |                         |       |       |       |
| Off Time           | OFF | 1                     | 3                     | 8                     | 8                     | 1                        | 1                       |       |       |       |
| Stabilizer A       | SA  | 1                     | 2                     | 1                     | 1                     | 1                        | 1                       |       |       |       |
| Stabilizer B       | SB  | 16                    | 12                    | 8                     | 8                     | 1                        | 1                       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                       |       |       |       |
| Stabilizer E       | SE  | 5                     | 4                     | 1                     | 1                     | 1                        | 1                       |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 57.0<br>(54.0 ~ 60.0) | 44.0<br>(42.0 ~ 46.0) | 48.0<br>(46.0 ~ 50.0) | 140.0<br>(138.0 ~ 142.0) | 100.0<br>(98.0 ~ 102.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                      |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                     |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 11                    | 11                    | 10                       | 10                      |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                        | 3                       |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                       | 13                      |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                      |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 6                     | 4                        | 4                       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                      |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.3                   | 4.8                   | 4.8                   | 11.0                     | 8.0                     |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                     |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                     |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 62.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 94.0  | 54.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 116.0 | 76.0  | 56.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 127.0 | 87.0  | 67.0  | 61.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 131.0 | 91.0  | 71.0  | 65.0  | 59.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 20.0  | 6.0   | 6.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 2.5 ~ 3.0   | 6.2 ~ 7.6   | 7.5 ~ 9.2   | 10.2 ~ 11.3 | 7.4 ~ 8.2   |  |  |
| Average Voltage Gap  | V   |  | 46 ~ 68     | 33 ~ 55     | 45 ~ 55     | 151 ~ 168   | 107 ~ 122   |  |  |
| Avg. Linear Feedrate | ALF |  | 165.0       | 118.0       | 95.5        | 83.2        | 70.6        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | STEEL         | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 4031                  | 4032                  | 4033                  | 4034                     | 4035                  |       |       |       |
| Power Supply       | PS  | KL                    | RL                    | RL                    | RL                    | LC                       | LA                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 10                       | 10                    |       |       |       |
| Power Setting      | IP  | 4.0                   | 5.0                   | 4.0                   | 4.0                   | 3.0                      | 2.0                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 15                    | 10                    | 10                    |                          |                       |       |       |       |
| Off Time           | OFF | 1                     | 4                     | 6                     | 6                     | 1                        | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Stabilizer B       | SB  | 16                    | 12                    | 6                     | 6                     | 1                        | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     |       |       |       |
| Stabilizer E       | SE  | 5                     | 4                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 52.0<br>(49.0 ~ 55.0) | 44.0<br>(42.0 ~ 46.0) | 42.0<br>(40.0 ~ 44.0) | 110.0<br>(108.0 ~ 112.0) | 90.0<br>(88.0 ~ 92.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 11                    | 11                    | 10                       | 10                    |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                        | 3                     |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                       | 13                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 6                     | 4                        | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 0.9                   | 4.2                   | 4.2                   | 11.0                     | 7.4                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 62.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 95.0  | 55.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 115.0 | 75.0  | 55.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 126.0 | 86.0  | 66.0  | 61.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 129.0 | 89.0  | 69.0  | 64.0  | 56.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 20.0  | 5.0   | 8.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.2 ~ 1.6   | 5.0 ~ 6.2   | 7.4 ~ 9.1   | 10.3 ~ 11.4 | 7.0 ~ 7.7   |  |  |
| Average Voltage Gap  | V   |  | 39 ~ 63     | 40 ~ 51     | 39 ~ 49     | 136 ~ 146   | 102 ~ 113   |  |  |
| Avg. Linear Feedrate | ALF |  | 84.0        | 67.2        | 59.2        | 54.2        | 48.3        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | STEEL         | 30mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 932                   | 4041                  | 4042                  | 4043                  | 4044                  | 4045                  |       |       |       |
| Power Supply       | PS  | KL                    | RL                    | RL                    | RL                    | LC                    | LA                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 12                    |       |       |       |
| Power Setting      | IP  | 4.0                   | 5.0                   | 4.0                   | 4.0                   | 3.0                   | 2.0                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 15                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 1                     | 4                     | 5                     | 5                     | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 15                    | 12                    | 5                     | 5                     | 1                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 5                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 56.0<br>(53.0 ~ 59.0) | 43.0<br>(41.0 ~ 45.0) | 41.0<br>(39.0 ~ 43.0) | 95.0<br>(93.0 ~ 97.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                     | 3                     |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                    | 13                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 6                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.7                   | 3.9                   | 3.9                   | 9.5                   | 6.2                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 67.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 92.0  | 55.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 113.0 | 76.0  | 56.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 124.0 | 87.0  | 67.0  | 60.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 128.0 | 91.0  | 71.0  | 64.0  | 57.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 37.0  | 20.0  | 7.0   | 7.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.9 ~ 1.2   | 4.0 ~ 5.5   | 5.8 ~ 7.1   | 9.0 ~ 10.0  | 5.7 ~ 6.7   |  |  |
| Average Voltage Gap  | V   |  | 38 ~ 63     | 41 ~ 52     | 38 ~ 48     | 118 ~ 130   | 90 ~ 100    |  |  |
| Avg. Linear Feedrate | ALF |  | 63.0        | 51.6        | 45.5        | 42.2        | 37.9        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | STEEL         | 40mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 932                   | 4051                  | 4052                  | 4053                  | 4054                  | 4055                  |       |       |       |
| Power Supply       | PS  | KL                    | RL                    | RL                    | RL                    | LC                    | LA                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 13                    |       |       |       |
| Power Setting      | IP  | 4.0                   | 5.0                   | 5.0                   | 4.0                   | 3.0                   | 2.0                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 15                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 1                     | 4                     | 4                     | 4                     | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 15                    | 12                    | 4                     | 4                     | 1                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 5                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 60.0<br>(57.0 ~ 63.0) | 42.0<br>(40.0 ~ 44.0) | 40.0<br>(38.0 ~ 42.0) | 80.0<br>(78.0 ~ 82.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                     | 3                     |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                    | 13                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 6                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.5                   | 3.6                   | 3.6                   | 8.0                   | 5.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 73.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 99.0  | 54.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 123.0 | 78.0  | 58.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 134.0 | 89.0  | 69.0  | 60.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 139.0 | 94.0  | 74.0  | 65.0  | 59.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 45.0  | 20.0  | 9.0   | 6.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.6 ~ 0.8   | 3.9 ~ 4.8   | 4.2 ~ 5.2   | 7.4 ~ 8.2   | 4.8 ~ 5.3   |  |  |
| Average Voltage Gap  | V   |  | 38 ~ 62     | 42 ~ 53     | 37 ~ 47     | 99 ~ 114    | 81 ~ 96     |  |  |
| Avg. Linear Feedrate | ALF |  | 42.0        | 36.2        | 32.1        | 30.0        | 27.3        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.10BS            | STEEL         | STDPO1 |

Thickness 5 mm

| No.               | Cutting process |    |      | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 931             | KL | 1.0  |        |      |       |       |       |     |     |     |           |
| 1                 | 17411           | RH | 2.4  | 64.0   | 95.0 | 116.0 | 127.0 | 131.0 |     |     |     | 0.0       |
| 2                 | 17412           | RL | 5.4  | -      | 55.0 | 76.0  | 87.0  | 91.0  |     |     |     | 40.0      |
| 3                 | 17413           | RL | 5.4  | -      | -    | 56.0  | 67.0  | 71.0  |     |     |     | 20.0      |
| 4                 | 17414           | LC | 12.5 | -      | -    | -     | 61.0  | 65.0  |     |     |     | 6.0       |
| 5                 | 17415           | LA | 9.0  | -      | -    | -     | -     | 57.0  |     |     |     | 8.0       |
| 6                 |                 |    |      | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |      | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |      | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra   | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 10.0mm |
| Lower      | 5.0mm  |

Thickness 10 mm

| No.               | Cutting process |    |      | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 931             | KL | 1.0  |        |      |       |       |       |     |     |     |           |
| 1                 | 17421           | RH | 1.0  | 63.0   | 94.0 | 117.0 | 127.0 | 130.0 |     |     |     | 0.0       |
| 2                 | 17422           | RL | 4.8  | -      | 54.0 | 77.0  | 87.0  | 90.0  |     |     |     | 40.0      |
| 3                 | 17423           | RL | 4.8  | -      | -    | 57.0  | 67.0  | 70.0  |     |     |     | 20.0      |
| 4                 | 17424           | LC | 11.0 | -      | -    | -     | 61.0  | 64.0  |     |     |     | 6.0       |
| 5                 | 17425           | LA | 8.0  | -      | -    | -     | -     | 58.0  |     |     |     | 6.0       |
| 6                 |                 |    |      | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |      | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |      | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra   | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 10.0mm |
| Lower      | 5.0mm  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |       |
|--------------------|---------------|--------------------|---------|------------|---------------------|-------|
|                    |               |                    |         |            | Upper               | Lower |
| φ 0.10BS           | STEEL         | 5mm                | STDPO1  | φ 4.0mm    | 10.0mm              | 5.0mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                    | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 17411                 | 17412                 | 17413                 | 17414                    | 17415                    |       |       |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                       | LA                       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |
| Voltage Open       | Vo  | 7                     | 5                     | 4                     | 4                     | 10                       | 10                       |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 3.0                      | 2.0                      |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                          |                          |       |       |       |
| Off Time           | OFF | 1                     | 4                     | 10                    | 10                    | 1                        | 1                        |       |       |       |
| Stabilizer A       | SA  | 1                     | 2                     | 1                     | 1                     | 1                        | 1                        |       |       |       |
| Stabilizer B       | SB  | 16                    | 13                    | 10                    | 10                    | 1                        | 1                        |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                        |       |       |       |
| Stabilizer E       | SE  | 5                     | 4                     | 1                     | 1                     | 1                        | 1                        |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 52.0<br>(49.0 ~ 55.0) | 44.0<br>(42.0 ~ 46.0) | 54.0<br>(52.0 ~ 56.0) | 160.0<br>(158.0 ~ 162.0) | 135.0<br>(133.0 ~ 137.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                      |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 11                    | 11                    | 10                       | 10                       |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                        | 3                        |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                       | 13                       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 6                     | 4                        | 4                        |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.4                   | 5.4                   | 5.4                   | 12.5                     | 9.0                      |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 64.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 95.0  | 55.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 116.0 | 76.0  | 56.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 127.0 | 87.0  | 67.0  | 61.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 131.0 | 91.0  | 71.0  | 65.0  | 57.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 20.0  | 6.0   | 8.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 3.7 ~ 4.6   | 8.7 ~ 10.7  | 8.2 ~ 10.0  | 11.6 ~ 12.9 | 8.4 ~ 9.3   |  |  |
| Average Voltage Gap  | V   |  | 40 ~ 60     | 33 ~ 54     | 51 ~ 61     | 169 ~ 182   | 144 ~ 159   |  |  |
| Avg. Linear Feedrate | ALF |  | 249.0       | 174.4       | 132.2       | 112.0       | 92.5        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |       |
|--------------------|---------------|--------------------|---------|------------|---------------------|-------|
|                    |               |                    |         |            | Upper               | Lower |
| φ 0.10BS           | STEEL         | 10mm               | STDPO1  | φ 4.0mm    | 10.0mm              | 5.0mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 17421                 | 17422                 | 17423                 | 17424                    | 17425                 |       |       |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                       | LA                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 10                       | 10                    |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 3.0                      | 2.0                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                          |                       |       |       |       |
| Off Time           | OFF | 1                     | 4                     | 8                     | 8                     | 1                        | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Stabilizer B       | SB  | 16                    | 14                    | 8                     | 8                     | 1                        | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     |       |       |       |
| Stabilizer E       | SE  | 5                     | 4                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 62.0<br>(59.0 ~ 65.0) | 44.0<br>(42.0 ~ 46.0) | 48.0<br>(46.0 ~ 50.0) | 140.0<br>(138.0 ~ 142.0) | 95.0<br>(93.0 ~ 97.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 10                    | 11                    | 11                    | 10                       | 10                    |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                        | 3                     |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                       | 13                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 6                     | 4                        | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.0                   | 4.8                   | 4.8                   | 11.0                     | 8.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 63.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 94.0  | 54.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 117.0 | 77.0  | 57.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 127.0 | 87.0  | 67.0  | 61.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 130.0 | 90.0  | 70.0  | 64.0  | 58.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 20.0  | 6.0   | 6.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 2.0 ~ 2.5   | 7.5 ~ 9.2   | 6.3 ~ 7.7   | 10.2 ~ 11.3 | 7.4 ~ 8.2   |  |  |
| Average Voltage Gap  | V   |  | 34 ~ 59     | 31 ~ 55     | 45 ~ 55     | 152 ~ 167   | 105 ~ 120   |  |  |
| Avg. Linear Feedrate | ALF |  | 135.0       | 106.3       | 84.9        | 75.0        | 64.6        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.10BS            | WC-Co         | STD   |

Thickness 5 mm

| No.               | Cutting process |    |      | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 931             | KL | 1.0  |        |      |       |       |       |     |     |     |           |
| 1                 | 4111            | RH | 0.8  | 55.0   | 89.0 | 104.0 | 111.0 | 115.0 |     |     |     | 0.0       |
| 2                 | 4112            | RL | 5.4  | -      | 54.0 | 69.0  | 76.0  | 80.0  |     |     |     | 35.0      |
| 3                 | 4113            | RL | 5.4  | -      | -    | 59.0  | 66.0  | 70.0  |     |     |     | 10.0      |
| 4                 | 4114            | LC | 12.5 | -      | -    | -     | 56.0  | 60.0  |     |     |     | 10.0      |
| 5                 | 4115            | LA | 9.5  | -      | -    | -     | -     | 56.0  |     |     |     | 4.0       |
| 6                 |                 |    |      | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |      | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |      | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 15.0   | 14.0 | 11.0  | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra   | 2.50   | 2.00 | 1.50  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |      | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 931             | KL | 1.0  |        |      |       |       |       |     |     |     |           |
| 1                 | 4121            | RH | 0.5  | 56.0   | 90.0 | 104.0 | 112.0 | 115.0 |     |     |     | 0.0       |
| 2                 | 4122            | RL | 4.8  | -      | 55.0 | 69.0  | 77.0  | 80.0  |     |     |     | 35.0      |
| 3                 | 4123            | RL | 3.9  | -      | -    | 59.0  | 67.0  | 70.0  |     |     |     | 10.0      |
| 4                 | 4124            | LC | 11.0 | -      | -    | -     | 57.0  | 60.0  |     |     |     | 10.0      |
| 5                 | 4125            | LA | 8.0  | -      | -    | -     | -     | 56.0  |     |     |     | 4.0       |
| 6                 |                 |    |      | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |      | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |      | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 15.0   | 14.0 | 11.0  | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra   | 2.50   | 2.00 | 1.50  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |      | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 931             | KL | 1.0  |        |      |       |       |       |     |     |     |           |
| 1                 | 4131            | RH | 0.4  | 61.0   | 88.0 | 107.0 | 114.0 | 117.0 |     |     |     | 0.0       |
| 2                 | 4132            | RL | 4.2  | -      | 53.0 | 72.0  | 79.0  | 82.0  |     |     |     | 35.0      |
| 3                 | 4133            | RL | 3.2  | -      | -    | 62.0  | 69.0  | 72.0  |     |     |     | 10.0      |
| 4                 | 4134            | LC | 10.5 | -      | -    | -     | 58.0  | 61.0  |     |     |     | 11.0      |
| 5                 | 4135            | LA | 7.0  | -      | -    | -     | -     | 58.0  |     |     |     | 3.0       |
| 6                 |                 |    |      | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |      | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |      | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 15.0   | 14.0 | 11.0  | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra   | 2.50   | 2.00 | 1.50  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.10BS            | WC-Co         | STD   |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 932             | KL | 0.6 |        |      |       |       |       |     |     |     |           |
| 1                 | 4141            | RH | 0.3 | 65.0   | 89.0 | 108.0 | 116.0 | 118.0 |     |     |     | 0.0       |
| 2                 | 4142            | RL | 3.9 | -      | 52.0 | 71.0  | 79.0  | 81.0  |     |     |     | 37.0      |
| 3                 | 4143            | RL | 2.5 | -      | -    | 61.0  | 69.0  | 71.0  |     |     |     | 10.0      |
| 4                 | 4144            | LC | 9.5 | -      | -    | -     | 57.0  | 59.0  |     |     |     | 12.0      |
| 5                 | 4145            | LA | 6.0 | -      | -    | -     | -     | 56.0  |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0  | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 932             | KL | 0.6 |        |      |       |       |       |     |     |     |           |
| 1                 | 4151            | RH | 0.3 | 70.0   | 92.0 | 111.0 | 120.0 | 120.0 |     |     |     | 0.0       |
| 2                 | 4152            | RL | 3.6 | -      | 52.0 | 71.0  | 80.0  | 80.0  |     |     |     | 40.0      |
| 3                 | 4153            | RL | 1.8 | -      | -    | 61.0  | 70.0  | 70.0  |     |     |     | 10.0      |
| 4                 | 4154            | LC | 8.0 | -      | -    | -     | 57.0  | 57.0  |     |     |     | 13.0      |
| 5                 | 4155            | LA | 5.0 | -      | -    | -     | -     | 54.0  |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0  | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | WC-Co         | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                    | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 4111                  | 4112                  | 4113                  | 4114                     | 4115                     |       |       |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                       | LA                       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                       | 13                       |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 3.0                      | 2.0                      |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                          |                          |       |       |       |
| Off Time           | OFF | 1                     | 3                     | 10                    | 10                    | 1                        | 1                        |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 1                        | 1                        |       |       |       |
| Stabilizer B       | SB  | 16                    | 15                    | 10                    | 10                    | 1                        | 1                        |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                        |       |       |       |
| Stabilizer E       | SE  | 5                     | 5                     | 1                     | 1                     | 1                        | 1                        |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 60.0<br>(57.0 ~ 63.0) | 46.0<br>(44.0 ~ 48.0) | 58.0<br>(56.0 ~ 60.0) | 140.0<br>(138.0 ~ 142.0) | 125.0<br>(123.0 ~ 127.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                      |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 11                    | 10                       | 10                       |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                        | 3                        |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                       | 13                       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 4                     | 4                        | 4                        |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 0.8                   | 5.4                   | 5.4                   | 12.5                     | 9.5                      |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 55.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 89.0  | 54.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 104.0 | 69.0  | 59.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 111.0 | 76.0  | 66.0  | 56.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 115.0 | 80.0  | 70.0  | 60.0  | 56.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 35.0  | 10.0  | 10.0  | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.4 ~ 1.7   | 4.8 ~ 5.9   | 7.2 ~ 8.8   | 11.7 ~ 12.9 | 9.1 ~ 10.0  |  |  |
| Average Voltage Gap  | V   |  | 47 ~ 72     | 33 ~ 55     | 49 ~ 65     | 151 ~ 162   | 140 ~ 153   |  |  |
| Avg. Linear Feedrate | ALF |  | 93.0        | 72.1        | 62.7        | 57.8        | 52.5        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | WC-Co         | 10mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 4121                  | 4122                  | 4123                  | 4124                     | 4125                  |       |       |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                       | LA                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                       | 13                    |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 3.0                      | 2.0                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                          |                       |       |       |       |
| Off Time           | OFF | 1                     | 3                     | 9                     | 9                     | 1                        | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Stabilizer B       | SB  | 16                    | 14                    | 9                     | 9                     | 1                        | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     |       |       |       |
| Stabilizer E       | SE  | 5                     | 5                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 58.0<br>(55.0 ~ 61.0) | 46.0<br>(44.0 ~ 48.0) | 52.0<br>(50.0 ~ 54.0) | 110.0<br>(108.0 ~ 112.0) | 85.0<br>(83.0 ~ 87.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 11                    | 10                       | 10                    |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                        | 3                     |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                       | 13                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 4                     | 4                        | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 0.5                   | 4.8                   | 3.9                   | 11.0                     | 8.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 56.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 90.0  | 55.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 104.0 | 69.0  | 59.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 112.0 | 77.0  | 67.0  | 57.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 115.0 | 80.0  | 70.0  | 60.0  | 56.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 35.0  | 10.0  | 10.0  | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.0   | 3.0 ~ 3.7   | 4.8 ~ 5.8   | 10.4 ~ 11.5 | 7.7 ~ 8.5   |  |  |
| Average Voltage Gap  | V   |  | 48 ~ 70     | 38 ~ 56     | 44 ~ 62     | 125 ~ 140   | 94 ~ 109    |  |  |
| Avg. Linear Feedrate | ALF |  | 54.0        | 42.6        | 37.5        | 35.5        | 33.1        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | WC-Co         | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 4131                  | 4132                  | 4133                  | 4134                  | 4135                  |       |       |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                    | LA                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 13                    |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 3.0                   | 2.0                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 1                     | 3                     | 8                     | 8                     | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 16                    | 13                    | 8                     | 8                     | 1                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 5                     | 5                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 50.0<br>(47.0 ~ 53.0) | 46.0<br>(44.0 ~ 48.0) | 50.0<br>(48.0 ~ 52.0) | 75.0<br>(73.0 ~ 77.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                     | 3                     |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                    | 13                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 0.4                   | 4.2                   | 3.2                   | 10.5                  | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 61.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 88.0  | 53.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 107.0 | 72.0  | 62.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 114.0 | 79.0  | 69.0  | 58.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 117.0 | 82.0  | 72.0  | 61.0  | 58.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 35.0  | 10.0  | 11.0  | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.6 ~ 0.8   | 2.4 ~ 3.0   | 2.7 ~ 3.3   | 9.9 ~ 11.0  | 7.2 ~ 8.0   |  |  |
| Average Voltage Gap  | V   |  | 41 ~ 61     | 36 ~ 57     | 41 ~ 60     | 91 ~ 107    | 79 ~ 93     |  |  |
| Avg. Linear Feedrate | ALF |  | 42.0        | 33.4        | 28.1        | 26.9        | 25.4        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | WC-Co         | 30mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 932                   | 4141                  | 4142                  | 4143                  | 4144                  | 4145                  |       |       |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                    | LA                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 13                    |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 3.0                   | 2.0                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 1                     | 3                     | 7                     | 7                     | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 15                    | 13                    | 7                     | 7                     | 1                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 5                     | 5                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 50.0<br>(47.0 ~ 53.0) | 42.0<br>(40.0 ~ 44.0) | 43.0<br>(41.0 ~ 45.0) | 62.0<br>(60.0 ~ 64.0) | 57.0<br>(55.0 ~ 59.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                     | 3                     |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                    | 13                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.3                   | 3.9                   | 2.5                   | 9.5                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 65.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 89.0  | 52.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 108.0 | 71.0  | 61.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 116.0 | 79.0  | 69.0  | 57.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 118.0 | 81.0  | 71.0  | 59.0  | 56.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 37.0  | 10.0  | 12.0  | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.4 ~ 0.7   | 2.3 ~ 2.8   | 2.2 ~ 2.7   | 9.0 ~ 10.0  | 5.5 ~ 6.5   |  |  |
| Average Voltage Gap  | V   |  | 42 ~ 60     | 32 ~ 53     | 34 ~ 53     | 77 ~ 90     | 66 ~ 84     |  |  |
| Avg. Linear Feedrate | ALF |  | 33.0        | 27.1        | 22.9        | 22.0        | 20.8        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | WC-Co         | 40mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 932                   | 4151                  | 4152                  | 4153                  | 4154                  | 4155                  |       |       |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                    | LA                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 13                    |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 4.0                   | 3.0                   | 2.0                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 1                     | 3                     | 6                     | 6                     | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 2                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 15                    | 12                    | 6                     | 6                     | 1                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 5                     | 5                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 50.0<br>(47.0 ~ 53.0) | 40.0<br>(38.0 ~ 42.0) | 37.0<br>(35.0 ~ 39.0) | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                     | 3                     |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                    | 13                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.3                   | 3.6                   | 1.8                   | 8.0                   | 5.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 70.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 92.0  | 52.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 111.0 | 71.0  | 61.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 120.0 | 80.0  | 70.0  | 57.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 120.0 | 80.0  | 70.0  | 57.0  | 54.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 10.0  | 13.0  | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.3 ~ 0.5   | 2.2 ~ 3.0   | 1.8 ~ 2.2   | 7.3 ~ 8.0   | 4.6 ~ 5.1   |  |  |
| Average Voltage Gap  | V   |  | 43 ~ 59     | 29 ~ 49     | 28 ~ 47     | 62 ~ 74     | 53 ~ 66     |  |  |
| Avg. Linear Feedrate | ALF |  | 24.0        | 20.8        | 17.7        | 17.1        | 16.1        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.10BS            | WC-Co         | STDPO1 |

Thickness 5 mm

| No.               | Cutting process |    |      | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 931             | KL | 1.0  |        |      |       |       |       |     |     |     |           |
| 1                 | 17611           | RH | 0.8  | 64.0   | 90.0 | 104.0 | 112.0 | 116.0 |     |     |     | 0.0       |
| 2                 | 17612           | RL | 5.4  | -      | 55.0 | 69.0  | 77.0  | 81.0  |     |     |     | 35.0      |
| 3                 | 17613           | RL | 5.4  | -      | -    | 59.0  | 67.0  | 71.0  |     |     |     | 10.0      |
| 4                 | 17614           | LC | 12.0 | -      | -    | -     | 57.0  | 61.0  |     |     |     | 10.0      |
| 5                 | 17615           | LA | 10.0 | -      | -    | -     | -     | 57.0  |     |     |     | 4.0       |
| 6                 |                 |    |      | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |      | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |      | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 15.0   | 14.0 | 11.0  | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra   | 2.50   | 2.00 | 1.50  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 10.0mm |
| Lower      | 5.0mm  |

Thickness 10 mm

| No.               | Cutting process |    |      | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|------|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA   | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 931             | KL | 1.0  |        |      |       |       |       |     |     |     |           |
| 1                 | 17621           | RH | 0.5  | 64.0   | 92.0 | 106.0 | 113.0 | 116.0 |     |     |     | 0.0       |
| 2                 | 17622           | RL | 4.8  | -      | 57.0 | 71.0  | 78.0  | 81.0  |     |     |     | 35.0      |
| 3                 | 17623           | RL | 3.9  | -      | -    | 61.0  | 68.0  | 71.0  |     |     |     | 10.0      |
| 4                 | 17624           | LC | 11.0 | -      | -    | -     | 58.0  | 61.0  |     |     |     | 10.0      |
| 5                 | 17625           | LA | 8.0  | -      | -    | -     | -     | 57.0  |     |     |     | 4.0       |
| 6                 |                 |    |      | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |      | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |      | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz   | 15.0   | 14.0 | 11.0  | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra   | 2.50   | 2.00 | 1.50  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 10.0mm |
| Lower      | 5.0mm  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |       |
|--------------------|---------------|--------------------|---------|------------|---------------------|-------|
|                    |               |                    |         |            | Upper               | Lower |
| φ 0.10BS           | WC-Co         | 5mm                | STDPO1  | φ 4.0mm    | 10.0mm              | 5.0mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                    | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 17611                 | 17612                 | 17613                 | 17614                    | 17615                    |       |       |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                       | LA                       |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                       |       |       |       |
| Voltage Open       | Vo  | 7                     | 10                    | 4                     | 4                     | 11                       | 13                       |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 3.0                      | 2.0                      |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                          |                          |       |       |       |
| Off Time           | OFF | 1                     | 3                     | 10                    | 10                    | 1                        | 1                        |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 1                        | 1                        |       |       |       |
| Stabilizer B       | SB  | 16                    | 15                    | 10                    | 10                    | 1                        | 1                        |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                        |       |       |       |
| Stabilizer E       | SE  | 5                     | 5                     | 1                     | 1                     | 1                        | 1                        |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 70.0<br>(67.0 ~ 73.0) | 46.0<br>(44.0 ~ 48.0) | 58.0<br>(56.0 ~ 60.0) | 140.0<br>(138.0 ~ 142.0) | 125.0<br>(123.0 ~ 127.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                      |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 11                    | 10                       | 10                       |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                        | 3                        |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                       | 13                       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                       |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 4                     | 4                        | 4                        |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                        |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 0.8                   | 5.4                   | 5.4                   | 12.0                     | 10.0                     |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                      |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 64.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 90.0  | 55.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 104.0 | 69.0  | 59.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 112.0 | 77.0  | 67.0  | 57.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 116.0 | 81.0  | 71.0  | 61.0  | 57.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 35.0  | 10.0  | 10.0  | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.3 ~ 1.6   | 5.5 ~ 6.7   | 8.9 ~ 10.9  | 11.6 ~ 12.8 | 9.0 ~ 10.0  |  |  |
| Average Voltage Gap  | V   |  | 47 ~ 72     | 33 ~ 55     | 49 ~ 65     | 151 ~ 162   | 140 ~ 153   |  |  |
| Avg. Linear Feedrate | ALF |  | 87.0        | 70.3        | 62.9        | 57.9        | 52.5        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |       |
|--------------------|---------------|--------------------|---------|------------|---------------------|-------|
|                    |               |                    |         |            | Upper               | Lower |
| φ 0.10BS           | WC-Co         | 10mm               | STDPO1  | φ 4.0mm    | 10.0mm              | 5.0mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 17621                 | 17622                 | 17623                 | 17624                    | 17625                 |       |       |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                       | LA                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 10                    | 4                     | 4                     | 10                       | 12                    |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 3.0                      | 2.0                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                          |                       |       |       |       |
| Off Time           | OFF | 1                     | 3                     | 9                     | 9                     | 1                        | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Stabilizer B       | SB  | 16                    | 14                    | 9                     | 9                     | 1                        | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     |       |       |       |
| Stabilizer E       | SE  | 5                     | 5                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 58.0<br>(55.0 ~ 61.0) | 46.0<br>(44.0 ~ 48.0) | 52.0<br>(50.0 ~ 54.0) | 110.0<br>(108.0 ~ 112.0) | 85.0<br>(83.0 ~ 87.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 11                    | 10                       | 10                    |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                        | 3                     |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                       | 13                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 4                     | 4                        | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 0.5                   | 4.8                   | 3.9                   | 11.0                     | 8.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 64.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 92.0  | 57.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 106.0 | 71.0  | 61.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 113.0 | 78.0  | 68.0  | 58.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 116.0 | 81.0  | 71.0  | 61.0  | 57.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 35.0  | 10.0  | 10.0  | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.7 ~ 0.9   | 4.0 ~ 4.9   | 4.0 ~ 4.9   | 10.2 ~ 11.3 | 7.7 ~ 8.5   |  |  |
| Average Voltage Gap  | V   |  | 48 ~ 70     | 38 ~ 56     | 44 ~ 62     | 125 ~ 140   | 94 ~ 109    |  |  |
| Avg. Linear Feedrate | ALF |  | 48.0        | 40.7        | 35.3        | 33.5        | 31.3        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.10BS            | Cu            | STD   |

Thickness 5 mm

| No.               | Cutting process |    |     | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 931             | KL | 1.0 |        |      |       |       |       |     |     |     |           |
| 1                 | 4611            | KL | 3.0 | 70.0   | 97.0 | 117.0 | 132.0 | 134.0 |     |     |     | 0.0       |
| 2                 | 4612            | RL | 4.4 | -      | 62.0 | 82.0  | 97.0  | 99.0  |     |     |     | 35.0      |
| 3                 | 4613            | RL | 4.9 | -      | -    | 62.0  | 77.0  | 79.0  |     |     |     | 20.0      |
| 4                 | 4614            | LC | 5.8 | -      | -    | -     | 62.0  | 64.0  |     |     |     | 15.0      |
| 5                 | 4615            | LA | 3.4 | -      | -    | -     | -     | 61.0  |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 11.0 | 8.0   | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.50 | 1.00  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 10.00mm |
| Lower      | 5.00mm  |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 931             | KL | 1.0 |        |      |       |       |       |     |     |     |           |
| 1                 | 4621            | KL | 1.7 | 72.0   | 97.0 | 118.0 | 132.0 | 134.0 |     |     |     | 0.0       |
| 2                 | 4622            | RL | 3.8 | -      | 62.0 | 83.0  | 97.0  | 99.0  |     |     |     | 35.0      |
| 3                 | 4623            | RL | 4.3 | -      | -    | 63.0  | 77.0  | 79.0  |     |     |     | 20.0      |
| 4                 | 4624            | LC | 5.2 | -      | -    | -     | 62.0  | 64.0  |     |     |     | 15.0      |
| 5                 | 4625            | LA | 2.8 | -      | -    | -     | -     | 61.0  |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 11.0 | 8.0   | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.50 | 1.00  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |         |
|------------|---------|
| Upper      | 10.00mm |
| Lower      | 5.00mm  |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 931             | KL | 1.0 |        |      |       |       |       |     |     |     |           |
| 1                 | 4631            | KL | 0.9 | 73.0   | 99.0 | 118.0 | 132.0 | 134.0 |     |     |     | 0.0       |
| 2                 | 4632            | RL | 3.2 | -      | 64.0 | 83.0  | 97.0  | 99.0  |     |     |     | 35.0      |
| 3                 | 4633            | RL | 3.7 | -      | -    | 63.0  | 77.0  | 79.0  |     |     |     | 20.0      |
| 4                 | 4634            | LC | 4.6 | -      | -    | -     | 62.0  | 64.0  |     |     |     | 15.0      |
| 5                 | 4635            | LA | 2.2 | -      | -    | -     | -     | 61.0  |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 11.0 | 8.0   | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.50 | 1.00  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | Cu            | 5mm                | STD     | φ 4.0mm    | 10.00mm             | 5.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 4611                  | 4612                  | 4613                  | 4614                     | 4615                  |       |       |       |
| Power Supply       | PS  | KL                    | KL                    | RL                    | RL                    | LC                       | LA                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 10                       | 10                    |       |       |       |
| Power Setting      | IP  | 4.0                   | 5.0                   | 4.0                   | 4.0                   | 3.0                      | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 10                    | 10                    | 10                    |                          |                       |       |       |       |
| Off Time           | OFF | 1                     | 1                     | 10                    | 10                    | 1                        | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Stabilizer B       | SB  | 16                    | 13                    | 10                    | 10                    | 1                        | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     |       |       |       |
| Stabilizer E       | SE  | 5                     | 4                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 60.0<br>(57.0 ~ 63.0) | 54.0<br>(52.0 ~ 56.0) | 60.0<br>(58.0 ~ 62.0) | 138.0<br>(136.0 ~ 140.0) | 84.0<br>(82.0 ~ 86.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 11                    | 10                       | 10                    |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                        | 3                     |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                       | 13                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 6                     | 4                        | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 3.0                   | 4.4                   | 4.9                   | 5.8                      | 3.4                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 70.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 97.0  | 62.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 117.0 | 82.0  | 62.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 132.0 | 97.0  | 77.0  | 62.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 134.0 | 99.0  | 79.0  | 64.0  | 61.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 35.0  | 20.0  | 15.0  | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 4.4 ~ 5.4   | 7.3 ~ 8.9   | 7.8 ~ 9.6   | 11.2 ~ 12.4 | 6.8 ~ 7.6   |  |  |
| Average Voltage Gap  | V   |  | 51 ~ 69     | 46 ~ 66     | 50 ~ 70     | 152 ~ 170   | 95 ~ 113    |  |  |
| Avg. Linear Feedrate | ALF |  | 294.0       | 183.2       | 135.6       | 113.8       | 90.1        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 9.9 ~ 12.1  | 7.2 ~ 8.8   | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.35 ~ 2.25 | 0.90 ~ 1.50 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | Cu            | 10mm               | STD     | φ 4.0mm    | 10.00mm             | 5.00mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 4621                  | 4622                  | 4623                  | 4624                     | 4625                  |       |       |       |
| Power Supply       | PS  | KL                    | KL                    | RL                    | RL                    | LC                       | LA                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 10                       | 10                    |       |       |       |
| Power Setting      | IP  | 4.0                   | 5.0                   | 4.0                   | 4.0                   | 3.0                      | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 11                    | 10                    | 10                    |                          |                       |       |       |       |
| Off Time           | OFF | 1                     | 1                     | 8                     | 8                     | 1                        | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Stabilizer B       | SB  | 16                    | 9                     | 8                     | 8                     | 1                        | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     |       |       |       |
| Stabilizer E       | SE  | 5                     | 4                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 60.0<br>(57.0 ~ 63.0) | 54.0<br>(52.0 ~ 56.0) | 58.0<br>(56.0 ~ 60.0) | 118.0<br>(116.0 ~ 120.0) | 64.0<br>(62.0 ~ 66.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 11                    | 10                       | 10                    |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                        | 3                     |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                       | 13                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 6                     | 4                        | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.7                   | 3.8                   | 4.3                   | 5.2                      | 2.8                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 72.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 97.0  | 62.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 118.0 | 83.0  | 63.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 132.0 | 97.0  | 77.0  | 62.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 134.0 | 99.0  | 79.0  | 64.0  | 61.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 35.0  | 20.0  | 15.0  | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 2.5 ~ 3.1   | 5.8 ~ 7.0   | 6.0 ~ 7.3   | 10.3 ~ 11.4 | 5.8 ~ 6.4   |  |  |
| Average Voltage Gap  | V   |  | 51 ~ 69     | 45 ~ 65     | 48 ~ 68     | 136 ~ 154   | 76 ~ 94     |  |  |
| Avg. Linear Feedrate | ALF |  | 168.0       | 116.9       | 90.4        | 79.4        | 65.2        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 9.9 ~ 12.1  | 7.2 ~ 8.8   | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.35 ~ 2.25 | 0.90 ~ 1.50 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | Cu            | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 4631                  | 4632                  | 4633                  | 4634                  | 4635                  |       |       |       |
| Power Supply       | PS  | KL                    | KL                    | RL                    | RL                    | LC                    | LA                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 10                    | 10                    |       |       |       |
| Power Setting      | IP  | 4.0                   | 5.0                   | 4.0                   | 4.0                   | 3.0                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 11                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 1                     | 1                     | 6                     | 6                     | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 2                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 16                    | 9                     | 6                     | 6                     | 1                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 5                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 60.0<br>(57.0 ~ 63.0) | 54.0<br>(52.0 ~ 56.0) | 52.0<br>(50.0 ~ 54.0) | 84.0<br>(82.0 ~ 86.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 11                    | 11                    | 10                    | 10                    |       |       |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                     | 3                     |       |       |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                    | 13                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 6                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 0.9                   | 3.2                   | 3.7                   | 4.6                   | 2.2                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 73.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 99.0  | 64.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 118.0 | 83.0  | 63.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 132.0 | 97.0  | 77.0  | 62.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 134.0 | 99.0  | 79.0  | 64.0  | 61.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 35.0  | 20.0  | 15.0  | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.3 ~ 1.7   | 3.6 ~ 4.4   | 5.2 ~ 6.3   | 9.3 ~ 10.3  | 4.7 ~ 5.1   |  |  |
| Average Voltage Gap  | V   |  | 51 ~ 69     | 44 ~ 64     | 42 ~ 62     | 101 ~ 119   | 50 ~ 67     |  |  |
| Avg. Linear Feedrate | ALF |  | 90.0        | 65.5        | 55.0        | 50.3        | 43.0        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 9.9 ~ 12.1  | 7.2 ~ 8.8   | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.35 ~ 2.25 | 0.90 ~ 1.50 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**5-5 ø0.15 Wire**  
**Machining Characteristics Data**

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.15BS            | STEEL         | STD   |

Thickness 5 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 971             | RH | 1.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 4711            | RH | 6.0 | 105.0  | 120.0 | 147.0 | 163.0 | 167.0 |     |     |     | 0.0       |
| 2                 | 4712            | RL | 9.0 | -      | 80.0  | 107.0 | 123.0 | 127.0 |     |     |     | 40.0      |
| 3                 | 4713            | HL | 9.0 | -      | -     | 77.0  | 93.0  | 97.0  |     |     |     | 30.0      |
| 4                 | 4714            | LC | 7.0 | -      | -     | -     | 83.0  | 87.0  |     |     |     | 10.0      |
| 5                 | 4715            | LC | 7.0 | -      | -     | -     | -     | 81.0  |     |     |     | 6.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 971             | RH | 1.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 4721            | RH | 4.0 | 102.0  | 120.0 | 141.0 | 157.0 | 158.0 |     |     |     | 0.0       |
| 2                 | 4722            | RL | 7.0 | -      | 80.0  | 101.0 | 117.0 | 118.0 |     |     |     | 40.0      |
| 3                 | 4723            | HL | 7.0 | -      | -     | 76.0  | 92.0  | 93.0  |     |     |     | 25.0      |
| 4                 | 4724            | LC | 6.5 | -      | -     | -     | 82.0  | 83.0  |     |     |     | 10.0      |
| 5                 | 4725            | LC | 6.5 | -      | -     | -     | -     | 81.0  |     |     |     | 2.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 971             | RH | 1.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 4731            | RH | 2.5 | 111.0  | 120.0 | 142.0 | 157.0 | 161.0 |     |     |     | 0.0       |
| 2                 | 4732            | RL | 6.0 | -      | 80.0  | 102.0 | 117.0 | 121.0 |     |     |     | 40.0      |
| 3                 | 4733            | HL | 6.0 | -      | -     | 77.0  | 92.0  | 96.0  |     |     |     | 25.0      |
| 4                 | 4734            | LC | 6.0 | -      | -     | -     | 80.0  | 84.0  |     |     |     | 12.0      |
| 5                 | 4735            | LC | 6.0 | -      | -     | -     | -     | 81.0  |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.15BS            | STEEL         | STD   |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 972             | RH | 0.6 |        |       |       |       |       |     |     |     |           |
| 1                 | 4741            | RH | 1.8 | 109.0  | 122.0 | 144.0 | 158.0 | 161.0 |     |     |     | 0.0       |
| 2                 | 4742            | RL | 5.0 | -      | 80.0  | 102.0 | 116.0 | 119.0 |     |     |     | 42.0      |
| 3                 | 4743            | HL | 5.0 | -      | -     | 77.0  | 91.0  | 94.0  |     |     |     | 25.0      |
| 4                 | 4744            | LC | 5.7 | -      | -     | -     | 80.0  | 83.0  |     |     |     | 11.0      |
| 5                 | 4745            | LC | 5.7 | -      | -     | -     | -     | 80.0  |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 972             | RH | 0.6 |        |       |       |       |       |     |     |     |           |
| 1                 | 4751            | RH | 1.2 | 108.0  | 125.0 | 147.0 | 163.0 | 166.0 |     |     |     | 0.0       |
| 2                 | 4752            | RL | 4.0 | -      | 80.0  | 102.0 | 118.0 | 121.0 |     |     |     | 45.0      |
| 3                 | 4753            | HL | 4.0 | -      | -     | 77.0  | 93.0  | 96.0  |     |     |     | 25.0      |
| 4                 | 4754            | LC | 5.5 | -      | -     | -     | 83.0  | 86.0  |     |     |     | 10.0      |
| 5                 | 4755            | LC | 5.5 | -      | -     | -     | -     | 82.0  |     |     |     | 4.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | STEEL         | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 4711                  | 4712                  | 4713                  | 4714                     | 4715                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | HL                    | LC                       | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 6                     | 6                     | 12                       | 8                     |       |       |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 2.5                      | 1.0                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 6                     |                          |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 14                    | 10                    | 1                        | 1                     |       |       |       |
| Stabilizer A       | SA  | 2                     | 2                     | 3                     | 1                     | 1                        | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 13                    | 14                    | 10                    | 1                        | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 76.0<br>(73.0 ~ 79.0) | 48.0<br>(46.0 ~ 50.0) | 70.0<br>(68.0 ~ 72.0) | 165.0<br>(163.0 ~ 167.0) | 90.0<br>(88.0 ~ 92.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                       | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                        | 7                     |       |       |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                       | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                        | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 6.0                   | 9.0                   | 9.0                   | 7.0                      | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 120.0 | 80.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 147.0 | 107.0 | 77.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 163.0 | 123.0 | 93.0  | 83.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 167.0 | 127.0 | 97.0  | 87.0  | 81.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 30.0  | 10.0  | 6.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 5.4 ~ 6.6   | 9.8 ~ 14.6  | 7.7 ~ 9.4   | 6.5 ~ 7.2   | 6.4 ~ 7.1   |  |  |
| Average Voltage Gap  | V   |  | 64 ~ 84     | 38 ~ 62     | 67 ~ 77     | 182 ~ 195   | 111 ~ 124   |  |  |
| Avg. Linear Feedrate | ALF |  | 360.0       | 241.3       | 164.1       | 117.3       | 90.9        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | STEEL         | 10mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 4721                  | 4722                  | 4723                  | 4724                     | 4725                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | HL                    | LC                       | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 6                     | 6                     | 10                       | 8                     |       |       |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                      | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 6                     |                          |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 12                    | 8                     | 1                        | 1                     |       |       |       |
| Stabilizer A       | SA  | 2                     | 2                     | 3                     | 1                     | 1                        | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 11                    | 12                    | 8                     | 1                        | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 62.0<br>(59.0 ~ 65.0) | 38.0<br>(36.0 ~ 40.0) | 70.0<br>(68.0 ~ 72.0) | 140.0<br>(138.0 ~ 142.0) | 95.0<br>(93.0 ~ 97.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                       | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                        | 7                     |       |       |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                       | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                        | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 4.0                   | 7.0                   | 7.0                   | 6.5                      | 6.5                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 102.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 120.0 | 80.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 141.0 | 101.0 | 76.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 157.0 | 117.0 | 92.0  | 82.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 158.0 | 118.0 | 93.0  | 83.0  | 81.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 25.0  | 10.0  | 2.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 10.7 ~ 13.0 | 7.3 ~ 8.9   | 7.3 ~ 8.9   | 6.0 ~ 6.6   | 6.0 ~ 6.6   |  |  |
| Average Voltage Gap  | V   |  | 48 ~ 68     | 27 ~ 51     | 67 ~ 77     | 151 ~ 164   | 117 ~ 129   |  |  |
| Avg. Linear Feedrate | ALF |  | 711.0       | 288.7       | 181.1       | 122.4       | 92.5        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | STEEL         | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                   | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 4731                  | 4732                  | 4733                  | 4734                    | 4735                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | HL                    | LC                      | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                      | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 6                     | 6                     | 10                      | 9                     |       |       |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                     | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 6                     |                         |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 10                    | 6                     | 1                       | 1                     |       |       |       |
| Stabilizer A       | SA  | 2                     | 2                     | 3                     | 1                     | 1                       | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 6                     | 10                    | 6                     | 1                       | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                       | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                       | 1                     |       |       |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 52.0<br>(49.0 ~ 55.0) | 30.0<br>(28.0 ~ 32.0) | 58.0<br>(56.0 ~ 60.0) | 100.0<br>(98.0 ~ 102.0) | 75.0<br>(73.0 ~ 77.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                      | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                     | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                      | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                       | 7                     |       |       |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                      | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                      | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                       | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                      | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                       | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.5                   | 6.0                   | 6.0                   | 6.0                     | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 111.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 120.0 | 80.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 142.0 | 102.0 | 77.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 157.0 | 117.0 | 92.0  | 80.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 161.0 | 121.0 | 96.0  | 84.0  | 81.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 25.0  | 12.0  | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 3.7 ~ 4.6   | 10.1 ~ 12.4 | 5.9 ~ 7.2   | 5.6 ~ 6.2   | 5.5 ~ 6.1   |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 60     | 27 ~ 44     | 55 ~ 65     | 120 ~ 132   | 90 ~ 103    |  |  |
| Avg. Linear Feedrate | ALF |  | 249.0       | 181.9       | 124.3       | 92.0        | 72.8        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | STEEL         | 30mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 972                   | 4741                  | 4742                  | 4743                  | 4744                  | 4745                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 7                     | 6                     | 10                    | 9                     |       |       |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 7                     |                       |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 10                    | 6                     | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 2                     | 2                     | 3                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 13                    | 6                     | 10                    | 5                     | 1                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 49.0<br>(46.0 ~ 52.0) | 30.0<br>(28.0 ~ 32.0) | 59.0<br>(57.0 ~ 61.0) | 85.0<br>(83.0 ~ 87.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                     | 7                     |       |       |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.8                   | 5.0                   | 5.0                   | 5.7                   | 5.7                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 122.0 | 80.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 144.0 | 102.0 | 77.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 158.0 | 116.0 | 91.0  | 80.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 161.0 | 119.0 | 94.0  | 83.0  | 80.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 42.0  | 25.0  | 11.0  | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 2.5 ~ 3.2   | 9.0 ~ 11.1  | 5.0 ~ 6.2   | 5.4 ~ 6.0   | 5.2 ~ 5.8   |  |  |
| Average Voltage Gap  | V   |  | 34 ~ 57     | 28 ~ 48     | 56 ~ 66     | 115 ~ 118   | 78 ~ 91     |  |  |
| Avg. Linear Feedrate | ALF |  | 171.0       | 133.2       | 95.4        | 74.6        | 60.8        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | STEEL         | 40mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 972                   | 4751                  | 4752                  | 4753                  | 4754                  | 4755                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 8                     | 7                     | 10                    | 10                    |       |       |       |
| Power Setting      | IP  | 5.0                   | 7.0                   | 6.0                   | 6.0                   | 3.0                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 8                     | 8                     |                       |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 9                     | 5                     | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 2                     | 2                     | 3                     | 2                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 13                    | 6                     | 9                     | 5                     | 1                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 46.0<br>(43.0 ~ 49.0) | 30.0<br>(28.0 ~ 32.0) | 60.0<br>(58.0 ~ 62.0) | 70.0<br>(68.0 ~ 72.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                     | 7                     |       |       |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.2                   | 4.0                   | 4.0                   | 5.5                   | 5.5                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 125.0 | 80.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 147.0 | 102.0 | 77.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 163.0 | 118.0 | 93.0  | 83.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 166.0 | 121.0 | 96.0  | 86.0  | 82.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 45.0  | 25.0  | 10.0  | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.4 ~ 1.8   | 8.0 ~ 9.8   | 4.2 ~ 5.2   | 5.2 ~ 5.8   | 5.0 ~ 5.5   |  |  |
| Average Voltage Gap  | V   |  | 33 ~ 55     | 29 ~ 53     | 57 ~ 67     | 90 ~ 104    | 66 ~ 79     |  |  |
| Avg. Linear Feedrate | ALF |  | 96.0        | 81.4        | 63.1        | 53.0        | 45.4        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.15BS            | STEEL         | STDPO1 |

Thickness 5 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 971             | RH | 1.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 17511           | RH | 6.0 | 105.0  | 120.0 | 148.0 | 164.0 | 167.0 |     |     |     | 0.0       |
| 2                 | 17512           | RL | 9.0 | -      | 80.0  | 108.0 | 124.0 | 127.0 |     |     |     | 40.0      |
| 3                 | 17513           | HL | 9.0 | -      | -     | 78.0  | 94.0  | 97.0  |     |     |     | 30.0      |
| 4                 | 17514           | LC | 7.0 | -      | -     | -     | 84.0  | 87.0  |     |     |     | 10.0      |
| 5                 | 17515           | LC | 7.0 | -      | -     | -     | -     | 81.0  |     |     |     | 6.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 10.0mm |
| Lower      | 5.0mm  |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 971             | RH | 1.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 17521           | RH | 4.0 | 107.0  | 120.0 | 144.0 | 158.0 | 158.0 |     |     |     | 0.0       |
| 2                 | 17522           | RL | 7.0 | -      | 80.0  | 104.0 | 118.0 | 118.0 |     |     |     | 40.0      |
| 3                 | 17523           | HL | 7.0 | -      | -     | 79.0  | 93.0  | 93.0  |     |     |     | 25.0      |
| 4                 | 17524           | LC | 6.5 | -      | -     | -     | 83.0  | 83.0  |     |     |     | 10.0      |
| 5                 | 17525           | LC | 6.5 | -      | -     | -     | -     | 81.0  |     |     |     | 2.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0  | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00  | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 10.0mm |
| Lower      | 5.0mm  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |       |
|--------------------|---------------|--------------------|---------|------------|---------------------|-------|
|                    |               |                    |         |            | Upper               | Lower |
| φ 0.15BS           | STEEL         | 5mm                | STDPO1  | φ 4.0mm    | 10.0mm              | 5.0mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 17511                 | 17512                 | 17513                 | 17514                    | 17515                 |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | HL                    | LC                       | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 6                     | 6                     | 12                       | 8                     |       |       |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 2.5                      | 1.0                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 6                     |                          |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 14                    | 10                    | 1                        | 1                     |       |       |       |
| Stabilizer A       | SA  | 2                     | 2                     | 3                     | 1                     | 1                        | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 13                    | 14                    | 10                    | 1                        | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 76.0<br>(73.0 ~ 79.0) | 58.0<br>(56.0 ~ 60.0) | 70.0<br>(68.0 ~ 72.0) | 160.0<br>(158.0 ~ 162.0) | 85.0<br>(83.0 ~ 87.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                       | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                        | 7                     |       |       |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                       | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                        | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 6.0                   | 9.0                   | 9.0                   | 7.0                      | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 120.0 | 80.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 148.0 | 108.0 | 78.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 164.0 | 124.0 | 94.0  | 84.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 167.0 | 127.0 | 97.0  | 87.0  | 81.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 30.0  | 10.0  | 6.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 4.8 ~ 6.0   | 13.2 ~ 16.2 | 6.1 ~ 7.5   | 6.3 ~ 7.0   | 6.2 ~ 6.9   |  |  |
| Average Voltage Gap  | V   |  | 68 ~ 85     | 47 ~ 67     | 67 ~ 77     | 165 ~ 179   | 90 ~ 105    |  |  |
| Avg. Linear Feedrate | ALF |  | 324.0       | 237.0       | 149.9       | 109.0       | 85.3        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |       |
|--------------------|---------------|--------------------|---------|------------|---------------------|-------|
|                    |               |                    |         |            | Upper               | Lower |
| φ 0.15BS           | STEEL         | 10mm               | STDPO1  | φ 4.0mm    | 10.0mm              | 5.0mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 17521                 | 17522                 | 17523                 | 17524                    | 17525                 |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | HL                    | LC                       | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 6                     | 6                     | 10                       | 8                     |       |       |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                      | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 6                     |                          |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 12                    | 8                     | 1                        | 1                     |       |       |       |
| Stabilizer A       | SA  | 2                     | 2                     | 3                     | 1                     | 1                        | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 11                    | 12                    | 8                     | 1                        | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 62.0<br>(59.0 ~ 65.0) | 48.0<br>(46.0 ~ 50.0) | 70.0<br>(68.0 ~ 72.0) | 140.0<br>(138.0 ~ 142.0) | 90.0<br>(88.0 ~ 92.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                       | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                        | 7                     |       |       |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                       | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                        | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 4.0                   | 7.0                   | 7.0                   | 6.5                      | 6.5                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 120.0 | 80.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 144.0 | 104.0 | 79.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 158.0 | 118.0 | 93.0  | 83.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 158.0 | 118.0 | 93.0  | 83.0  | 81.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 25.0  | 10.0  | 2.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 3.7 ~ 4.6   | 9.3 ~ 11.4  | 6.0 ~ 7.4   | 5.9 ~ 6.5   | 5.8 ~ 6.4   |  |  |
| Average Voltage Gap  | V   |  | 52 ~ 72     | 40 ~ 60     | 67 ~ 77     | 147 ~ 162   | 95 ~ 112    |  |  |
| Avg. Linear Feedrate | ALF |  | 249.0       | 177.7       | 123.2       | 92.6        | 73.9        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.15BS            | WC-Co         | STD   |

Thickness 5 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 971             | RH | 1.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 4811            | RH | 3.4 | 99.0   | 121.0 | 134.0 | 144.0 | 147.0 |     |     |     | 0.0       |
| 2                 | 4812            | RL | 6.0 | -      | 81.0  | 94.0  | 104.0 | 107.0 |     |     |     | 40.0      |
| 3                 | 4813            | RL | 7.0 | -      | -     | 82.0  | 92.0  | 95.0  |     |     |     | 12.0      |
| 4                 | 4814            | LC | 8.0 | -      | -     | -     | 79.0  | 82.0  |     |     |     | 13.0      |
| 5                 | 4815            | LC | 8.0 | -      | -     | -     | -     | 80.0  |     |     |     | 2.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 13.0  | 11.0  | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.80  | 1.50  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 971             | RH | 1.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 4821            | RH | 2.6 | 101.0  | 123.0 | 134.0 | 144.0 | 146.0 |     |     |     | 0.0       |
| 2                 | 4822            | RL | 5.0 | -      | 83.0  | 94.0  | 104.0 | 106.0 |     |     |     | 40.0      |
| 3                 | 4823            | RL | 6.0 | -      | -     | 82.0  | 92.0  | 94.0  |     |     |     | 12.0      |
| 4                 | 4824            | LC | 7.0 | -      | -     | -     | 79.0  | 81.0  |     |     |     | 13.0      |
| 5                 | 4825            | LC | 7.0 | -      | -     | -     | -     | 79.0  |     |     |     | 2.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 13.0  | 11.0  | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.80  | 1.50  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 971             | RH | 1.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 4831            | RH | 1.8 | 102.0  | 125.0 | 146.0 | 156.0 | 158.0 |     |     |     | 0.0       |
| 2                 | 4832            | RL | 5.0 | -      | 80.0  | 101.0 | 111.0 | 113.0 |     |     |     | 45.0      |
| 3                 | 4833            | RL | 2.0 | -      | -     | 83.0  | 93.0  | 95.0  |     |     |     | 18.0      |
| 4                 | 4834            | LC | 6.0 | -      | -     | -     | 80.0  | 82.0  |     |     |     | 13.0      |
| 5                 | 4835            | LC | 6.0 | -      | -     | -     | -     | 79.0  |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 13.0  | 11.0  | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.80  | 1.50  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.15BS            | WC-Co         | STD   |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 972             | RH | 0.6 |        |       |       |       |       |     |     |     |           |
| 1                 | 4841            | RH | 1.9 | 108.0  | 125.0 | 148.0 | 158.0 | 160.0 |     |     |     | 0.0       |
| 2                 | 4842            | RL | 5.0 | -      | 80.0  | 103.0 | 113.0 | 115.0 |     |     |     | 45.0      |
| 3                 | 4843            | RL | 1.5 | -      | -     | 84.0  | 94.0  | 96.0  |     |     |     | 19.0      |
| 4                 | 4844            | LC | 6.0 | -      | -     | -     | 81.0  | 83.0  |     |     |     | 13.0      |
| 5                 | 4845            | LC | 6.0 | -      | -     | -     | -     | 80.0  |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 13.0  | 11.0  | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.80  | 1.50  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 972             | RH | 0.6 |        |       |       |       |       |     |     |     |           |
| 1                 | 4851            | RH | 1.0 | 114.0  | 125.0 | 150.0 | 161.0 | 162.0 |     |     |     | 0.0       |
| 2                 | 4852            | RL | 5.0 | -      | 80.0  | 105.0 | 116.0 | 117.0 |     |     |     | 45.0      |
| 3                 | 4853            | RL | 1.0 | -      | -     | 85.0  | 96.0  | 97.0  |     |     |     | 20.0      |
| 4                 | 4854            | LC | 6.0 | -      | -     | -     | 83.0  | 84.0  |     |     |     | 13.0      |
| 5                 | 4855            | LC | 6.0 | -      | -     | -     | -     | 81.0  |     |     |     | 3.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 13.0  | 11.0  | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.80  | 1.50  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | WC-Co         | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 4811                  | 4812                  | 4813                  | 4814                     | 4815                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | RL                    | LC                       | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 8                     | 8                        | 8                     |       |       |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                      | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 5                     | 6                     |                          |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 14                    | 16                    | 1                        | 1                     |       |       |       |
| Stabilizer A       | SA  | 2                     | 2                     | 2                     | 2                     | 1                        | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 13                    | 14                    | 16                    | 1                        | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 70.0<br>(67.0 ~ 73.0) | 40.0<br>(38.0 ~ 42.0) | 45.0<br>(43.0 ~ 47.0) | 120.0<br>(118.0 ~ 122.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                       | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                        | 7                     |       |       |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                       | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                        | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 3.4                   | 6.0                   | 7.0                   | 8.0                      | 8.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 99.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 121.0 | 81.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 134.0 | 94.0  | 82.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 144.0 | 104.0 | 92.0  | 79.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 147.0 | 107.0 | 95.0  | 82.0  | 80.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 12.0  | 13.0  | 2.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 3.0 ~ 3.7   | 8.0 ~ 9.8   | 6.3 ~ 7.8   | 7.3 ~ 8.1   | 7.4 ~ 8.2   |  |  |
| Average Voltage Gap  | V   |  | 59 ~ 78     | 27 ~ 49     | 34 ~ 58     | 124 ~ 137   | 95 ~ 108    |  |  |
| Avg. Linear Feedrate | ALF |  | 201.0       | 146.0       | 108.6       | 87.9        | 74.0        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | WC-Co         | 10mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                   | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 4821                  | 4822                  | 4823                  | 4824                    | 4825                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | RL                    | LC                      | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                      | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 10                    | 8                       | 8                     |       |       |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                     | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 6                     | 7                     |                         |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 12                    | 15                    | 1                       | 1                     |       |       |       |
| Stabilizer A       | SA  | 2                     | 2                     | 2                     | 2                     | 1                       | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 11                    | 12                    | 15                    | 1                       | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                       | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                       | 1                     |       |       |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 62.0<br>(59.0 ~ 65.0) | 40.0<br>(38.0 ~ 42.0) | 40.0<br>(38.0 ~ 42.0) | 100.0<br>(98.0 ~ 102.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                      | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                     | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                      | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                       | 7                     |       |       |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                      | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                      | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                       | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                      | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                       | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.6                   | 5.0                   | 6.0                   | 7.0                     | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 101.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 123.0 | 83.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 134.0 | 94.0  | 82.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 144.0 | 104.0 | 92.0  | 79.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 146.0 | 106.0 | 94.0  | 81.0  | 79.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 12.0  | 13.0  | 2.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 2.1 ~ 2.7   | 6.1 ~ 7.5   | 5.4 ~ 6.6   | 6.5 ~ 7.1   | 6.5 ~ 7.2   |  |  |
| Average Voltage Gap  | V   |  | 55 ~ 75     | 26 ~ 49     | 29 ~ 51     | 106 ~ 119   | 73 ~ 86     |  |  |
| Avg. Linear Feedrate | ALF |  | 144.0       | 106.4       | 82.1        | 68.4        | 58.6        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | WC-Co         | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 4831                  | 4832                  | 4833                  | 4834                  | 4835                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | RL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 10                    | 8                     | 8                     |       |       |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 8                     |                       |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 9                     | 13                    | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 2                     | 2                     | 2                     | 2                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 8                     | 9                     | 13                    | 1                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 55.0<br>(52.0 ~ 58.0) | 36.0<br>(34.0 ~ 38.0) | 34.0<br>(32.0 ~ 36.0) | 70.0<br>(68.0 ~ 72.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                     | 7                     |       |       |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.8                   | 5.0                   | 2.0                   | 6.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 102.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 125.0 | 80.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 146.0 | 101.0 | 83.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 156.0 | 111.0 | 93.0  | 80.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 158.0 | 113.0 | 95.0  | 82.0  | 79.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 45.0  | 18.0  | 13.0  | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.1 ~ 1.5   | 5.1 ~ 6.2   | 1.9 ~ 2.4   | 5.7 ~ 6.5   | 5.5 ~ 6.1   |  |  |
| Average Voltage Gap  | V   |  | 47 ~ 66     | 24 ~ 45     | 24 ~ 45     | 86 ~ 98     | 55 ~ 67     |  |  |
| Avg. Linear Feedrate | ALF |  | 78.0        | 63.4        | 42.5        | 38.1        | 34.3        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | WC-Co         | 30mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 972                   | 4841                  | 4842                  | 4843                  | 4844                  | 4845                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | RL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 10                    | 9                     | 8                     |       |       |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 8                     |                       |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 7                     | 12                    | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 2                     | 2                     | 2                     | 2                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 13                    | 8                     | 7                     | 12                    | 1                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 61.0<br>(58.0 ~ 64.0) | 43.0<br>(41.0 ~ 45.0) | 32.0<br>(30.0 ~ 34.0) | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                     | 7                     |       |       |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.9                   | 5.0                   | 1.5                   | 6.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 125.0 | 80.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 148.0 | 103.0 | 84.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 158.0 | 113.0 | 94.0  | 81.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 160.0 | 115.0 | 96.0  | 83.0  | 80.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 45.0  | 19.0  | 13.0  | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.9 ~ 1.2   | 5.0 ~ 6.0   | 1.4 ~ 1.8   | 5.7 ~ 6.4   | 5.5 ~ 6.1   |  |  |
| Average Voltage Gap  | V   |  | 51 ~ 72     | 34 ~ 54     | 22 ~ 44     | 77 ~ 89     | 48 ~ 60     |  |  |
| Avg. Linear Feedrate | ALF |  | 63.0        | 52.9        | 34.1        | 31.2        | 28.6        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | WC-Co         | 40mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 972                   | 4851                  | 4852                  | 4853                  | 4854                  | 4855                  |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | RL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 10                    | 10                    | 9                     |       |       |       |
| Power Setting      | IP  | 5.0                   | 7.0                   | 6.0                   | 5.0                   | 3.0                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 8                     |                       |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 5                     | 12                    | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 2                     | 2                     | 2                     | 2                     | 1                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 13                    | 7                     | 5                     | 12                    | 1                     | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 68.0<br>(65.0 ~ 71.0) | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(28.0 ~ 32.0) | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                     | 7                     |       |       |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 1.0                   | 5.0                   | 1.0                   | 6.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 114.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 125.0 | 80.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 150.0 | 105.0 | 85.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 161.0 | 116.0 | 96.0  | 83.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 162.0 | 117.0 | 97.0  | 84.0  | 81.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 45.0  | 20.0  | 13.0  | 3.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.7 ~ 0.9   | 4.9 ~ 5.8   | 1.0 ~ 1.3   | 5.7 ~ 6.3   | 5.5 ~ 6.1   |  |  |
| Average Voltage Gap  | V   |  | 56 ~ 79     | 44 ~ 63     | 20 ~ 43     | 68 ~ 80     | 41 ~ 53     |  |  |
| Avg. Linear Feedrate | ALF |  | 48.0        | 41.8        | 26.0        | 24.3        | 22.7        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class  |
|--------------------|---------------|--------|
| φ0.15BS            | WC-Co         | STDPO1 |

Thickness 5 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 971             | RH | 1.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 17711           | RH | 3.4 | 106.0  | 122.0 | 134.0 | 145.0 | 147.0 |     |     |     | 0.0       |
| 2                 | 17712           | RL | 6.0 | -      | 82.0  | 94.0  | 105.0 | 107.0 |     |     |     | 40.0      |
| 3                 | 17713           | RL | 7.0 | -      | -     | 82.0  | 93.0  | 95.0  |     |     |     | 12.0      |
| 4                 | 17714           | LC | 8.0 | -      | -     | -     | 80.0  | 82.0  |     |     |     | 13.0      |
| 5                 | 17715           | LC | 8.0 | -      | -     | -     | -     | 80.0  |     |     |     | 2.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 13.0  | 11.0  | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.80  | 1.50  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 10.0mm |
| Lower      | 5.0mm  |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |       |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 971             | RH | 1.0 |        |       |       |       |       |     |     |     |           |
| 1                 | 17721           | RH | 2.6 | 106.0  | 122.0 | 134.0 | 146.0 | 148.0 |     |     |     | 0.0       |
| 2                 | 17722           | RL | 5.0 | -      | 82.0  | 94.0  | 106.0 | 108.0 |     |     |     | 40.0      |
| 3                 | 17723           | RL | 6.0 | -      | -     | 82.0  | 94.0  | 96.0  |     |     |     | 12.0      |
| 4                 | 17724           | LC | 7.0 | -      | -     | -     | 81.0  | 83.0  |     |     |     | 13.0      |
| 5                 | 17725           | LC | 7.0 | -      | -     | -     | -     | 81.0  |     |     |     | 2.0       |
| 6                 |                 |    |     | -      | -     | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 13.0  | 11.0  | 2.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 1.80  | 1.50  | 0.30  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 10.0mm |
| Lower      | 5.0mm  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |       |
|--------------------|---------------|--------------------|---------|------------|---------------------|-------|
|                    |               |                    |         |            | Upper               | Lower |
| φ 0.15BS           | WC-Co         | 5mm                | STDPO1  | φ 4.0mm    | 10.0mm              | 5.0mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 17711                 | 17712                 | 17713                 | 17714                    | 17715                 |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | RL                    | LC                       | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 8                     | 8                        | 8                     |       |       |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                      | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 5                     | 6                     |                          |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 14                    | 16                    | 1                        | 1                     |       |       |       |
| Stabilizer A       | SA  | 2                     | 2                     | 2                     | 2                     | 1                        | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 13                    | 14                    | 16                    | 1                        | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                     |       |       |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 76.0<br>(73.0 ~ 79.0) | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(43.0 ~ 47.0) | 115.0<br>(113.0 ~ 117.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                       | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                        | 7                     |       |       |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                       | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                        | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 3.4                   | 6.0                   | 7.0                   | 8.0                      | 8.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                      | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 122.0 | 82.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 134.0 | 94.0  | 82.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 145.0 | 105.0 | 93.0  | 80.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 147.0 | 107.0 | 95.0  | 82.0  | 80.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 12.0  | 13.0  | 2.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 2.8 ~ 3.4   | 7.2 ~ 8.8   | 6.6 ~ 8.1   | 7.4 ~ 8.1   | 7.6 ~ 8.4   |  |  |
| Average Voltage Gap  | V   |  | 65 ~ 86     | 42 ~ 62     | 35 ~ 54     | 122 ~ 135   | 87 ~ 101    |  |  |
| Avg. Linear Feedrate | ALF |  | 186.0       | 134.1       | 102.8       | 84.2        | 71.6        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |       |
|--------------------|---------------|--------------------|---------|------------|---------------------|-------|
|                    |               |                    |         |            | Upper               | Lower |
| φ 0.15BS           | WC-Co         | 10mm               | STDPO1  | φ 4.0mm    | 10.0mm              | 5.0mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                   | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 17721                 | 17722                 | 17723                 | 17724                   | 17725                 |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | RL                    | LC                      | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                      | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 10                    | 8                       | 8                     |       |       |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                     | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 10                    | 16                    | 6                     | 7                     |                         |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 12                    | 15                    | 1                       | 1                     |       |       |       |
| Stabilizer A       | SA  | 2                     | 2                     | 2                     | 2                     | 1                       | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 11                    | 12                    | 15                    | 1                       | 1                     |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                       | 4                     |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                       | 1                     |       |       |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 57.0<br>(54.0 ~ 60.0) | 40.0<br>(38.0 ~ 42.0) | 40.0<br>(38.0 ~ 42.0) | 100.0<br>(98.0 ~ 102.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                      | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                     | OFF                   |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                      | 12                    |       |       |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                       | 7                     |       |       |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                      | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                      | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                       | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                      | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                       | 0                     |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.6                   | 5.0                   | 6.0                   | 7.0                     | 7.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 10.0                  | 1.0                   | 1.0                   | 1.0                     | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 122.0 | 82.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 134.0 | 94.0  | 82.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 146.0 | 106.0 | 94.0  | 81.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 148.0 | 108.0 | 96.0  | 83.0  | 81.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 12.0  | 13.0  | 2.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.9 ~ 2.4   | 6.2 ~ 7.6   | 4.4 ~ 5.4   | 6.5 ~ 7.2   | 6.7 ~ 7.5   |  |  |
| Average Voltage Gap  | V   |  | 51 ~ 72     | 33 ~ 48     | 31 ~ 50     | 107 ~ 120   | 70 ~ 82     |  |  |
| Avg. Linear Feedrate | ALF |  | 129.0       | 98.4        | 73.7        | 62.5        | 54.5        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**5-6 Land machining**  
**Machining Characteristics Data**

MV2400R

|                    |               |                |           |
|--------------------|---------------|----------------|-----------|
| Wire Dia. and Type | Material Type | Class          | Thickness |
| 0.20BS             | Steel         | Land Machining | 5 ~ 60    |

| Cutting process |      |    |    |    |    |     |     |    |    |    |    |     |     |     |    |    |    |    |    | Monitor |             |           |
|-----------------|------|----|----|----|----|-----|-----|----|----|----|----|-----|-----|-----|----|----|----|----|----|---------|-------------|-----------|
| No,             | E    | PS | SV | Vo | IP | ΔIP | OFF | SA | SB | SC | SE | VG  | FM  | DAE | WS | WT | PT | FB | LQ | LR      | FC          | V         |
| 1               | 5901 | MP | NM | 12 | 6  | 12  | 1   | 1  | 16 | 1  | 1  | 90  | OFF | OFF | 10 | 9  | 14 | NM | 4  | 10      | 6.0 ~ 8.0   | 99 ~ 105  |
| 2               | 5902 | LC | NM | 10 | 3  | —   | 1   | 1  | 1  | 4  | 1  | 145 | ON  | OFF | 10 | 10 | 14 | NM | 4  | 10      | 10.0 ~ 12.0 | 180 ~ 185 |

|                |            |
|----------------|------------|
| Length of land | 3 to 5 mm  |
| Relief         | 0.5 to 1.0 |

| No.               | Cutting process |    |     | Offset     |           | Step Increment |
|-------------------|-----------------|----|-----|------------|-----------|----------------|
|                   | E               | PS | FA  | 1st        | 2nd       |                |
| 1                 | 5901            | MP | 4.0 | 121        | 127       | -              |
| 2                 | 5902            | LC | 5.0 | —          | 107       | 20             |
| Surface roughness |                 |    | Rz  | 9.0 ~ 11.0 | 3.5 ~ 5.0 |                |
|                   |                 |    | Ra  | 1.3 ~ 1.5  | 0.4 ~ 0.6 |                |

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|                    |                  |                |           |
|--------------------|------------------|----------------|-----------|
| Wire Dia. and Type | Material Type    | Class          | Thickness |
| 0.20BS             | Tungsten Carbide | Land Machining | 5 ~ 60    |

| Cutting process |      |    |    |    |    |     |     |    |    |    |    |     |     |     |    |    |    |    |    | Monitor |             |           |
|-----------------|------|----|----|----|----|-----|-----|----|----|----|----|-----|-----|-----|----|----|----|----|----|---------|-------------|-----------|
| No,             | E    | PS | SV | Vo | IP | ΔIP | OFF | SA | SB | SC | SE | VG  | FM  | DAE | WS | WT | PT | FB | LQ | LR      | FC          | V         |
| 1               | 5951 | MP | NM | 12 | 8  | 12  | 1   | 1  | 16 | 1  | 1  | 87  | OFF | OFF | 10 | 9  | 14 | NM | 4  | 10      | 6.0 ~ 8.0   | 101 ~ 107 |
| 2               | 5952 | LC | NM | 10 | 3  | —   | 1   | 1  | 1  | 4  | 1  | 150 | ON  | OFF | 10 | 10 | 14 | NM | 4  | 10      | 10.0 ~ 12.0 | 170 ~ 177 |

|                |            |
|----------------|------------|
| Length of land | 3 to 5 mm  |
| Relief         | 0.5 to 1.0 |

| No.               | Cutting process |    |     | Offset    |           | Step Increment |
|-------------------|-----------------|----|-----|-----------|-----------|----------------|
|                   | E               | PS | FA  | 1st       | 2nd       |                |
| 1                 | 5951            | MP | 3.0 | 114       | 124       | -              |
| 2                 | 5952            | LC | 4.0 | —         | 106       | 18             |
| Surface roughness |                 |    | Rz  | 5.5 ~ 7.0 | 3.0 ~ 4.5 |                |
|                   |                 |    | Ra  | 0.9 ~ 1.2 | 0.4 ~ 0.6 |                |

MV2400R

|                    |               |                |           |
|--------------------|---------------|----------------|-----------|
| Wire Dia. and Type | Material Type | Class          | Thickness |
| 0.25BS             | Steel         | Land Machining | 5 ~ 60    |

| Cutting process |      |    |    |    |    |     |     |    |    |    |    |     |     |     |    |    |    |    |    | Monitor |             |           |
|-----------------|------|----|----|----|----|-----|-----|----|----|----|----|-----|-----|-----|----|----|----|----|----|---------|-------------|-----------|
| No,             | E    | PS | SV | Vo | IP | ΔIP | OFF | SA | SB | SC | SE | VG  | FM  | DAE | WS | WT | PT | FB | LQ | LR      | FC          | V         |
| 1               | 5911 | MP | NM | 12 | 8  | 12  | 1   | 1  | 16 | 1  | 1  | 87  | OFF | OFF | 10 | 10 | 14 | NM | 4  | 10      | 7.5 ~ 8.5   | 104 ~ 110 |
| 2               | 5912 | LC | NM | 16 | 3  | —   | 1   | 1  | 1  | 4  | 1  | 150 | ON  | OFF | 10 | 13 | 14 | NM | 4  | 10      | 11.0 ~ 13.0 | 220 ~ 230 |

|                |            |
|----------------|------------|
| Length of land | 3 to 5 mm  |
| Relief         | 0.5 to 1.0 |

| No.               | Cutting process |    |     | Offset     |           | Step Increment |
|-------------------|-----------------|----|-----|------------|-----------|----------------|
|                   | E               | PS | FA  | 1st        | 2nd       |                |
| 1                 | 5911            | MP | 5.0 | 139        | 150       | -              |
| 2                 | 5912            | LC | 6.0 | —          | 130       | 20             |
| Surface roughness |                 |    | Rz  | 9.0 ~ 11.0 | 3.5 ~ 5.0 |                |
|                   |                 |    | Ra  | 1.3 ~ 1.5  | 0.4 ~ 0.6 |                |

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|                    |                  |                |           |
|--------------------|------------------|----------------|-----------|
| Wire Dia. and Type | Material Type    | Class          | Thickness |
| 0.25BS             | Tungsten Carbide | Land Machining | 5 ~ 60    |

| Cutting process |      |    |    |    |    |     |     |    |    |    |    |     |     |     |    |    |    |    |    | Monitor |             |           |
|-----------------|------|----|----|----|----|-----|-----|----|----|----|----|-----|-----|-----|----|----|----|----|----|---------|-------------|-----------|
| No,             | E    | PS | SV | Vo | IP | ΔIP | OFF | SA | SB | SC | SE | VG  | FM  | DAE | WS | WT | PT | FB | LQ | LR      | FC          | V         |
| 1               | 5961 | MP | NM | 12 | 8  | 12  | 1   | 1  | 16 | 1  | 1  | 87  | OFF | OFF | 10 | 10 | 14 | NM | 4  | 10      | 6.0 ~ 8.0   | 104 ~ 107 |
| 2               | 5962 | LC | NM | 16 | 3  | —   | 1   | 1  | 1  | 4  | 1  | 180 | ON  | OFF | 10 | 13 | 14 | NM | 4  | 10      | 10.0 ~ 12.0 | 220 ~ 230 |

|                |            |
|----------------|------------|
| Length of land | 3 to 5 mm  |
| Relief         | 0.5 to 1.0 |

| No.               | Cutting process |    |     | Offset    |           | Step Increment |
|-------------------|-----------------|----|-----|-----------|-----------|----------------|
|                   | E               | PS | FA  | 1st       | 2nd       |                |
| 1                 | 5961            | MP | 4.5 | 140       | 149       | -              |
| 2                 | 5962            | LC | 5.0 | —         | 131       | 18             |
| Surface roughness |                 |    | Rz  | 5.5 ~ 7.0 | 3.0 ~ 4.5 |                |
|                   |                 |    | Ra  | 0.9 ~ 1.2 | 0.4 ~ 0.6 |                |



**5-7 PCD·CBN machining  
Machining Characteristics Data**

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|----------|------------|---------------------|---------|
|                    |               |                    |          |            | Upper               | Lower   |
| 0.20BS             | PCD           | 2mm                | Standard | φ4.0mm     | 10.00mm             | 10.00mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   | Class4 |                   |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--------|-------------------|--|--|
| E-pack Number      | Eno      | 941               | 17101             |        | 17102             |        | 17103             |        | 17104             |  |  |
| Power Supply       | PS       | RH                | RH                |        | RH                |        | RH                |        | RH                |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |        | NM                |  |  |
| Voltage Open       | Vo       | 7                 | 2                 |        | 2                 |        | 2                 |        | 2                 |  |  |
| Power Setting      | IP       | 6.0               | 7.0               |        | 7.0               |        | 7.0               |        | 7.0               |  |  |
| IP adjust          | ΔIP      | 11                | 6                 |        | 6                 |        | 6                 |        | 6                 |  |  |
| Off Time           | OFF      | 6                 | 12                |        | 12                |        | 12                |        | 11                |  |  |
| Stabilizer A       | SA       | 3                 | 3                 |        | 3                 |        | 3                 |        | 3                 |  |  |
| Stabilizer B       | SB       | 8                 | 12                |        | 12                |        | 12                |        | 11                |  |  |
| Stabilizer C       | SC       | 7                 | 7                 |        | 7                 |        | 7                 |        | 7                 |  |  |
| Stabilizer E       | SE       | 4                 | 1                 |        | 1                 |        | 1                 |        | 1                 |  |  |
| Voltage Gap        | VG       | 60.0<br>(58 ~ 62) | 25.0<br>(22 ~ 28) |        | 25.0<br>(22 ~ 28) |        | 25.0<br>(22 ~ 28) |        | 25.0<br>(22 ~ 28) |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |        | OFF               |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |        | OFF               |  |  |
| Wire Speed         | WS       | 8                 | 10                |        | 10                |        | 10                |        | 10                |  |  |
| Wire Tension       | WT       | 6                 | 8                 |        | 8                 |        | 8                 |        | 8                 |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |        | 14                |  |  |
| Flow Balance       | FB       | NM                | L                 |        | L                 |        | L                 |        | L                 |  |  |
| Liquid Quantity    | LQ       | 11                | 12                |        | 12                |        | 12                |        | 12                |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |        | 10                |  |  |
| Feedrate Address   | FA       | 2.0               | 2.5               |        | 2.5               |        | 2.5               |        | 2.5               |  |  |
| Upper Flow Rate    |          | 6.0               | 10.0              |        | 10.0              |        | 10.0              |        | 10.0              |  |  |
| Lower Flow Rate    |          | 6.0               | 10.0              |        | 10.0              |        | 10.0              |        | 10.0              |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |       |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|-------|--|--|--|
| Rough Cut       | ----- | 130.0 |  | 130.0 |  | 128.0 |  | 125.0 |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |             |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|-------------|--|--|
| Feedrate Cutting     | FC  |  | 4.3 ~ 5.2   |  | 4.1 ~ 4.7   |  | 4.0 ~ 4.6   |  | 3.9 ~ 4.5   |  |  |
| Average Voltage Gap  | V   |  | 23 ~ 29     |  | 20 ~ 29     |  | 22 ~ 29     |  | 20 ~ 29     |  |  |
| Avg. Linear Feedrate | ALF |  | 9.8         |  | 9.2         |  | 9.1         |  | 8.2         |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 |  | 16.2 ~ 19.8 |  | 16.2 ~ 19.8 |  | 16.2 ~ 19.8 |  |  |
|                      | Ra  |  | 2.40 ~ 3.00 |  | 2.40 ~ 3.00 |  | 2.40 ~ 3.00 |  | 2.40 ~ 3.00 |  |  |

Note: Set flush cup clearance as shown as Top chart.PCD material side of the workpiece should be faced up for workpiece set-up.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

(Class1=Particle size2μm ,Class2=Particle size4μm ,Class3=Particle size5μm ,Class4=Particle size10μm)

Version9.0

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|----------|------------|---------------------|---------|
|                    |               |                    |          |            | Upper               | Lower   |
| 0.20BS             | CBN           | 2mm                | Standard | φ4mm       | 10.00mm             | 10.00mm |

|                    |          |                   |                      |  |  |  |  |  |  |  |  |
|--------------------|----------|-------------------|----------------------|--|--|--|--|--|--|--|--|
| Cutting Process    | Start Up | Class1            |                      |  |  |  |  |  |  |  |  |
| E-pack Number      | Eno      | 941               | 17141                |  |  |  |  |  |  |  |  |
| Power Supply       | PS       | RH                | RH                   |  |  |  |  |  |  |  |  |
| Servo              | SV       | NM                | NM                   |  |  |  |  |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 12                   |  |  |  |  |  |  |  |  |
| Power Setting      | IP       | 6.0               | 10.0                 |  |  |  |  |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 8                    |  |  |  |  |  |  |  |  |
| Off Time           | OFF      | 6                 | 16                   |  |  |  |  |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 3                    |  |  |  |  |  |  |  |  |
| Stabilizer B       | SB       | 8                 | 16                   |  |  |  |  |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                    |  |  |  |  |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 1                    |  |  |  |  |  |  |  |  |
| Voltage Gap        | VG       | 60.0<br>(58 ~ 62) | 125.0<br>(122 ~ 128) |  |  |  |  |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF                  |  |  |  |  |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF                  |  |  |  |  |  |  |  |  |
| Wire Speed         | WS       | 8                 | 12                   |  |  |  |  |  |  |  |  |
| Wire Tension       | WT       | 6                 | 8                    |  |  |  |  |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                   |  |  |  |  |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                   |  |  |  |  |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 12                   |  |  |  |  |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                   |  |  |  |  |  |  |  |  |
| Feedrate Address   | FA       | 2.0               | 1.5                  |  |  |  |  |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 10.0                 |  |  |  |  |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 10.0                 |  |  |  |  |  |  |  |  |

| Offset Value(s) |       |       |  |  |  |  |  |  |  |  |  |
|-----------------|-------|-------|--|--|--|--|--|--|--|--|--|
| Rough Cut       | ----- | 165.0 |  |  |  |  |  |  |  |  |  |

| RESULTS              |     |  |             |  |  |  |  |  |  |  |  |
|----------------------|-----|--|-------------|--|--|--|--|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.9 ~ 2.6   |  |  |  |  |  |  |  |  |
| Average Voltage Gap  | V   |  | 119 ~ 132   |  |  |  |  |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 3.6         |  |  |  |  |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 |  |  |  |  |  |  |  |  |
|                      | Ra  |  | 2.40 ~ 3.00 |  |  |  |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)  
 (Class1=Particle size2μm )

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|----------|------------|---------------------|---------|
|                    |               |                    |          |            | Upper               | Lower   |
| 0.25BS             | PCD           | 2mm                | Standard | φ4.0mm     | 10.00mm             | 10.00mm |

| Cutting Process    | Start Up | Class1            |                   | Class2 |                   | Class3 |                   | Class4 |                   |  |  |
|--------------------|----------|-------------------|-------------------|--------|-------------------|--------|-------------------|--------|-------------------|--|--|
| E-pack Number      | Eno      | 951               | 16901             |        | 16902             |        | 16903             |        | 16904             |  |  |
| Power Supply       | PS       | RH                | RH                |        | RH                |        | RH                |        | RH                |  |  |
| Servo              | SV       | NM                | NM                |        | NM                |        | NM                |        | NM                |  |  |
| Voltage Open       | Vo       | 7                 | 2                 |        | 2                 |        | 2                 |        | 2                 |  |  |
| Power Setting      | IP       | 7.0               | 7.0               |        | 7.0               |        | 7.0               |        | 7.0               |  |  |
| IP adjast          | ΔIP      | 11                | 6                 |        | 6                 |        | 6                 |        | 6                 |  |  |
| Off Time           | OFF      | 6                 | 12                |        | 12                |        | 12                |        | 11                |  |  |
| Stabilizer A       | SA       | 3                 | 3                 |        | 3                 |        | 3                 |        | 3                 |  |  |
| Stabilizer B       | SB       | 8                 | 12                |        | 12                |        | 12                |        | 11                |  |  |
| Stabilizer C       | SC       | 7                 | 7                 |        | 7                 |        | 7                 |        | 7                 |  |  |
| Stabilizer E       | SE       | 4                 | 1                 |        | 1                 |        | 1                 |        | 1                 |  |  |
| Voltage Gap        | VG       | 60.0<br>(58 ~ 62) | 25.0<br>(22 ~ 28) |        | 25.0<br>(22 ~ 28) |        | 25.0<br>(22 ~ 28) |        | 30.0<br>(27 ~ 33) |  |  |
| Fine machining     | FM       | OFF               | OFF               |        | OFF               |        | OFF               |        | OFF               |  |  |
| Digital AE         | DAE      | OFF               | OFF               |        | OFF               |        | OFF               |        | OFF               |  |  |
| Wire Speed         | WS       | 8                 | 10                |        | 10                |        | 10                |        | 10                |  |  |
| Wire Tension       | WT       | 9                 | 10                |        | 10                |        | 10                |        | 10                |  |  |
| Pre-Tension        | PT       | 14                | 14                |        | 14                |        | 14                |        | 14                |  |  |
| Flow Balance       | FB       | NM                | L                 |        | L                 |        | L                 |        | L                 |  |  |
| Liquid Quantity    | LQ       | 11                | 12                |        | 12                |        | 12                |        | 12                |  |  |
| Liquid Resistivity | LR       | 10                | 10                |        | 10                |        | 10                |        | 10                |  |  |
| Feedrate Address   | FA       | 2.0               | 2.5               |        | 2.5               |        | 2.5               |        | 2.5               |  |  |
| Upper Flow Rate    |          | 6.0               | 10.0              |        | 10.0              |        | 10.0              |        | 10.0              |  |  |
| Lower Flow Rate    |          | 6.0               | 10.0              |        | 10.0              |        | 10.0              |        | 10.0              |  |  |

| Offset Value(s) |       |       |  |       |  |       |  |       |  |  |  |
|-----------------|-------|-------|--|-------|--|-------|--|-------|--|--|--|
| Rough Cut       | ----- | 147.0 |  | 147.0 |  | 147.0 |  | 149.0 |  |  |  |

| RESULTS              |     |  |             |  |             |  |             |  |             |  |  |
|----------------------|-----|--|-------------|--|-------------|--|-------------|--|-------------|--|--|
| Feedrate Cutting     | FC  |  | 4.3 ~ 5.2   |  | 4.1 ~ 4.7   |  | 4.0 ~ 4.6   |  | 3.9 ~ 4.5   |  |  |
| Average Voltage Gap  | V   |  | 23 ~ 29     |  | 20 ~ 29     |  | 22 ~ 29     |  | 20 ~ 29     |  |  |
| Avg. Linear Feedrate | ALF |  | 9.8         |  | 9.2         |  | 9.1         |  | 8.2         |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 |  | 16.2 ~ 19.8 |  | 16.2 ~ 19.8 |  | 16.2 ~ 19.8 |  |  |
|                      | Ra  |  | 2.40 ~ 3.00 |  | 2.40 ~ 3.00 |  | 2.40 ~ 3.00 |  | 2.40 ~ 3.00 |  |  |

Note: Set flush cup clearance as shown as Top chart.PCD material side of the workpiece should be faced up for workpiece set-up.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

(Class1=Particle size2μm ,Class2=Particle size4μm ,Class3=Particle size5μm ,Class4=Particle size10μm)

Version9.0

## MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process  | Nozzle Dia | Flush cup clearance |         |
|--------------------|---------------|--------------------|----------|------------|---------------------|---------|
|                    |               |                    |          |            | Upper               | Lower   |
| 0.25BS             | CBN           | 2mm                | Standard | φ4mm       | 10.00mm             | 10.00mm |

|                    |          |                   |                      |  |  |  |  |  |  |  |  |
|--------------------|----------|-------------------|----------------------|--|--|--|--|--|--|--|--|
| Cutting Process    | Start Up | Class1            |                      |  |  |  |  |  |  |  |  |
| E-pack Number      | Eno      | 951               | 16941                |  |  |  |  |  |  |  |  |
| Power Supply       | PS       | RH                | RH                   |  |  |  |  |  |  |  |  |
| Servo              | SV       | NM                | NM                   |  |  |  |  |  |  |  |  |
| Voltage Open       | Vo       | 7                 | 12                   |  |  |  |  |  |  |  |  |
| Power Setting      | IP       | 7.0               | 10.0                 |  |  |  |  |  |  |  |  |
| IP adjust          | ΔIP      | 11                | 8                    |  |  |  |  |  |  |  |  |
| Off Time           | OFF      | 6                 | 16                   |  |  |  |  |  |  |  |  |
| Stabilizer A       | SA       | 3                 | 3                    |  |  |  |  |  |  |  |  |
| Stabilizer B       | SB       | 8                 | 16                   |  |  |  |  |  |  |  |  |
| Stabilizer C       | SC       | 7                 | 3                    |  |  |  |  |  |  |  |  |
| Stabilizer E       | SE       | 4                 | 1                    |  |  |  |  |  |  |  |  |
| Voltage Gap        | VG       | 60.0<br>(58 ~ 62) | 125.0<br>(122 ~ 128) |  |  |  |  |  |  |  |  |
| Fine machining     | FM       | OFF               | OFF                  |  |  |  |  |  |  |  |  |
| Digital AE         | DAE      | OFF               | OFF                  |  |  |  |  |  |  |  |  |
| Wire Speed         | WS       | 8                 | 12                   |  |  |  |  |  |  |  |  |
| Wire Tension       | WT       | 9                 | 10                   |  |  |  |  |  |  |  |  |
| Pre-Tension        | PT       | 14                | 14                   |  |  |  |  |  |  |  |  |
| Flow Balance       | FB       | NM                | NM                   |  |  |  |  |  |  |  |  |
| Liquid Quantity    | LQ       | 11                | 12                   |  |  |  |  |  |  |  |  |
| Liquid Resistivity | LR       | 10                | 10                   |  |  |  |  |  |  |  |  |
| Feedrate Address   | FA       | 2.0               | 1.5                  |  |  |  |  |  |  |  |  |
| Upper Flow Rate    |          | 6.0               | 10.0                 |  |  |  |  |  |  |  |  |
| Lower Flow Rate    |          | 6.0               | 10.0                 |  |  |  |  |  |  |  |  |

| Offset Value(s) |       |       |  |  |  |  |  |  |  |  |  |
|-----------------|-------|-------|--|--|--|--|--|--|--|--|--|
| Rough Cut       | ----- | 169.0 |  |  |  |  |  |  |  |  |  |

| RESULTS              |     |  |             |  |  |  |  |  |  |  |  |
|----------------------|-----|--|-------------|--|--|--|--|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.9 ~ 2.6   |  |  |  |  |  |  |  |  |
| Average Voltage Gap  | V   |  | 119 ~ 132   |  |  |  |  |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 3.6         |  |  |  |  |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 |  |  |  |  |  |  |  |  |
|                      | Ra  |  | 2.40 ~ 3.00 |  |  |  |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
 (If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)  
 (Class1=Particle size2μm )

**5-8 SL machining**  
**Machining Characteristics Data**

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process      |
|--------------------|---------------|--------------------|--------------|
| 0.20BS             | STEEL         | 5~100mm            | SL machining |

| Cutting Process  | Start Up | Rough Cut | Skim1           | Skim2           | Skim3           | Skim4           | Skim5 | Skim6 |
|------------------|----------|-----------|-----------------|-----------------|-----------------|-----------------|-------|-------|
| E-pack Number    | Eno      | PM        | 5502            | 5503            | 5504            | 5505            |       |       |
| Power Supply     | PS       |           | RL              | HL              | LC              | LC              |       |       |
| Servo            | SV       |           | SL              | SL              | SL              | SL              |       |       |
| Voltage Open     | Vo       |           | 4               | 12              | 12              | 11              |       |       |
| Power Setting    | IP       |           | 6               | 14              | 3               | 2.5             |       |       |
| IP adjust        | ΔIP      |           | 10              | 12              | -               | -               |       |       |
| Off Time         | OFF      |           | 7               | 7               | 10              | 8               |       |       |
| Stabilizer A     | SA       |           | 3               | 1               | 2               | 1               |       |       |
| Stabilizer B     | SB       |           | 7               | 7               | 9               | 7               |       |       |
| Stabilizer C     | SC       |           | 1               | 1               | 1               | 1               |       |       |
| Stabilizer E     | SE       |           | 1               | 1               | 1               | 1               |       |       |
| Voltage Gap      | VG       |           | 42<br>(39 ~ 45) | 44<br>(41 ~ 47) | 30<br>(27 ~ 33) | 44<br>(41 ~ 47) |       |       |
| Fine Machining   | FM       |           | OFF             | OFF             | ON              | ON              |       |       |
| Digital AE       | DAE      |           | ON              | ON              | OFF             | OFF             |       |       |
| Fine machining   | WS       |           | 12              | 12              | 10              | 10              |       |       |
| Wire Speed       | WT       |           | 10              | 10              | 10              | 10              |       |       |
| Wire Tension     | PT       |           | 14              | 14              | 14              | 14              |       |       |
| Pre-Tension      | FB       |           | NM              | NM              | NM              | NM              |       |       |
| Flow Balance     | LQ       |           | 4               | 4               | 4               | 4               |       |       |
| Liquid Quantity  | LR       |           | 10              | 10              | 10              | 10              |       |       |
| Feedrate Address | FA       |           | 4.2             | 3.0             | 7.0             | 6.5             |       |       |
| SL Control       | P        |           | 7329            | 10694           | 10988           | 16378           |       |       |
| SL Adjustment    | SLA      |           | 105             | 422             | 1716            | 4518            |       |       |
| Upper Flow Rate  | 6.0      | 8.0       | 1.0             | 1.0             | 1.0             | 1.0             |       |       |
| Lower Flow Rate  | 5.0      | 8.0       | 1.0             | 1.0             | 1.0             | 1.0             |       |       |

| Offset Value (μm)  |      |      |      |      |      |      |      |      |
|--------------------|------|------|------|------|------|------|------|------|
| Rough Cut          | ---- | 141  | ---- | ---- | ---- | ---- | ---- | ---- |
| Rough & 1 Skim     | ---- | 172  | 107  | ---- | ---- | ---- | ---- | ---- |
| Rough & 2 Skims    | ---- | 197  | 132  | 107  | ---- | ---- | ---- | ---- |
| Rough & 3 Skims    | ---- | 209  | 144  | 119  | 107  | ---- | ---- | ---- |
| Rough & 4 Skims    | ---- | 212  | 147  | 122  | 110  | 107  | ---- | ---- |
| Rough & 5 Skims    | ---- |      |      |      |      |      |      | ---- |
| Rough & 6 Skims    | ---- |      |      |      |      |      |      |      |
| Stepping Increment | ---- | ---- | 65   | 25   | 12   | 3    |      |      |

| RESULTS             |    |  |             |             |             |           |           |  |
|---------------------|----|--|-------------|-------------|-------------|-----------|-----------|--|
| Surface Finish(u m) | Rz |  | 19.0 ~ 22.0 | 14.0 ~ 16.0 | 10.0 ~ 12.0 | 4.5 ~ 5.5 | 2.5 ~ 3.5 |  |
|                     | Ra |  | 2.3 ~ 2.7   | 1.7 ~ 2.0   | 1.3 ~ 1.5   | 0.5 ~ 0.7 | 0.3 ~ 0.4 |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process      |
|--------------------|---------------|--------------------|--------------|
| 0.25BS             | STEEL         | 5~100mm            | SL machining |

| Cutting Process  | Start Up | Rough Cut | Skim1           | Skim2           | Skim3           | Skim4           | Skim5 | Skim6 |
|------------------|----------|-----------|-----------------|-----------------|-----------------|-----------------|-------|-------|
| E-pack Number    | Eno      | PM        | 5602            | 5603            | 5604            | 5605            |       |       |
| Power Supply     | PS       |           | RH              | HL              | LC              | LC              |       |       |
| Servo            | SV       |           | SL              | SL              | SL              | SL              |       |       |
| Voltage Open     | Vo       |           | 8               | 12              | 14              | 13              |       |       |
| Power Setting    | IP       |           | 6               | 14              | 3               | 2.5             |       |       |
| IP adjust        | ΔIP      |           | 10              | 12              | -               | -               |       |       |
| Off Time         | OFF      |           | 7               | 8               | 10              | 2               |       |       |
| Stabilizer A     | SA       |           | 4               | 1               | 2               | 1               |       |       |
| Stabilizer B     | SB       |           | 7               | 8               | 9               | 6               |       |       |
| Stabilizer C     | SC       |           | 1               | 1               | 1               | 1               |       |       |
| Stabilizer E     | SE       |           | 1               | 1               | 1               | 1               |       |       |
| Voltage Gap      | VG       |           | 40<br>(37 ~ 43) | 45<br>(42 ~ 48) | 30<br>(27 ~ 33) | 60<br>(57 ~ 63) |       |       |
| Fine Machining   | FM       |           | OFF             | OFF             | ON              | ON              |       |       |
| Digital AE       | DAE      |           | ON              | ON              | OFF             | OFF             |       |       |
| Fine machining   | WS       |           | 12              | 12              | 10              | 10              |       |       |
| Wire Speed       | WT       |           | 14              | 14              | 14              | 14              |       |       |
| Wire Tension     | PT       |           | 14              | 14              | 14              | 14              |       |       |
| Pre-Tension      | FB       |           | NM              | NM              | NM              | NM              |       |       |
| Flow Balance     | LQ       |           | 4               | 4               | 4               | 4               |       |       |
| Liquid Quantity  | LR       |           | 10              | 10              | 10              | 10              |       |       |
| Feedrate Address | FA       |           | 6.0             | 3.0             | 9.0             | 6.5             |       |       |
| SL Control       | P        |           | 20142           | 2226            | 12488           | 4627            |       |       |
| SL Adjustment    | SLA      |           | 316             | 622             | 2315            | 2021            |       |       |
| Upper Flow Rate  | 6.0      | 8.0       | 1.0             | 1.0             | 1.0             | 1.0             |       |       |
| Lower Flow Rate  | 5.0      | 8.0       | 1.0             | 1.0             | 1.0             | 1.0             |       |       |

| Offset Value (μm)  |      |      |      |      |      |      |      |      |
|--------------------|------|------|------|------|------|------|------|------|
| Rough Cut          | ---- | 184  | ---- | ---- | ---- | ---- | ---- | ---- |
| Rough & 1 Skim     | ---- | 207  | 132  | ---- | ---- | ---- | ---- | ---- |
| Rough & 2 Skims    | ---- | 237  | 162  | 132  | ---- | ---- | ---- | ---- |
| Rough & 3 Skims    | ---- | 249  | 174  | 144  | 132  | ---- | ---- | ---- |
| Rough & 4 Skims    | ---- | 252  | 177  | 147  | 135  | 132  | ---- | ---- |
| Rough & 5 Skims    | ---- |      |      |      |      |      |      | ---- |
| Rough & 6 Skims    | ---- |      |      |      |      |      |      |      |
| Stepping Increment | ---- | ---- | 75   | 30   | 12   | 3    |      |      |

| RESULTS  |    |  |             |             |             |           |           |  |
|----------|----|--|-------------|-------------|-------------|-----------|-----------|--|
| 面あらし(μm) | Rz |  | 19.0 ~ 22.0 | 14.0 ~ 16.0 | 10.0 ~ 12.0 | 4.5 ~ 5.5 | 2.5 ~ 3.5 |  |
|          | Ra |  | 2.3 ~ 2.7   | 1.7 ~ 2.0   | 1.3 ~ 1.5   | 0.5 ~ 0.7 | 0.3 ~ 0.4 |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



**5-9 Anglemaster**  
**Wide Angle Taper Specifications (Option)**  
**Machining Characteristics Data**

## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.20<br>(Megacut Type-T) | STEEL         | 20mm               | A=15        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1               | Skim2              | Skim3                | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|---------------------|--------------------|----------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16241             | 16242               | 16243              | 16244                | 16245             |       |       |       |       |       |
| Taper Angle           | A        | 15                | 15                  | 15                 | 15                   | 15                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                  | RH                 | LC                   | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                  | NM                 | SL                   | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 10                  | 6                  | 10                   | 9                 |       |       |       |       |       |
| Power Setting         | IP       | 7.0               | 6.0                 | 5.0                | 3.0                  | 2.5               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                  | 10                 | -                    | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 7                   | 7                  | 8                    | 8                 |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                   | 2                  | 2                    | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 8                 | 7                   | 7                  | 6                    | 6                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 60.0<br>(56 ~ 70) | 100.0<br>(90 ~ 110) | 90.0<br>(80 ~ 100) | 120.0<br>(110 ~ 130) | 80.0<br>(75 ~ 85) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                  | 12                 | 12                   | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 5                 | 5                   | 5                  | 5                    | 5                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                  | 13                 | 13                   | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                  | NM                 | NM                   | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                   | 4                  | 4                    | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                  | 10                 | 10                   | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 808                 | 808                | 808                  | 808               |       |       |       |       |       |
| SL Control            | P        | -                 | -                   | -                  | 220                  | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                   | -                  | 110                  | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                  | ON                 | ON                   | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.9               | 3.3                 | 4.0                | 6.0                  | 6.2               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 278.0             | 188.0               | 158.0              | 127.0                | 115.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 90.0                | 30.0               | 31.0                 | 12.0              |       |       |       |       |       |

| RESULTS             |    |           |           |           |           |             |  |  |  |  |  |
|---------------------|----|-----------|-----------|-----------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 1.2 ~ 1.8 | 6.0 ~ 7.4 | 6.8 ~ 9.0 | 6.0 ~ 6.4 | 6.4 ~ 6.8   |  |  |  |  |  |
| Average Voltage Gap | V  | 54 ~ 70   | 95 ~ 115  | 80 ~ 96   | 140 ~ 150 | 110 ~ 120   |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -         | -         | -         | 4.0 ~ 4.5   |  |  |  |  |  |
|                     | Ra | -         | -         | -         | -         | 0.63 ~ 0.68 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.20<br>(Megacut Type-T) | STEEL         | 20mm               | A=20        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1               | Skim2              | Skim3                | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|---------------------|--------------------|----------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16251             | 16252               | 16253              | 16254                | 16255             |       |       |       |       |       |
| Taper Angle           | A        | 20                | 20                  | 20                 | 20                   | 20                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                  | RH                 | LC                   | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                  | NM                 | SL                   | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 10                  | 6                  | 10                   | 9                 |       |       |       |       |       |
| Power Setting         | IP       | 7.0               | 6.0                 | 5.0                | 3.0                  | 2.5               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                  | 10                 | -                    | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 7                   | 7                  | 8                    | 8                 |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                   | 2                  | 2                    | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 8                 | 7                   | 7                  | 6                    | 6                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 60.0<br>(56 ~ 70) | 100.0<br>(90 ~ 110) | 90.0<br>(80 ~ 100) | 120.0<br>(110 ~ 130) | 80.0<br>(75 ~ 85) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                  | 12                 | 12                   | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 5                 | 5                   | 5                  | 5                    | 5                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                  | 13                 | 13                   | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                  | NM                 | NM                   | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                   | 4                  | 4                    | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                  | 10                 | 10                   | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 808                 | 808                | 808                  | 808               |       |       |       |       |       |
| SL Control            | P        | -                 | -                   | -                  | 220                  | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                   | -                  | 110                  | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                  | ON                 | ON                   | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.9               | 3.3                 | 4.0                | 6.0                  | 6.2               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 275.0             | 185.0               | 155.0              | 124.0                | 112.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 90.0                | 30.0               | 31.0                 | 12.0              |       |       |       |       |       |

| RESULTS             |    |           |           |           |           |             |  |  |  |  |  |
|---------------------|----|-----------|-----------|-----------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 1.2 ~ 1.8 | 5.4 ~ 6.8 | 5.6 ~ 7.0 | 6.0 ~ 6.4 | 6.4 ~ 6.8   |  |  |  |  |  |
| Average Voltage Gap | V  | 54 ~ 70   | 95 ~ 115  | 80 ~ 96   | 140 ~ 150 | 110 ~ 120   |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -         | -         | -         | 4.5 ~ 5.0   |  |  |  |  |  |
|                     | Ra | -         | -         | -         | -         | 0.63 ~ 0.68 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.20<br>(Megacut Type-T) | STEEL         | 20mm               | A=30        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1             | Skim2             | Skim3             | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|-------------------|-------------------|-------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16201             | 16202             | 16203             | 16204             | 16205             |       |       |       |       |       |
| Taper Angle           | A        | 30                | 30                | 30                | 30                | 30                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                | RH                | LC                | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                | NM                | SL                | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 4                 | 4                 | 7                 | 5                 |       |       |       |       |       |
| Power Setting         | IP       | 7.0               | 6.0               | 5.0               | 3.0               | 3.0               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                | 10                | -                 | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 9                 | 9                 | 12                | 10                |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                 | 2                 | 2                 | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 8                 | 9                 | 9                 | 10                | 7                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                 | 1                 | 1                 | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                 | 1                 | 1                 | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 60.0<br>(57 ~ 63) | 50.0<br>(47 ~ 53) | 40.0<br>(37 ~ 43) | 55.0<br>(52 ~ 58) | 80.0<br>(77 ~ 83) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF               | OFF               | OFF               | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF               | OFF               | OFF               | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                | 12                | 12                | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 5                 | 5                 | 5                 | 5                 | 5                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                | 13                | 13                | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                | NM                | NM                | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                 | 4                 | 4                 | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                | 10                | 10                | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 608               | 608               | 608               | 608               |       |       |       |       |       |
| SL Control            | P        | -                 | -                 | -                 | 220               | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                 | -                 | 110               | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                | ON                | ON                | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.5               | 3.9               | 2.5               | 6.0               | 6.2               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0               | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0               | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 281.0             | 191.0             | 168.0             | 143.0             | 137.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 90.0              | 23.0              | 25.0              | 6.0               |       |       |       |       |       |

| RESULTS             |    |           |           |           |           |             |  |  |  |  |  |
|---------------------|----|-----------|-----------|-----------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 1.2 ~ 1.4 | 7.4 ~ 7.6 | 8.7 ~ 9.2 | 6.1 ~ 6.2 | 6.3 ~ 6.3   |  |  |  |  |  |
| Average Voltage Gap | V  | 60 ~ 67   | 54 ~ 62   | 63 ~ 66   | 69 ~ 72   | 92 ~ 94     |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -         | -         | -         | 4.0 ~ 4.5   |  |  |  |  |  |
|                     | Ra | -         | -         | -         | -         | 0.58 ~ 0.63 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.20<br>(Megacut Type-T) | STEEL         | 40mm               | A=15        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1               | Skim2              | Skim3                | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|---------------------|--------------------|----------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16261             | 16261               | 16263              | 16264                | 16265             |       |       |       |       |       |
| Taper Angle           | A        | 15                | 15                  | 15                 | 15                   | 15                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                  | RH                 | LC                   | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                  | NM                 | SL                   | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 10                  | 6                  | 10                   | 9                 |       |       |       |       |       |
| Power Setting         | IP       | 7.0               | 6.0                 | 5.0                | 3.0                  | 2.5               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                  | 10                 | -                    | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 7                   | 7                  | 8                    | 8                 |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                   | 2                  | 2                    | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 8                 | 7                   | 7                  | 6                    | 6                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 60.0<br>(56 ~ 70) | 100.0<br>(90 ~ 110) | 90.0<br>(80 ~ 100) | 115.0<br>(110 ~ 130) | 80.0<br>(75 ~ 85) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                  | 12                 | 12                   | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 5                 | 5                   | 5                  | 5                    | 5                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                  | 13                 | 13                   | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                  | NM                 | NM                   | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                   | 4                  | 4                    | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                  | 10                 | 10                   | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 808                 | 808                | 808                  | 808               |       |       |       |       |       |
| SL Control            | P        | -                 | -                   | -                  | 220                  | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                   | -                  | 110                  | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                  | ON                 | ON                   | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.9               | 2.0                 | 2.0                | 6.0                  | 6.2               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 282.0             | 192.0               | 162.0              | 131.0                | 119.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 90.0                | 30.0               | 31.0                 | 12.0              |       |       |       |       |       |

| RESULTS             |    |           |           |           |           |             |  |  |  |  |  |
|---------------------|----|-----------|-----------|-----------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 0.2 ~ 0.6 | 1.8 ~ 3.6 | 2.8 ~ 4.4 | 6.0 ~ 6.4 | 6.4 ~ 6.8   |  |  |  |  |  |
| Average Voltage Gap | V  | 50 ~ 64   | 90 ~ 110  | 86 ~ 98   | 135 ~ 145 | 110 ~ 120   |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -         | -         | -         | 4.5 ~ 5.0   |  |  |  |  |  |
|                     | Ra | -         | -         | -         | -         | 0.63 ~ 0.68 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.20<br>(Megacut Type-T) | STEEL         | 40mm               | A=20        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1               | Skim2              | Skim3                | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|---------------------|--------------------|----------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16271             | 16272               | 16273              | 16274                | 16275             |       |       |       |       |       |
| Taper Angle           | A        | 20                | 20                  | 20                 | 20                   | 20                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                  | RH                 | LC                   | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                  | NM                 | SL                   | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 10                  | 6                  | 10                   | 9                 |       |       |       |       |       |
| Power Setting         | IP       | 7.0               | 6.0                 | 5.0                | 3.0                  | 2.5               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                  | 10                 | -                    | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 7                   | 7                  | 8                    | 8                 |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                   | 2                  | 2                    | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 8                 | 7                   | 7                  | 6                    | 6                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 60.0<br>(56 ~ 70) | 100.0<br>(90 ~ 110) | 90.0<br>(80 ~ 100) | 115.0<br>(110 ~ 130) | 80.0<br>(75 ~ 85) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                  | 12                 | 12                   | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 5                 | 5                   | 5                  | 5                    | 5                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                  | 13                 | 13                   | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                  | NM                 | NM                   | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                   | 4                  | 4                    | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                  | 10                 | 10                   | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 808                 | 808                | 808                  | 808               |       |       |       |       |       |
| SL Control            | P        | -                 | -                   | -                  | 220                  | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                   | -                  | 110                  | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                  | ON                 | ON                   | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.2               | 2.8                 | 2.0                | 6.0                  | 6.0               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 279.0             | 189.0               | 159.0              | 128.0                | 116.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 90.0                | 30.0               | 31.0                 | 12.0              |       |       |       |       |       |

| RESULTS             |    |           |           |           |           |             |  |  |  |  |  |
|---------------------|----|-----------|-----------|-----------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 0.2 ~ 0.6 | 1.6 ~ 3.6 | 2.6 ~ 4.4 | 6.0 ~ 6.4 | 6.4 ~ 6.8   |  |  |  |  |  |
| Average Voltage Gap | V  | 50 ~ 64   | 90 ~ 110  | 86 ~ 98   | 135 ~ 145 | 110 ~ 120   |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -         | -         | -         | 4.5 ~ 5.0   |  |  |  |  |  |
|                     | Ra | -         | -         | -         | -         | 0.63 ~ 0.68 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.20<br>(Megacut Type-T) | STEEL         | 20mm               | A=45        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1             | Skim2             | Skim3             | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|-------------------|-------------------|-------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16211             | 16212             | 16213             | 16214             | 16215             |       |       |       |       |       |
| Taper Angle           | A        | 45                | 45                | 45                | 45                | 45                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                | RH                | LC                | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                | NM                | SL                | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 4                 | 4                 | 7                 | 5                 |       |       |       |       |       |
| Power Setting         | IP       | 7.0               | 6.0               | 5.0               | 3.0               | 3.0               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                | 10                | -                 | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 9                 | 9                 | 12                | 10                |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                 | 2                 | 2                 | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 8                 | 9                 | 9                 | 10                | 7                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                 | 1                 | 1                 | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                 | 1                 | 1                 | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 60.0<br>(57 ~ 63) | 50.0<br>(47 ~ 53) | 46.0<br>(43 ~ 49) | 55.0<br>(52 ~ 58) | 60.0<br>(57 ~ 63) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF               | OFF               | OFF               | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF               | OFF               | OFF               | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                | 12                | 12                | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 5                 | 5                 | 5                 | 5                 | 5                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                | 13                | 13                | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                | NM                | NM                | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                 | 4                 | 4                 | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                | 10                | 10                | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 608               | 608               | 608               | 608               |       |       |       |       |       |
| SL Control            | P        | -                 | -                 | -                 | 220               | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                 | -                 | 110               | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                | ON                | ON                | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.4               | 3.3               | 2.5               | 6.0               | 6.2               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0               | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0               | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 275.0             | 185.0             | 162.0             | 137.0             | 131.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 90.0              | 23.0              | 25.0              | 6.0               |       |       |       |       |       |

| RESULTS             |    |           |           |           |           |             |  |  |  |  |  |
|---------------------|----|-----------|-----------|-----------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 1.1 ~ 1.3 | 7.5 ~ 7.8 | 8.0 ~ 8.3 | 6.2 ~ 6.2 | 6.5 ~ 6.6   |  |  |  |  |  |
| Average Voltage Gap | V  | 62 ~ 64   | 60 ~ 63   | 66 ~ 70   | 78 ~ 80   | 96 ~ 98     |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -         | -         | -         | 4.0 ~ 4.5   |  |  |  |  |  |
|                     | Ra | -         | -         | -         | -         | 0.58 ~ 0.63 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.20<br>(Megacut Type-T) | STEEL         | 40mm               | A=30        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1             | Skim2             | Skim3             | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|-------------------|-------------------|-------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16221             | 16222             | 16223             | 16224             | 16225             |       |       |       |       |       |
| Taper Angle           | A        | 30                | 30                | 30                | 30                | 30                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                | RH                | LC                | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                | NM                | SL                | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 4                 | 4                 | 7                 | 5                 |       |       |       |       |       |
| Power Setting         | IP       | 7.0               | 6.0               | 5.0               | 3.0               | 3.0               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                | 10                | -                 | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 9                 | 9                 | 12                | 10                |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                 | 2                 | 2                 | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 8                 | 9                 | 9                 | 10                | 7                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                 | 1                 | 1                 | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                 | 1                 | 1                 | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 60.0<br>(57 ~ 63) | 55.0<br>(52 ~ 58) | 50.0<br>(47 ~ 53) | 55.0<br>(52 ~ 58) | 66.0<br>(63 ~ 69) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF               | OFF               | OFF               | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF               | OFF               | OFF               | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                | 12                | 12                | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 5                 | 5                 | 5                 | 5                 | 5                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                | 13                | 13                | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                | NM                | NM                | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                 | 4                 | 4                 | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                | 10                | 10                | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 608               | 608               | 608               | 608               |       |       |       |       |       |
| SL Control            | P        | -                 | -                 | -                 | 220               | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                 | -                 | 110               | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                | ON                | ON                | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.3               | 2.8               | 2.5               | 6.0               | 6.0               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0               | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0               | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 285.0             | 185.0             | 162.0             | 147.0             | 141.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 100.0             | 23.0              | 15.0              | 6.0               |       |       |       |       |       |

| RESULTS             |    |           |           |           |           |             |  |  |  |  |  |
|---------------------|----|-----------|-----------|-----------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 0.5 ~ 0.7 | 3.6 ~ 3.9 | 5.8 ~ 6.1 | 6.1 ~ 6.1 | 6.1 ~ 6.1   |  |  |  |  |  |
| Average Voltage Gap | V  | 57 ~ 60   | 57 ~ 61   | 59 ~ 61   | 63 ~ 66   | 83 ~ 86     |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -         | -         | -         | 4.0 ~ 4.5   |  |  |  |  |  |
|                     | Ra | -         | -         | -         | -         | 0.58 ~ 0.63 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.20<br>(Megacut Type-T) | STEEL         | 40mm               | A=45        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1             | Skim2             | Skim3             | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|-------------------|-------------------|-------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16231             | 16232             | 16233             | 16234             | 16235             |       |       |       |       |       |
| Taper Angle           | A        | 45                | 45                | 45                | 45                | 45                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                | RH                | LC                | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                | NM                | SL                | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 4                 | 4                 | 7                 | 10                |       |       |       |       |       |
| Power Setting         | IP       | 7.0               | 6.0               | 5.0               | 3.0               | 3.0               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                | 10                | -                 | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 9                 | 9                 | 12                | 10                |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                 | 2                 | 2                 | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 8                 | 9                 | 9                 | 10                | 7                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                 | 1                 | 1                 | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                 | 1                 | 1                 | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 60.0<br>(57 ~ 63) | 50.0<br>(47 ~ 53) | 46.0<br>(43 ~ 49) | 55.0<br>(52 ~ 58) | 80.0<br>(77 ~ 83) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF               | OFF               | OFF               | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF               | OFF               | OFF               | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                | 12                | 12                | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 5                 | 5                 | 5                 | 5                 | 5                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                | 13                | 13                | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                | NM                | NM                | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                 | 4                 | 4                 | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                | 10                | 10                | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 608               | 608               | 608               | 608               |       |       |       |       |       |
| SL Control            | P        | -                 | -                 | -                 | 220               | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                 | -                 | 110               | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                | ON                | ON                | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.2               | 2.8               | 2.0               | 6.0               | 6.0               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0               | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0               | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 279.0             | 179.0             | 156.0             | 141.0             | 135.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 100.0             | 23.0              | 15.0              | 6.0               |       |       |       |       |       |

| RESULTS             |    |           |           |           |           |             |  |  |  |  |  |
|---------------------|----|-----------|-----------|-----------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 0.5 ~ 0.7 | 5.7 ~ 5.9 | 4.7 ~ 5.0 | 6.1 ~ 6.1 | 6.2 ~ 6.2   |  |  |  |  |  |
| Average Voltage Gap | V  | 57 ~ 59   | 55 ~ 58   | 53 ~ 55   | 69 ~ 71   | 96 ~ 97     |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -         | -         | -         | 4.0 ~ 4.5   |  |  |  |  |  |
|                     | Ra | -         | -         | -         | -         | 0.58 ~ 0.63 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.25<br>(Megacut Type-T) | STEEL         | 20mm               | A=15        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1               | Skim2              | Skim3                | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|---------------------|--------------------|----------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16341             | 16342               | 16343              | 16344                | 16345             |       |       |       |       |       |
| Taper Angle           | A        | 15                | 15                  | 15                 | 15                   | 15                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                  | RH                 | LC                   | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                  | NM                 | SL                   | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 10                  | 6                  | 11                   | 10                |       |       |       |       |       |
| Power Setting         | IP       | 8.0               | 6.0                 | 5.0                | 3.0                  | 2.5               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                  | 10                 | -                    | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 6                   | 6                  | 8                    | 8                 |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                   | 2                  | 2                    | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 8                 | 6                   | 6                  | 6                    | 6                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 60.0<br>(56 ~ 70) | 100.0<br>(90 ~ 110) | 90.0<br>(80 ~ 100) | 125.0<br>(115 ~ 135) | 86.0<br>(76 ~ 96) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                  | 12                 | 12                   | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 7                 | 7                   | 7                  | 7                    | 7                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                  | 13                 | 13                   | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                  | NM                 | NM                   | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                   | 4                  | 4                    | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                  | 10                 | 10                   | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 808                 | 808                | 808                  | 808               |       |       |       |       |       |
| SL Control            | P        | -                 | -                   | -                  | 220                  | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                   | -                  | 110                  | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                  | ON                 | ON                   | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.9               | 3.3                 | 4.0                | 6.0                  | 6.2               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 291.0             | 201.0               | 171.0              | 140.0                | 128.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 90.0                | 30.0               | 31.0                 | 12.0              |       |       |       |       |       |

| RESULTS             |    |           |           |           |           |             |  |  |  |  |  |
|---------------------|----|-----------|-----------|-----------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 1.2 ~ 2.0 | 5.4 ~ 8.0 | 6.2 ~ 8.4 | 6.0 ~ 6.4 | 6.4 ~ 6.8   |  |  |  |  |  |
| Average Voltage Gap | V  | 52 ~ 72   | 90 ~ 115  | 82 ~ 98   | 144 ~ 156 | 114 ~ 124   |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -         | -         | -         | 4.5 ~ 5.0   |  |  |  |  |  |
|                     | Ra | -         | -         | -         | -         | 0.63 ~ 0.68 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.25<br>(Megacut Type-T) | STEEL         | 20mm               | A=20        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1               | Skim2              | Skim3                | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|---------------------|--------------------|----------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16351             | 16352               | 16353              | 16354                | 16355             |       |       |       |       |       |
| Taper Angle           | A        | 20                | 20                  | 20                 | 20                   | 20                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                  | RH                 | LC                   | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                  | NM                 | SL                   | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 10                  | 6                  | 11                   | 10                |       |       |       |       |       |
| Power Setting         | IP       | 8.0               | 6.0                 | 5.0                | 3.0                  | 2.5               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                  | 10                 | -                    | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 6                   | 6                  | 8                    | 8                 |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                   | 2                  | 2                    | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 8                 | 6                   | 6                  | 6                    | 6                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 60.0<br>(56 ~ 70) | 100.0<br>(90 ~ 110) | 90.0<br>(80 ~ 100) | 125.0<br>(115 ~ 135) | 86.0<br>(76 ~ 96) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                  | 12                 | 12                   | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 7                 | 7                   | 7                  | 7                    | 7                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                  | 13                 | 13                   | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                  | NM                 | NM                   | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                   | 4                  | 4                    | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                  | 10                 | 10                   | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 808                 | 808                | 808                  | 808               |       |       |       |       |       |
| SL Control            | P        | -                 | -                   | -                  | 220                  | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                   | -                  | 110                  | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                  | ON                 | ON                   | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.9               | 3.3                 | 4.0                | 6.0                  | 6.2               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 288.0             | 198.0               | 168.0              | 137.0                | 125.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 90.0                | 30.0               | 31.0                 | 12.0              |       |       |       |       |       |

| RESULTS             |    |           |           |           |           |             |  |  |  |  |  |
|---------------------|----|-----------|-----------|-----------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 1.2 ~ 2.0 | 4.8 ~ 8.0 | 5.0 ~ 8.4 | 6.0 ~ 6.4 | 6.4 ~ 6.8   |  |  |  |  |  |
| Average Voltage Gap | V  | 52 ~ 72   | 86 ~ 115  | 82 ~ 98   | 144 ~ 156 | 114 ~ 124   |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -         | -         | -         | 4.5 ~ 5.0   |  |  |  |  |  |
|                     | Ra | -         | -         | -         | -         | 0.63 ~ 0.68 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.25<br>(Megacut Type-T) | STEEL         | 20mm               | A=30        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1             | Skim2             | Skim3                | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|-------------------|-------------------|----------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16301             | 16302             | 16303             | 16304                | 16305             |       |       |       |       |       |
| Taper Angle           | A        | 30                | 30                | 30                | 30                   | 30                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                | RH                | LC                   | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                | NM                | SL                   | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 10                | 6                 | 11                   | 9                 |       |       |       |       |       |
| Power Setting         | IP       | 8.0               | 6.0               | 5.0               | 3.0                  | 3.0               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                | 10                | -                    | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 6                 | 6                 | 8                    | 8                 |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                 | 2                 | 2                    | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 8                 | 6                 | 6                 | 6                    | 6                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                 | 1                 | 1                    | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                 | 1                 | 1                    | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 60.0<br>(57 ~ 63) | 76.0<br>(73 ~ 79) | 61.0<br>(58 ~ 64) | 115.0<br>(112 ~ 118) | 86.0<br>(83 ~ 89) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF               | OFF               | OFF                  | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF               | OFF               | OFF                  | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                | 12                | 12                   | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 7                 | 7                 | 7                 | 7                    | 7                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                | 13                | 13                   | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                | NM                | NM                   | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                 | 4                 | 4                    | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                | 10                | 10                   | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 808               | 808               | 808                  | 808               |       |       |       |       |       |
| SL Control            | P        | -                 | -                 | -                 | 220                  | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                 | -                 | 110                  | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                | ON                | ON                   | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.9               | 3.3               | 4.0               | 6.0                  | 6.2               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0                  | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0                  | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 311.0             | 221.0             | 198.0             | 173.0                | 162.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 90.0              | 23.0              | 25.0                 | 11.0              |       |       |       |       |       |

| RESULTS             |    |           |            |             |           |             |  |  |  |  |  |
|---------------------|----|-----------|------------|-------------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 1.5 ~ 2.1 | 8.3 ~ 10.0 | 10.4 ~ 11.6 | 6.4 ~ 6.5 | 6.6 ~ 6.6   |  |  |  |  |  |
| Average Voltage Gap | V  | 53 ~ 65   | 85 ~ 100   | 79 ~ 88     | 158 ~ 163 | 126 ~ 131   |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -          | -           | -         | 4.0 ~ 4.5   |  |  |  |  |  |
|                     | Ra | -         | -          | -           | -         | 0.58 ~ 0.63 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.25<br>(Megacut Type-T) | STEEL         | 20mm               | A=45        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1             | Skim2             | Skim3                | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|-------------------|-------------------|----------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16311             | 16312             | 16313             | 16314                | 16315             |       |       |       |       |       |
| Taper Angle           | A        | 45                | 45                | 45                | 45                   | 45                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                | RH                | LC                   | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                | NM                | SL                   | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 10                | 6                 | 11                   | 9                 |       |       |       |       |       |
| Power Setting         | IP       | 8.0               | 6.0               | 5.0               | 3.0                  | 3.0               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                | 10                | -                    | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 6                 | 6                 | 8                    | 8                 |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                 | 2                 | 2                    | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 8                 | 6                 | 6                 | 6                    | 6                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                 | 1                 | 1                    | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                 | 1                 | 1                    | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 60.0<br>(57 ~ 63) | 76.0<br>(73 ~ 79) | 61.0<br>(58 ~ 64) | 108.0<br>(105 ~ 111) | 80.0<br>(77 ~ 83) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF               | OFF               | OFF                  | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF               | OFF               | OFF                  | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                | 12                | 12                   | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 7                 | 7                 | 7                 | 7                    | 7                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                | 13                | 13                   | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                | NM                | NM                   | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                 | 4                 | 4                    | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                | 10                | 10                   | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 808               | 808               | 808                  | 808               |       |       |       |       |       |
| SL Control            | P        | -                 | -                 | -                 | 220                  | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                 | -                 | 110                  | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                | ON                | ON                   | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.9               | 3.3               | 4.0               | 6.0                  | 6.2               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0                  | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0                  | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 305.0             | 215.0             | 192.0             | 167.0                | 156.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 90.0              | 23.0              | 25.0                 | 11.0              |       |       |       |       |       |

| RESULTS             |    |           |            |             |           |             |  |  |  |  |  |
|---------------------|----|-----------|------------|-------------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 1.3 ~ 1.9 | 9.7 ~ 11.2 | 11.0 ~ 12.2 | 6.5 ~ 6.6 | 6.8 ~ 6.8   |  |  |  |  |  |
| Average Voltage Gap | V  | 56 ~ 65   | 95 ~ 105   | 81 ~ 91     | 164 ~ 167 | 141 ~ 144   |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -          | -           | -         | 4.0 ~ 4.5   |  |  |  |  |  |
|                     | Ra | -         | -          | -           | -         | 0.58 ~ 0.63 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.25<br>(Megacut Type-T) | STEEL         | 40mm               | A=15        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1               | Skim2              | Skim3                | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|---------------------|--------------------|----------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16361             | 16362               | 16363              | 16364                | 16365             |       |       |       |       |       |
| Taper Angle           | A        | 15                | 15                  | 15                 | 15                   | 15                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                  | RH                 | LC                   | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                  | NM                 | SL                   | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 10                  | 6                  | 11                   | 10                |       |       |       |       |       |
| Power Setting         | IP       | 8.0               | 6.0                 | 5.0                | 3.0                  | 2.5               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                  | 10                 | -                    | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 6                   | 6                  | 8                    | 8                 |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                   | 2                  | 2                    | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 8                 | 6                   | 6                  | 6                    | 6                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 60.0<br>(56 ~ 70) | 100.0<br>(90 ~ 110) | 90.0<br>(80 ~ 100) | 125.0<br>(115 ~ 135) | 86.0<br>(76 ~ 96) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                  | 12                 | 12                   | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 7                 | 7                   | 7                  | 7                    | 7                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                  | 13                 | 13                   | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                  | NM                 | NM                   | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                   | 4                  | 4                    | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                  | 10                 | 10                   | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 808                 | 808                | 808                  | 808               |       |       |       |       |       |
| SL Control            | P        | -                 | -                   | -                  | 220                  | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                   | -                  | 110                  | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                  | ON                 | ON                   | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.9               | 2.0                 | 2.0                | 6.0                  | 6.2               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 291.0             | 201.0               | 171.0              | 140.0                | 128.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 90.0                | 30.0               | 31.0                 | 12.0              |       |       |       |       |       |

| RESULTS             |    |           |           |           |           |             |  |  |  |  |  |
|---------------------|----|-----------|-----------|-----------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 0.4 ~ 1.0 | 2.4 ~ 4.8 | 2.0 ~ 3.6 | 6.0 ~ 6.4 | 6.2 ~ 6.4   |  |  |  |  |  |
| Average Voltage Gap | V  | 52 ~ 72   | 90 ~ 115  | 82 ~ 98   | 134 ~ 144 | 95 ~ 110    |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -         | -         | -         | 4.5 ~ 5.0   |  |  |  |  |  |
|                     | Ra | -         | -         | -         | -         | 0.63 ~ 0.68 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.25<br>(Megacut Type-T) | STEEL         | 40mm               | A=20        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1               | Skim2              | Skim3                | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|---------------------|--------------------|----------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16371             | 16372               | 16373              | 16374                | 16375             |       |       |       |       |       |
| Taper Angle           | A        | 20                | 20                  | 20                 | 20                   | 20                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                  | RH                 | LC                   | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                  | NM                 | SL                   | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 10                  | 6                  | 11                   | 10                |       |       |       |       |       |
| Power Setting         | IP       | 8.0               | 6.0                 | 5.0                | 3.0                  | 2.5               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                  | 10                 | -                    | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 6                   | 6                  | 8                    | 8                 |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                   | 2                  | 2                    | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 8                 | 6                   | 6                  | 6                    | 6                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                   | 1                  | 1                    | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 60.0<br>(56 ~ 70) | 100.0<br>(90 ~ 110) | 90.0<br>(80 ~ 100) | 125.0<br>(115 ~ 135) | 86.0<br>(76 ~ 96) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF                 | OFF                | OFF                  | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                  | 12                 | 12                   | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 7                 | 7                   | 7                  | 7                    | 7                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                  | 13                 | 13                   | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                  | NM                 | NM                   | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                   | 4                  | 4                    | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                  | 10                 | 10                   | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 808                 | 808                | 808                  | 808               |       |       |       |       |       |
| SL Control            | P        | -                 | -                   | -                  | 220                  | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                   | -                  | 110                  | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                  | ON                 | ON                   | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.9               | 2.0                 | 2.0                | 6.0                  | 6.2               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0                 | 1.0                | 1.0                  | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 288.0             | 198.0               | 168.0              | 137.0                | 125.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 90.0                | 30.0               | 31.0                 | 12.0              |       |       |       |       |       |

| RESULTS             |    |           |           |           |           |             |  |  |  |  |  |
|---------------------|----|-----------|-----------|-----------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 0.4 ~ 1.0 | 2.2 ~ 4.6 | 2.0 ~ 3.6 | 6.0 ~ 6.4 | 6.2 ~ 6.4   |  |  |  |  |  |
| Average Voltage Gap | V  | 48 ~ 72   | 90 ~ 115  | 82 ~ 98   | 132 ~ 144 | 90 ~ 100    |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -         | -         | -         | 4.5 ~ 5.0   |  |  |  |  |  |
|                     | Ra | -         | -         | -         | -         | 0.63 ~ 0.68 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.25<br>(Megacut Type-T) | STEEL         | 40mm               | A=30        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1             | Skim2             | Skim3                | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|-------------------|-------------------|----------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16321             | 16322             | 16323             | 16324                | 16325             |       |       |       |       |       |
| Taper Angle           | A        | 30                | 30                | 30                | 30                   | 30                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                | RH                | LC                   | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                | NM                | SL                   | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 10                | 6                 | 11                   | 9                 |       |       |       |       |       |
| Power Setting         | IP       | 8.0               | 6.0               | 5.0               | 3.0                  | 3.0               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                | 10                | -                    | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 6                 | 6                 | 8                    | 8                 |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                 | 2                 | 2                    | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 10                | 6                 | 6                 | 6                    | 6                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                 | 1                 | 1                    | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                 | 1                 | 1                    | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 50.0<br>(47 ~ 53) | 76.0<br>(73 ~ 79) | 75.0<br>(72 ~ 78) | 115.0<br>(112 ~ 118) | 86.0<br>(83 ~ 89) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF               | OFF               | OFF                  | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF               | OFF               | OFF                  | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                | 12                | 12                   | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 7                 | 7                 | 7                 | 7                    | 7                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                | 13                | 13                   | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                | NM                | NM                   | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                 | 4                 | 4                    | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                | 10                | 10                   | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 808               | 808               | 808                  | 808               |       |       |       |       |       |
| SL Control            | P        | -                 | -                 | -                 | 220                  | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                 | -                 | 110                  | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                | ON                | ON                   | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.7               | 2.8               | 3.5               | 6.0                  | 6.2               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0                  | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0                  | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 315.0             | 215.0             | 192.0             | 167.0                | 159.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 100.0             | 23.0              | 25.0                 | 8.0               |       |       |       |       |       |

| RESULTS             |    |           |           |           |           |             |  |  |  |  |  |
|---------------------|----|-----------|-----------|-----------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 0.4 ~ 1.2 | 5.5 ~ 6.4 | 5.5 ~ 7.2 | 6.1 ~ 6.2 | 6.3 ~ 6.4   |  |  |  |  |  |
| Average Voltage Gap | V  | 44 ~ 55   | 71 ~ 86   | 69 ~ 79   | 127 ~ 134 | 101 ~ 105   |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -         | -         | -         | 4.0 ~ 4.5   |  |  |  |  |  |
|                     | Ra | -         | -         | -         | -         | 0.58 ~ 0.63 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



## MV2400R Machning Data Sheet

| Wire Dia. and Type        | Material Type | Material Thickness | Taper Angle | Flush cup clearance (Upper) | Flush cup clearance (Lower) |
|---------------------------|---------------|--------------------|-------------|-----------------------------|-----------------------------|
| φ0.25<br>(Megacut Type-T) | STEEL         | 40mm               | A=45        | 0.20mm                      | 0.20mm                      |

| Cutting Process       | Start Up | Rough Cut         | Skim1             | Skim2             | Skim3                | Skim4             | Skim5 | Skim6 | Skim7 | Skim8 | Skim9 |
|-----------------------|----------|-------------------|-------------------|-------------------|----------------------|-------------------|-------|-------|-------|-------|-------|
| E-pack Number         | Eno      | 16331             | 16332             | 16333             | 16334                | 16335             |       |       |       |       |       |
| Taper Angle           | A        | 45                | 45                | 45                | 45                   | 45                |       |       |       |       |       |
| Power Supply          | PS       | RH                | RH                | RH                | LC                   | LC                |       |       |       |       |       |
| Servo                 | SV       | NM                | NM                | NM                | SL                   | SL                |       |       |       |       |       |
| Voltage Open          | Vo       | 4                 | 10                | 6                 | 11                   | 9                 |       |       |       |       |       |
| Power Setting         | IP       | 8.0               | 6.0               | 5.0               | 3.0                  | 3.0               |       |       |       |       |       |
| IP adjust             | ΔIP      | 12                | 10                | 10                | -                    | -                 |       |       |       |       |       |
| Off Time              | OFF      | 6                 | 6                 | 6                 | 8                    | 8                 |       |       |       |       |       |
| Stabilizer A          | SA       | 2                 | 3                 | 2                 | 2                    | 1                 |       |       |       |       |       |
| Stabilizer B          | SB       | 10                | 6                 | 6                 | 6                    | 6                 |       |       |       |       |       |
| Stabilizer C          | SC       | 3                 | 1                 | 1                 | 1                    | 1                 |       |       |       |       |       |
| Stabilizer E          | SE       | 5                 | 1                 | 1                 | 1                    | 1                 |       |       |       |       |       |
| Voltage Gap           | VG       | 64.0<br>(61 ~ 67) | 78.0<br>(75 ~ 81) | 75.0<br>(72 ~ 78) | 108.0<br>(105 ~ 111) | 80.0<br>(77 ~ 83) |       |       |       |       |       |
| Fine machining        | FM       | OFF               | OFF               | OFF               | OFF                  | OFF               |       |       |       |       |       |
| Digital AE            | DAE      | OFF               | OFF               | OFF               | OFF                  | OFF               |       |       |       |       |       |
| Wire Speed            | WS       | 12                | 12                | 12                | 12                   | 12                |       |       |       |       |       |
| Wire Tension          | WT       | 7                 | 7                 | 7                 | 7                    | 7                 |       |       |       |       |       |
| Pre-Tension           | PT       | 13                | 13                | 13                | 13                   | 13                |       |       |       |       |       |
| Flow Balance          | FB       | NM                | NM                | NM                | NM                   | NM                |       |       |       |       |       |
| Liquid Quantity       | LQ       | 14                | 4                 | 4                 | 4                    | 4                 |       |       |       |       |       |
| Liquid Resistivity    | LR       | 10                | 10                | 10                | 10                   | 10                |       |       |       |       |       |
| CM-S(Infometer)       | I        | -                 | 808               | 808               | 808                  | 808               |       |       |       |       |       |
| SL Control            | P        | -                 | -                 | -                 | 220                  | 220               |       |       |       |       |       |
| SL Adjustment         | SLA      | -                 | -                 | -                 | 110                  | 110               |       |       |       |       |       |
| Optimum Feed (ON/OFF) |          | ON                | ON                | ON                | ON                   | ON                |       |       |       |       |       |
| Feedrate Address      | FA       | 0.7               | 2.8               | 3.0               | 6.0                  | 6.0               |       |       |       |       |       |
| Upper Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0                  | 1.0               |       |       |       |       |       |
| Lower Flow Rate       |          | 6.0               | 1.0               | 1.0               | 1.0                  | 1.0               |       |       |       |       |       |
| Offset Value(s) (u m) | -----    | 309.0             | 209.0             | 186.0             | 161.0                | 150.0             |       |       |       |       |       |
| Stepping Increment    | -----    | -----             | 100.0             | 23.0              | 25.0                 | 11.0              |       |       |       |       |       |

| RESULTS             |    |           |           |           |           |             |  |  |  |  |  |
|---------------------|----|-----------|-----------|-----------|-----------|-------------|--|--|--|--|--|
| Feedrate Cutting    | FC | 0.2 ~ 0.8 | 6.0 ~ 7.2 | 6.0 ~ 6.5 | 6.3 ~ 6.4 | 6.4 ~ 6.4   |  |  |  |  |  |
| Average Voltage Gap | V  | 64 ~ 75   | 76 ~ 92   | 76 ~ 83   | 137 ~ 142 | 115 ~ 122   |  |  |  |  |  |
| Surface Finish(u m) | Rz | -         | -         | -         | -         | 4.0 ~ 4.5   |  |  |  |  |  |
|                     | Ra | -         | -         | -         | -         | 0.58 ~ 0.63 |  |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.  
(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**5-10 ø0.07 Wire**  
**Machining Characteristics Data**

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.07SP            | STEEL         | STD   |

Thickness 5 mm

| No.               | Cutting process |    |     | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 921             | RL | 0.5 |        |      |       |       |       |     |     |     |           |
| 1                 | 4211            | RL | 1.7 | 40.0   | 87.0 | 108.0 | 114.0 | 124.0 |     |     |     | 0.0       |
| 2                 | 4212            | HL | 4.5 | -      | 42.0 | 63.0  | 69.0  | 79.0  |     |     |     | 45.0      |
| 3                 | 4213            | HL | 4.0 | -      | -    | 38.0  | 44.0  | 54.0  |     |     |     | 25.0      |
| 4                 | 4214            | LC | 6.0 | -      | -    | -     | 38.0  | 48.0  |     |     |     | 6.0       |
| 5                 | 4215            | LC | 6.0 | -      | -    | -     | -     | 44.0  |     |     |     | 4.0       |
| 6                 |                 |    |     | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 921             | RL | 0.5 |        |      |       |       |       |     |     |     |           |
| 1                 | 4221            | RL | 1.5 | 42.0   | 82.0 | 103.0 | 114.0 | 117.0 |     |     |     | 0.0       |
| 2                 | 4222            | HL | 4.0 | -      | 42.0 | 63.0  | 74.0  | 77.0  |     |     |     | 40.0      |
| 3                 | 4223            | HL | 3.5 | -      | -    | 38.0  | 49.0  | 52.0  |     |     |     | 25.0      |
| 4                 | 4224            | LC | 6.0 | -      | -    | -     | 43.0  | 46.0  |     |     |     | 6.0       |
| 5                 | 4225            | LC | 6.0 | -      | -    | -     | -     | 42.0  |     |     |     | 4.0       |
| 6                 |                 |    |     | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 921             | RL | 0.5 |        |      |       |       |       |     |     |     |           |
| 1                 | 4231            | RL | 1.2 | 45.0   | 85.0 | 103.0 | 116.0 | 118.0 |     |     |     | 0.0       |
| 2                 | 4232            | HL | 3.5 | -      | 45.0 | 63.0  | 76.0  | 78.0  |     |     |     | 40.0      |
| 3                 | 4233            | HL | 3.0 | -      | -    | 38.0  | 51.0  | 53.0  |     |     |     | 25.0      |
| 4                 | 4234            | LC | 6.0 | -      | -    | -     | 45.0  | 47.0  |     |     |     | 6.0       |
| 5                 | 4235            | LC | 6.0 | -      | -    | -     | -     | 43.0  |     |     |     | 4.0       |
| 6                 |                 |    |     | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.07SP           | STEEL         | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 921                   | 4211                  | 4212                  | 4213                  | 4214                  | 4215                  |       |       |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 5                     | 5                     | 6                     | 6                     |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 5.0                   | 1.5                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 16                    | 16                    | 12                    | 12                    |                       |                       |       |       |       |
| Off Time           | OFF | 9                     | 9                     | 14                    | 15                    | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 10                    | 9                     | 14                    | 15                    | 10                    | 10                    |       |       |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     |       |       |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     |       |       |       |
| Pre-Tension        | PT  | 11                    | 11                    | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 12                    | 13                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 1.7                   | 4.5                   | 4.0                   | 6.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 87.0  | 42.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 108.0 | 63.0  | 38.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 114.0 | 69.0  | 44.0  | 38.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 124.0 | 79.0  | 54.0  | 48.0  | 44.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 45.0  | 25.0  | 6.0   | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 1.6 ~ 2.0   | 2.6 ~ 3.2   | 7.4 ~ 9.0   | 6.0 ~ 6.7   | 6.0 ~ 6.7   |  |  |
| Average Voltage Gap  | V   |  | 39 ~ 63     | 63 ~ 80     | 34 ~ 48     | 120 ~ 132   | 118 ~ 129   |  |  |
| Avg. Linear Feedrate | ALF |  | 108.0       | 66.6        | 58.7        | 50.9        | 44.9        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.07SP           | STEEL         | 10mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 921                   | 4221                  | 4222                  | 4223                  | 4224                  | 4225                  |       |       |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 5                     | 5                     | 6                     | 6                     |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 5.0                   | 1.5                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 16                    | 16                    | 12                    | 12                    |                       |                       |       |       |       |
| Off Time           | OFF | 9                     | 8                     | 14                    | 15                    | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 10                    | 8                     | 14                    | 15                    | 10                    | 10                    |       |       |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     |       |       |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     |       |       |       |
| Pre-Tension        | PT  | 11                    | 11                    | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 12                    | 13                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 1.5                   | 4.0                   | 3.5                   | 6.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 42.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 82.0  | 42.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 103.0 | 63.0  | 38.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 114.0 | 74.0  | 49.0  | 43.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 117.0 | 77.0  | 52.0  | 46.0  | 42.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 25.0  | 6.0   | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.0   | 1.4 ~ 1.7   | 4.7 ~ 5.8   | 6.0 ~ 6.7   | 6.0 ~ 6.7   |  |  |
| Average Voltage Gap  | V   |  | 30 ~ 52     | 61 ~ 80     | 29 ~ 43     | 84 ~ 96     | 75 ~ 86     |  |  |
| Avg. Linear Feedrate | ALF |  | 54.0        | 34.2        | 30.8        | 28.5        | 26.5        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.07SP           | STEEL         | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 921                   | 4231                  | 4232                  | 4233                  | 4234                  | 4235                  |       |       |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 5                     | 5                     | 6                     | 6                     |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 5.0                   | 1.5                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 16                    | 16                    | 12                    | 12                    |                       |                       |       |       |       |
| Off Time           | OFF | 9                     | 8                     | 14                    | 15                    | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 10                    | 8                     | 14                    | 15                    | 10                    | 10                    |       |       |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 30.0<br>(28.0 ~ 32.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     |       |       |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     |       |       |       |
| Pre-Tension        | PT  | 11                    | 11                    | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 12                    | 13                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 1.2                   | 3.5                   | 3.0                   | 6.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 45.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 85.0  | 45.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 103.0 | 63.0  | 38.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 116.0 | 76.0  | 51.0  | 45.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 118.0 | 78.0  | 53.0  | 47.0  | 43.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 25.0  | 6.0   | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.3 ~ 0.5   | 0.7 ~ 1.0   | 2.7 ~ 3.5   | 6.0 ~ 6.7   | 6.0 ~ 6.7   |  |  |
| Average Voltage Gap  | V   |  | 28 ~ 38     | 61 ~ 78     | 27 ~ 42     | 54 ~ 66     | 54 ~ 66     |  |  |
| Avg. Linear Feedrate | ALF |  | 24.0        | 16.3        | 15.0        | 14.4        | 13.9        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.07SP            | WC-Co         | STD   |

Thickness 5 mm

| No.               | Cutting process |    |     | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 921             | RL | 0.5 |        |      |       |       |       |     |     |     |           |
| 1                 | 4311            | RL | 0.8 | 40.0   | 85.0 | 108.0 | 117.0 | 120.0 |     |     |     | 0.0       |
| 2                 | 4312            | HL | 1.5 | -      | 40.0 | 63.0  | 72.0  | 75.0  |     |     |     | 45.0      |
| 3                 | 4313            | HL | 2.5 | -      | -    | 38.0  | 47.0  | 50.0  |     |     |     | 25.0      |
| 4                 | 4314            | LC | 5.0 | -      | -    | -     | 41.0  | 44.0  |     |     |     | 6.0       |
| 5                 | 4315            | LC | 5.0 | -      | -    | -     | -     | 40.0  |     |     |     | 4.0       |
| 6                 |                 |    |     | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 921             | RL | 0.5 |        |      |       |       |       |     |     |     |           |
| 1                 | 4321            | RL | 0.5 | 40.0   | 80.0 | 103.0 | 112.0 | 115.0 |     |     |     | 0.0       |
| 2                 | 4322            | HL | 1.0 | -      | 40.0 | 63.0  | 72.0  | 75.0  |     |     |     | 40.0      |
| 3                 | 4323            | HL | 2.0 | -      | -    | 38.0  | 47.0  | 50.0  |     |     |     | 25.0      |
| 4                 | 4324            | LC | 5.0 | -      | -    | -     | 41.0  | 44.0  |     |     |     | 6.0       |
| 5                 | 4325            | LC | 5.0 | -      | -    | -     | -     | 40.0  |     |     |     | 4.0       |
| 6                 |                 |    |     | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |      |       |       |       |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|-------|-------|-------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th | 7th | 8th | Increment |
| A                 | 921             | RL | 0.5 |        |      |       |       |       |     |     |     |           |
| 1                 | 4331            | RL | 0.3 | 40.0   | 80.0 | 104.0 | 114.0 | 116.0 |     |     |     | 0.0       |
| 2                 | 4332            | HL | 1.0 | -      | 40.0 | 64.0  | 74.0  | 76.0  |     |     |     | 40.0      |
| 3                 | 4333            | HL | 2.0 | -      | -    | 39.0  | 49.0  | 51.0  |     |     |     | 25.0      |
| 4                 | 4334            | LC | 5.0 | -      | -    | -     | 43.0  | 45.0  |     |     |     | 6.0       |
| 5                 | 4335            | LC | 5.0 | -      | -    | -     | -     | 41.0  |     |     |     | 4.0       |
| 6                 |                 |    |     | -      | -    | -     | -     | -     |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -     | -     | -     | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -     | -     | -     | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.07SP           | WC-Co         | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 921                   | 4311                  | 4312                  | 4313                  | 4314                  | 4315                  |       |       |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 5                     | 5                     | 6                     | 6                     |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 5.0                   | 1.5                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 16                    | 16                    | 12                    | 12                    |                       |                       |       |       |       |
| Off Time           | OFF | 9                     | 12                    | 13                    | 14                    | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 10                    | 12                    | 13                    | 14                    | 10                    | 10                    |       |       |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 65.0<br>(62.0 ~ 68.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     |       |       |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     |       |       |       |
| Pre-Tension        | PT  | 11                    | 11                    | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 12                    | 13                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.8                   | 1.5                   | 2.5                   | 5.0                   | 5.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 85.0  | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 108.0 | 63.0  | 38.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 117.0 | 72.0  | 47.0  | 41.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 120.0 | 75.0  | 50.0  | 44.0  | 40.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 45.0  | 25.0  | 6.0   | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.5 ~ 0.9   | 1.5 ~ 1.8   | 4.4 ~ 5.3   | 5.0 ~ 5.7   | 5.0 ~ 5.7   |  |  |
| Average Voltage Gap  | V   |  | 51 ~ 79     | 62 ~ 82     | 28 ~ 43     | 82 ~ 95     | 75 ~ 87     |  |  |
| Avg. Linear Feedrate | ALF |  | 42.0        | 29.5        | 26.8        | 24.7        | 22.9        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.07SP           | WC-Co         | 10mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 921                   | 4321                  | 4322                  | 4323                  | 4324                  | 4325                  |       |       |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 5                     | 5                     | 6                     | 6                     |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 5.0                   | 1.5                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 16                    | 16                    | 12                    | 12                    |                       |                       |       |       |       |
| Off Time           | OFF | 9                     | 12                    | 14                    | 15                    | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 10                    | 12                    | 14                    | 15                    | 10                    | 10                    |       |       |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(57.0 ~ 63.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     |       |       |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     |       |       |       |
| Pre-Tension        | PT  | 11                    | 11                    | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 12                    | 13                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.5                   | 1.0                   | 2.0                   | 5.0                   | 5.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 80.0  | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 103.0 | 63.0  | 38.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 112.0 | 72.0  | 47.0  | 41.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 115.0 | 75.0  | 50.0  | 44.0  | 40.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 25.0  | 6.0   | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.2 ~ 0.4   | 0.7 ~ 1.0   | 1.8 ~ 2.5   | 5.0 ~ 5.7   | 5.0 ~ 5.7   |  |  |
| Average Voltage Gap  | V   |  | 53 ~ 67     | 63 ~ 77     | 28 ~ 42     | 66 ~ 82     | 60 ~ 72     |  |  |
| Avg. Linear Feedrate | ALF |  | 18.0        | 13.3        | 12.1        | 11.6        | 11.2        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.07SP           | WC-Co         | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 921                   | 4331                  | 4332                  | 4333                  | 4334                  | 4335                  |       |       |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 5                     | 5                     | 6                     | 6                     |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 5.0                   | 1.5                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 16                    | 16                    | 12                    | 12                    |                       |                       |       |       |       |
| Off Time           | OFF | 9                     | 12                    | 14                    | 15                    | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 10                    | 12                    | 14                    | 15                    | 10                    | 10                    |       |       |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(57.0 ~ 63.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 35.0<br>(33.0 ~ 37.0) | 35.0<br>(33.0 ~ 37.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     |       |       |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     |       |       |       |
| Pre-Tension        | PT  | 11                    | 11                    | 12                    | 12                    | 12                    | 12                    |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 12                    | 13                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.3                   | 1.0                   | 2.0                   | 5.0                   | 5.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 80.0  | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 104.0 | 64.0  | 39.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 114.0 | 74.0  | 49.0  | 43.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 116.0 | 76.0  | 51.0  | 45.0  | 41.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 25.0  | 6.0   | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.1 ~ 0.2   | 0.5 ~ 0.8   | 1.0 ~ 1.5   | 5.0 ~ 5.7   | 5.0 ~ 5.7   |  |  |
| Average Voltage Gap  | V   |  | 52 ~ 70     | 65 ~ 76     | 28 ~ 44     | 45 ~ 57     | 42 ~ 54     |  |  |
| Avg. Linear Feedrate | ALF |  | 9.0         | 7.3         | 6.7         | 6.5         | 6.4         |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**5-11 ø0.05 Wire**  
**Machining Characteristics Data**

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.05SP            | STEEL         | STD   |

Thickness 5 mm

| No.               | Cutting process |    |     | Offset |      |      |      |      |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|------|------|------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd  | 4th  | 5th  | 6th | 7th | 8th | Increment |
| A                 | 911             | RL | 0.5 |        |      |      |      |      |     |     |     |           |
| 1                 | 4411            | RL | 0.8 | 32.0   | 39.0 | 49.0 | 59.0 | 64.0 |     |     |     | 0.0       |
| 2                 | 4412            | HL | 4.0 | -      | 32.0 | 42.0 | 52.0 | 57.0 |     |     |     | 7.0       |
| 3                 | 4413            | HL | 4.0 | -      | -    | 28.0 | 38.0 | 43.0 |     |     |     | 14.0      |
| 4                 | 4414            | LC | 6.0 | -      | -    | -    | 28.0 | 33.0 |     |     |     | 10.0      |
| 5                 | 4415            | LC | 6.0 | -      | -    | -    | -    | 29.0 |     |     |     | 4.0       |
| 6                 |                 |    |     | -      | -    | -    | -    | -    |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -    | -    | -    | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -    | -    | -    | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0 | 3.5  | 2.0  |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50 | 0.48 | 0.28 |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |      |      |      |      |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|------|------|------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd  | 4th  | 5th  | 6th | 7th | 8th | Increment |
| A                 | 911             | RL | 0.5 |        |      |      |      |      |     |     |     |           |
| 1                 | 4421            | RL | 0.5 | 35.0   | 42.0 | 49.0 | 60.0 | 63.0 |     |     |     | 0.0       |
| 2                 | 4422            | HL | 3.5 | -      | 35.0 | 42.0 | 53.0 | 56.0 |     |     |     | 7.0       |
| 3                 | 4423            | HL | 3.5 | -      | -    | 28.0 | 39.0 | 42.0 |     |     |     | 14.0      |
| 4                 | 4424            | LC | 6.0 | -      | -    | -    | 32.0 | 35.0 |     |     |     | 7.0       |
| 5                 | 4425            | LC | 6.0 | -      | -    | -    | -    | 31.0 |     |     |     | 4.0       |
| 6                 |                 |    |     | -      | -    | -    | -    | -    |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -    | -    | -    | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -    | -    | -    | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0 | 3.5  | 2.0  |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50 | 0.48 | 0.28 |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |      |      |      |      |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|------|------|------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd  | 4th  | 5th  | 6th | 7th | 8th | Increment |
| A                 | 911             | RL | 0.5 |        |      |      |      |      |     |     |     |           |
| 1                 | 4431            | RL | 0.3 | 38.0   | 46.0 | 50.0 | 59.0 | 62.0 |     |     |     | 0.0       |
| 2                 | 4432            | HL | 3.5 | -      | 39.0 | 43.0 | 52.0 | 55.0 |     |     |     | 7.0       |
| 3                 | 4433            | HL | 3.5 | -      | -    | 29.0 | 38.0 | 41.0 |     |     |     | 14.0      |
| 4                 | 4434            | LC | 6.0 | -      | -    | -    | 31.0 | 34.0 |     |     |     | 7.0       |
| 5                 | 4435            | LC | 6.0 | -      | -    | -    | -    | 30.0 |     |     |     | 4.0       |
| 6                 |                 |    |     | -      | -    | -    | -    | -    |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -    | -    | -    | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -    | -    | -    | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0 | 3.5  | 2.0  |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50 | 0.48 | 0.28 |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.05SP           | STEEL         | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 911                   | 4411                  | 4412                  | 4413                  | 4414                  | 4415                  |       |       |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 4                     | 4                     | 2                     | 2                     | 6                     | 6                     |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 1.5                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 16                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 12                    | 11                    | 14                    | 15                    | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 11                    | 14                    | 15                    | 10                    | 10                    |       |       |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 45.0<br>(42.0 ~ 48.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 55.0<br>(53.0 ~ 57.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     |       |       |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     |       |       |       |
| Pre-Tension        | PT  | 7                     | 7                     | 8                     | 8                     | 8                     | 8                     |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.8                   | 4.0                   | 4.0                   | 6.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 32.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 39.0  | 32.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 49.0  | 42.0  | 28.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 59.0  | 52.0  | 38.0  | 28.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 64.0  | 57.0  | 43.0  | 33.0  | 29.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 7.0   | 14.0  | 10.0  | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.1   | 7.4 ~ 9.0   | 7.4 ~ 9.0   | 6.0 ~ 6.7   | 6.0 ~ 6.7   |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 53     | 62 ~ 85     | 26 ~ 43     | 78 ~ 90     | 77 ~ 89     |  |  |
| Avg. Linear Feedrate | ALF |  | 57.0        | 51.1        | 46.3        | 41.3        | 37.2        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.05SP           | STEEL         | 10mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 911                   | 4421                  | 4422                  | 4423                  | 4424                  | 4425                  |       |       |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 4                     | 4                     | 2                     | 2                     | 6                     | 6                     |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 1.5                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 16                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 12                    | 12                    | 14                    | 15                    | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 12                    | 14                    | 15                    | 10                    | 10                    |       |       |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 55.0<br>(53.0 ~ 57.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     |       |       |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     |       |       |       |
| Pre-Tension        | PT  | 7                     | 7                     | 8                     | 8                     | 8                     | 8                     |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.5                   | 3.5                   | 3.5                   | 6.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 35.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 42.0  | 35.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 49.0  | 42.0  | 28.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 60.0  | 53.0  | 39.0  | 32.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 63.0  | 56.0  | 42.0  | 35.0  | 31.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 7.0   | 14.0  | 7.0   | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.4 ~ 0.6   | 4.9 ~ 6.0   | 4.5 ~ 5.5   | 6.0 ~ 6.7   | 6.0 ~ 6.7   |  |  |
| Average Voltage Gap  | V   |  | 27 ~ 50     | 62 ~ 78     | 28 ~ 42     | 67 ~ 80     | 68 ~ 81     |  |  |
| Avg. Linear Feedrate | ALF |  | 30.0        | 27.5        | 25.2        | 23.6        | 22.2        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.05SP           | STEEL         | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 911                   | 4431                  | 4432                  | 4433                  | 4434                  | 4435                  |       |       |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 4                     | 4                     | 2                     | 2                     | 6                     | 6                     |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 1.5                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 16                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 12                    | 12                    | 14                    | 15                    | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 12                    | 14                    | 15                    | 10                    | 10                    |       |       |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 30.0<br>(28.0 ~ 32.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     |       |       |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     |       |       |       |
| Pre-Tension        | PT  | 7                     | 7                     | 8                     | 8                     | 8                     | 8                     |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.3                   | 3.5                   | 3.5                   | 6.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 38.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 46.0  | 39.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 50.0  | 43.0  | 29.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 59.0  | 52.0  | 38.0  | 31.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 62.0  | 55.0  | 41.0  | 34.0  | 30.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 7.0   | 14.0  | 7.0   | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.2 ~ 0.4   | 2.6 ~ 3.2   | 2.9 ~ 3.5   | 6.0 ~ 6.7   | 6.0 ~ 6.7   |  |  |
| Average Voltage Gap  | V   |  | 29 ~ 51     | 63 ~ 78     | 28 ~ 42     | 27 ~ 44     | 42 ~ 54     |  |  |
| Avg. Linear Feedrate | ALF |  | 18.0        | 16.3        | 15.0        | 14.5        | 13.9        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.05SP            | WC-Co         | STD   |

Thickness 5 mm

| No.               | Cutting process |    |     | Offset |      |      |      |      |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|------|------|------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd  | 4th  | 5th  | 6th | 7th | 8th | Increment |
| A                 | 911             | RL | 0.5 |        |      |      |      |      |     |     |     |           |
| 1                 | 4511            | RL | 0.5 | 32.0   | 42.0 | 52.0 | 60.0 | 64.0 |     |     |     | 0.0       |
| 2                 | 4512            | HL | 1.5 | -      | 33.0 | 43.0 | 51.0 | 55.0 |     |     |     | 9.0       |
| 3                 | 4513            | HL | 3.0 | -      | -    | 29.0 | 37.0 | 41.0 |     |     |     | 14.0      |
| 4                 | 4514            | LC | 6.0 | -      | -    | -    | 30.0 | 34.0 |     |     |     | 7.0       |
| 5                 | 4515            | LC | 6.0 | -      | -    | -    | -    | 30.0 |     |     |     | 4.0       |
| 6                 |                 |    |     | -      | -    | -    | -    | -    |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -    | -    | -    | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -    | -    | -    | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0 | 3.5  | 2.0  |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50 | 0.48 | 0.28 |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |      |      |      |      |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|------|------|------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd  | 4th  | 5th  | 6th | 7th | 8th | Increment |
| A                 | 911             | RL | 0.5 |        |      |      |      |      |     |     |     |           |
| 1                 | 4521            | RL | 0.4 | 32.0   | 45.0 | 50.0 | 55.0 | 60.0 |     |     |     | 0.0       |
| 2                 | 4522            | HL | 1.5 | -      | 40.0 | 45.0 | 50.0 | 55.0 |     |     |     | 5.0       |
| 3                 | 4523            | HL | 3.0 | -      | -    | 31.0 | 36.0 | 41.0 |     |     |     | 14.0      |
| 4                 | 4524            | LC | 6.0 | -      | -    | -    | 29.0 | 34.0 |     |     |     | 7.0       |
| 5                 | 4525            | LC | 6.0 | -      | -    | -    | -    | 30.0 |     |     |     | 4.0       |
| 6                 |                 |    |     | -      | -    | -    | -    | -    |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -    | -    | -    | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -    | -    | -    | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0 | 3.5  | 2.0  |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50 | 0.48 | 0.28 |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |      |      |      |      |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|------|------|------|------|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd  | 3rd  | 4th  | 5th  | 6th | 7th | 8th | Increment |
| A                 | 911             | RL | 0.5 |        |      |      |      |      |     |     |     |           |
| 1                 | 4531            | RL | 0.3 | 32.0   | 50.0 | 52.0 | 58.0 | 60.0 |     |     |     | 0.0       |
| 2                 | 4532            | HL | 1.0 | -      | 45.0 | 47.0 | 53.0 | 55.0 |     |     |     | 5.0       |
| 3                 | 4533            | HL | 2.5 | -      | -    | 33.0 | 39.0 | 41.0 |     |     |     | 14.0      |
| 4                 | 4534            | LC | 6.0 | -      | -    | -    | 32.0 | 34.0 |     |     |     | 7.0       |
| 5                 | 4535            | LC | 6.0 | -      | -    | -    | -    | 30.0 |     |     |     | 4.0       |
| 6                 |                 |    |     | -      | -    | -    | -    | -    |     |     |     |           |
| 7                 |                 |    |     | -      | -    | -    | -    | -    | -   |     |     |           |
| 8                 |                 |    |     | -      | -    | -    | -    | -    | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 15.0   | 14.0 | 11.0 | 3.5  | 2.0  |     |     |     |           |
|                   |                 |    | Ra  | 2.50   | 2.00 | 1.50 | 0.48 | 0.28 |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.05SP           | WC-Co         | 5mm                | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 911                   | 4511                  | 4512                  | 4513                  | 4514                  | 4515                  |       |       |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 4                     | 4                     | 2                     | 2                     | 6                     | 6                     |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 1.5                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 16                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 12                    | 12                    | 14                    | 15                    | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 12                    | 14                    | 15                    | 10                    | 10                    |       |       |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 88.0<br>(86.0 ~ 90.0) | 50.0<br>(48.0 ~ 52.0) | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 7                     | 7                     | 7                     | 9                     | 9                     | 9                     |       |       |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     |       |       |       |
| Pre-Tension        | PT  | 7                     | 7                     | 8                     | 8                     | 8                     | 8                     |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.5                   | 1.5                   | 3.0                   | 6.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 32.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 42.0  | 33.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 52.0  | 43.0  | 29.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 60.0  | 51.0  | 37.0  | 30.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 64.0  | 55.0  | 41.0  | 34.0  | 30.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 9.0   | 14.0  | 7.0   | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.3 ~ 0.5   | 1.1 ~ 1.4   | 2.8 ~ 3.5   | 6.0 ~ 6.7   | 6.0 ~ 6.7   |  |  |
| Average Voltage Gap  | V   |  | 43 ~ 66     | 81 ~ 95     | 48 ~ 52     | 77 ~ 90     | 71 ~ 83     |  |  |
| Avg. Linear Feedrate | ALF |  | 24.0        | 18.2        | 16.6        | 15.9        | 15.3        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.05SP           | WC-Co         | 10mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 911                   | 4521                  | 4522                  | 4523                  | 4524                  | 4525                  |       |       |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 4                     | 4                     | 2                     | 2                     | 6                     | 6                     |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 1.5                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 16                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 12                    | 12                    | 14                    | 15                    | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 12                    | 14                    | 15                    | 10                    | 10                    |       |       |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 88.0<br>(86.0 ~ 90.0) | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(38.0 ~ 42.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 7                     | 7                     | 7                     | 9                     | 9                     | 9                     |       |       |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     |       |       |       |
| Pre-Tension        | PT  | 7                     | 7                     | 8                     | 8                     | 8                     | 8                     |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.4                   | 1.5                   | 3.0                   | 6.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 32.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 45.0  | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 50.0  | 45.0  | 31.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 55.0  | 50.0  | 36.0  | 29.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 60.0  | 55.0  | 41.0  | 34.0  | 30.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 5.0   | 14.0  | 7.0   | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.2 ~ 0.4   | 0.7 ~ 1.0   | 2.6 ~ 3.2   | 6.0 ~ 6.7   | 6.0 ~ 6.7   |  |  |
| Average Voltage Gap  | V   |  | 43 ~ 57     | 78 ~ 91     | 42 ~ 51     | 59 ~ 71     | 52 ~ 64     |  |  |
| Avg. Linear Feedrate | ALF |  | 18.0        | 13.3        | 12.4        | 12.0        | 11.6        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.05SP           | WC-Co         | 20mm               | STD     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 911                   | 4531                  | 4532                  | 4533                  | 4534                  | 4535                  |       |       |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    |       |       |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    |       |       |       |
| Voltage Open       | Vo  | 4                     | 4                     | 2                     | 2                     | 6                     | 6                     |       |       |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 1.5                   | 1.5                   |       |       |       |
| IP adjust          | ΔIP | 16                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 12                    | 12                    | 14                    | 15                    | 1                     | 1                     |       |       |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     |       |       |       |
| Stabilizer B       | SB  | 14                    | 12                    | 14                    | 15                    | 10                    | 10                    |       |       |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 88.0<br>(86.0 ~ 90.0) | 50.0<br>(48.0 ~ 52.0) | 25.0<br>(23.0 ~ 27.0) | 25.0<br>(23.0 ~ 27.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |
| Wire Speed         | WS  | 7                     | 7                     | 7                     | 9                     | 9                     | 9                     |       |       |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     |       |       |       |
| Pre-Tension        | PT  | 7                     | 7                     | 8                     | 8                     | 8                     | 8                     |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    |       |       |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.3                   | 1.0                   | 2.5                   | 6.0                   | 6.0                   |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 32.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 50.0  | 45.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 52.0  | 47.0  | 33.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 58.0  | 53.0  | 39.0  | 32.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 60.0  | 55.0  | 41.0  | 34.0  | 30.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 5.0   | 14.0  | 7.0   | 4.0   |       |       |       |

| RESULTS              |     |  |             |             |             |             |             |  |  |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|--|--|
| Feedrate Cutting     | FC  |  | 0.2 ~ 0.4   | 2.6 ~ 3.2   | 2.9 ~ 3.5   | 6.0 ~ 6.7   | 6.0 ~ 6.7   |  |  |
| Average Voltage Gap  | V   |  | 33 ~ 51     | 76 ~ 92     | 44 ~ 57     | 32 ~ 40     | 33 ~ 40     |  |  |
| Avg. Linear Feedrate | ALF |  | 18.0        | 16.3        | 15.0        | 14.5        | 13.9        |  |  |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   |  |  |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**5-12 Digital-FS**  
**Machining Characteristics Data**  
(\*Digital-FS is an option.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | DFS   |

Thickness 5 mm

| No.               | Cutting process |     |      | Offset |       |       |       |       |       |       |       |     |      | Step<br>Increment |
|-------------------|-----------------|-----|------|--------|-------|-------|-------|-------|-------|-------|-------|-----|------|-------------------|
|                   | E               | PS  | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th | 10th |                   |
| A                 | 941             | RH  | 2.0  |        |       |       |       |       |       |       |       |     |      |                   |
| 1                 | 10001           | RH  | 6.0  | 117.0  | 186.0 | 215.0 | 230.0 | 233.0 | 236.0 | 238.5 | 240.0 |     |      | 0.0               |
| 2                 | 10002           | RH  | 8.0  | -      | 111.0 | 140.0 | 155.0 | 158.0 | 161.0 | 163.5 | 165.0 |     |      | 75.0              |
| 3                 | 10003           | HL  | 8.0  | -      | -     | 105.0 | 120.0 | 123.0 | 126.0 | 128.5 | 130.0 |     |      | 35.0              |
| 4                 | 10004           | LC  | 12.0 | -      | -     | -     | 105.0 | 108.0 | 111.0 | 113.5 | 115.0 |     |      | 15.0              |
| 5                 | 10005           | LC  | 10.5 | -      | -     | -     | -     | 105.0 | 108.0 | 110.5 | 112.0 |     |      | 3.0               |
| 6                 | 10006           | LC  | 8.0  | -      | -     | -     | -     | -     | 105.0 | 107.5 | 109.0 |     |      | 3.0               |
| 7                 | 10007           | DFS | 8.0  | -      | -     | -     | -     | -     | -     | 105.0 | 106.5 |     |      | 2.5               |
| 8                 | 10008           | DFS | 8.0  | -      | -     | -     | -     | -     | -     | -     | 104.0 |     |      | 2.5               |
| 9                 |                 |     |      | -      | -     | -     | -     | -     | -     | -     | -     |     |      |                   |
| 10                |                 |     |      | -      | -     | -     | -     | -     | -     | -     | -     | -   |      |                   |
| Surface roughness |                 |     | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 1.5   | 1.2   |     |      |                   |
|                   |                 |     | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.18  | 0.15  |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |     |      | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|------|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 941             | RH  | 2.0  |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10011           | RH  | 4.0  | 119.0  | 177.0 | 209.0 | 224.0 | 228.0 | 230.0 | 233.0 | 236.0 | 236.5 |      | 0.0               |
| 2                 | 10012           | RH  | 8.0  | -      | 107.0 | 139.0 | 154.0 | 158.0 | 160.0 | 163.0 | 166.0 | 166.5 |      | 70.0              |
| 3                 | 10013           | HL  | 7.5  | -      | -     | 104.0 | 119.0 | 123.0 | 125.0 | 128.0 | 131.0 | 131.5 |      | 35.0              |
| 4                 | 10014           | LC  | 11.0 | -      | -     | -     | 105.0 | 109.0 | 111.0 | 114.0 | 117.0 | 117.5 |      | 14.0              |
| 5                 | 10015           | LC  | 10.0 | -      | -     | -     | -     | 106.0 | 108.0 | 111.0 | 114.0 | 114.5 |      | 3.0               |
| 6                 | 10016           | LC  | 7.5  | -      | -     | -     | -     | -     | 105.0 | 108.0 | 111.0 | 111.5 |      | 3.0               |
| 7                 | 10017           | DFS | 8.0  | -      | -     | -     | -     | -     | -     | 105.0 | 108.0 | 108.5 |      | 3.0               |
| 8                 | 10018           | DFS | 8.0  | -      | -     | -     | -     | -     | -     | -     | 106.0 | 106.5 |      | 2.0               |
| 9                 | 10019           | DFS | 4.0  | -      | -     | -     | -     | -     | -     | -     | -     | 105.0 |      | 1.5               |
| 10                |                 |     |      | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |     |      | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|------|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 941             | RH  | 2.0  |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10021           | RH  | 3.0  | 125.0  | 177.0 | 208.0 | 222.0 | 226.0 | 229.0 | 231.0 | 233.0 | 233.0 |      | 0.0               |
| 2                 | 10022           | RH  | 6.0  | -      | 107.0 | 138.0 | 152.0 | 156.0 | 159.0 | 161.0 | 163.0 | 163.0 |      | 70.0              |
| 3                 | 10023           | HL  | 7.0  | -      | -     | 103.0 | 117.0 | 121.0 | 124.0 | 126.0 | 128.0 | 128.0 |      | 35.0              |
| 4                 | 10024           | LC  | 10.5 | -      | -     | -     | 105.0 | 109.0 | 112.0 | 114.0 | 116.0 | 116.0 |      | 12.0              |
| 5                 | 10025           | LC  | 8.0  | -      | -     | -     | -     | 105.0 | 108.0 | 110.0 | 112.0 | 112.0 |      | 4.0               |
| 6                 | 10026           | LC  | 7.0  | -      | -     | -     | -     | -     | 105.0 | 107.0 | 109.0 | 109.0 |      | 3.0               |
| 7                 | 10027           | DFS | 8.0  | -      | -     | -     | -     | -     | -     | 105.0 | 107.0 | 107.0 |      | 2.0               |
| 8                 | 10028           | DFS | 8.0  | -      | -     | -     | -     | -     | -     | -     | 106.0 | 106.0 |      | 1.0               |
| 9                 | 10029           | DFS | 8.0  | -      | -     | -     | -     | -     | -     | -     | -     | 105.0 |      | 1.0               |
| 10                |                 |     |      | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | DFS   |

Thickness 30 mm

| No.               | Cutting process |     |      | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|------|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 942             | RH  | 1.0  |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10031           | RH  | 2.0  | 131.0  | 172.0 | 199.0 | 212.0 | 215.0 | 217.0 | 219.0 | 220.0 | 221.0 |      | 0.0               |
| 2                 | 10032           | RH  | 5.0  | -      | 107.0 | 134.0 | 147.0 | 150.0 | 152.0 | 154.0 | 155.0 | 156.0 |      | 65.0              |
| 3                 | 10033           | HL  | 6.0  | -      | -     | 104.0 | 117.0 | 120.0 | 122.0 | 124.0 | 125.0 | 126.0 |      | 30.0              |
| 4                 | 10034           | LC  | 10.5 | -      | -     | -     | 105.0 | 108.0 | 110.0 | 112.0 | 113.0 | 114.0 |      | 12.0              |
| 5                 | 10035           | LC  | 8.0  | -      | -     | -     | -     | 105.0 | 107.0 | 109.0 | 110.0 | 111.0 |      | 3.0               |
| 6                 | 10036           | LC  | 6.0  | -      | -     | -     | -     | -     | 105.0 | 107.0 | 108.0 | 109.0 |      | 2.0               |
| 7                 | 10037           | DFS | 6.0  | -      | -     | -     | -     | -     | -     | 105.0 | 106.0 | 107.0 |      | 2.0               |
| 8                 | 10038           | DFS | 6.0  | -      | -     | -     | -     | -     | -     | -     | 105.0 | 106.0 |      | 1.0               |
| 9                 | 10039           | DFS | 6.0  | -      | -     | -     | -     | -     | -     | -     | -     | 105.0 |      | 1.0               |
| 10                |                 |     |      | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |     |      | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|------|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA   | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 942             | RH  | 1.0  |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10041           | RH  | 2.0  | 133.0  | 168.0 | 190.0 | 203.0 | 206.0 | 208.0 | 209.0 | 211.5 | 212.5 |      | 0.0               |
| 2                 | 10042           | RH  | 5.0  | -      | 108.0 | 130.0 | 143.0 | 146.0 | 148.0 | 149.0 | 151.5 | 152.5 |      | 60.0              |
| 3                 | 10043           | HL  | 5.0  | -      | -     | 105.0 | 118.0 | 121.0 | 123.0 | 124.0 | 126.5 | 127.5 |      | 25.0              |
| 4                 | 10044           | LC  | 10.5 | -      | -     | -     | 104.0 | 107.0 | 109.0 | 110.0 | 112.5 | 113.5 |      | 14.0              |
| 5                 | 10045           | LC  | 8.5  | -      | -     | -     | -     | 105.0 | 107.0 | 108.0 | 110.5 | 111.5 |      | 2.0               |
| 6                 | 10046           | LC  | 5.0  | -      | -     | -     | -     | -     | 105.0 | 106.0 | 108.5 | 109.5 |      | 2.0               |
| 7                 | 10047           | DFS | 6.0  | -      | -     | -     | -     | -     | -     | 104.0 | 106.5 | 107.5 |      | 2.0               |
| 8                 | 10048           | DFS | 6.0  | -      | -     | -     | -     | -     | -     | -     | 105.0 | 106.0 |      | 1.5               |
| 9                 | 10049           | DFS | 4.0  | -      | -     | -     | -     | -     | -     | -     | -     | 105.0 |      | 1.0               |
| 10                |                 |     |      | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz   | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra   | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 943             | RH  | 0.7 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10051           | RH  | 1.5 | 135.0  | 176.0 | 207.0 | 220.0 | 222.0 | 225.0 | 226.0 | 227.5 | 229.0 |      | 0.0               |
| 2                 | 10052           | RH  | 4.5 | -      | 106.0 | 137.0 | 150.0 | 152.0 | 155.0 | 156.0 | 157.5 | 159.0 |      | 70.0              |
| 3                 | 10053           | HL  | 4.0 | -      | -     | 107.0 | 120.0 | 122.0 | 125.0 | 126.0 | 127.5 | 129.0 |      | 30.0              |
| 4                 | 10054           | LC  | 6.0 | -      | -     | -     | 106.0 | 108.0 | 111.0 | 112.0 | 113.5 | 115.0 |      | 14.0              |
| 5                 | 10055           | LC  | 7.0 | -      | -     | -     | -     | 106.0 | 109.0 | 110.0 | 111.5 | 113.0 |      | 2.0               |
| 6                 | 10056           | LC  | 6.0 | -      | -     | -     | -     | -     | 106.0 | 107.0 | 108.5 | 110.0 |      | 3.0               |
| 7                 | 10057           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 105.0 | 106.5 | 108.0 |      | 2.0               |
| 8                 | 10058           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | 105.0 | 106.5 |      | 1.5               |
| 9                 | 10059           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | -     | 105.0 |      | 1.5               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | DFS   |

Thickness 60 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 943             | RH  | 0.7 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10061           | RH  | 1.0 | 139.0  | 184.0 | 228.0 | 243.0 | 249.0 | 252.0 | 254.0 | 254.0 | 254.0 |      | 0.0               |
| 2                 | 10062           | RH  | 4.5 | -      | 104.0 | 148.0 | 163.0 | 169.0 | 172.0 | 174.0 | 174.0 | 174.0 |      | 80.0              |
| 3                 | 10063           | HL  | 4.0 | -      | -     | 108.0 | 123.0 | 129.0 | 132.0 | 134.0 | 134.0 | 134.0 |      | 40.0              |
| 4                 | 10064           | LC  | 2.5 | -      | -     | -     | 106.0 | 112.0 | 115.0 | 117.0 | 117.0 | 117.0 |      | 17.0              |
| 5                 | 10065           | LC  | 7.0 | -      | -     | -     | -     | 106.0 | 109.0 | 111.0 | 111.0 | 111.0 |      | 6.0               |
| 6                 | 10066           | LC  | 7.0 | -      | -     | -     | -     | -     | 106.0 | 108.0 | 108.0 | 108.0 |      | 3.0               |
| 7                 | 10067           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 106.0 | 106.0 | 106.0 |      | 2.0               |
| 8                 | 10068           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | 105.0 | 105.0 |      | 1.0               |
| 9                 | 10069           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | -     | 105.0 |      | 0.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 944             | RH  | 0.6 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10071           | RH  | 1.0 | 137.0  | 185.0 | 225.0 | 245.0 | 251.0 | 254.0 | 256.0 | 256.0 | 256.0 |      | 0.0               |
| 2                 | 10072           | RH  | 4.5 | -      | 105.0 | 145.0 | 165.0 | 171.0 | 174.0 | 176.0 | 176.0 | 176.0 |      | 80.0              |
| 3                 | 10073           | HL  | 4.0 | -      | -     | 105.0 | 125.0 | 131.0 | 134.0 | 136.0 | 136.0 | 136.0 |      | 40.0              |
| 4                 | 10074           | LC  | 2.5 | -      | -     | -     | 106.0 | 112.0 | 115.0 | 117.0 | 117.0 | 117.0 |      | 19.0              |
| 5                 | 10075           | LC  | 7.0 | -      | -     | -     | -     | 106.0 | 109.0 | 111.0 | 111.0 | 111.0 |      | 6.0               |
| 6                 | 10076           | LC  | 7.0 | -      | -     | -     | -     | -     | 106.0 | 108.0 | 108.0 | 108.0 |      | 3.0               |
| 7                 | 10077           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | 106.0 | 106.0 | 106.0 |      | 2.0               |
| 8                 | 10078           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | 105.0 | 105.0 |      | 1.0               |
| 9                 | 10079           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | -     | 105.0 |      | 0.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 944             | RH  | 0.6 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10081           | RH  | 1.0 | 142.0  | 186.0 | 224.0 | 248.0 | 255.0 | 257.0 | 259.0 | 259.0 | 259.0 |      | 0.0               |
| 2                 | 10082           | RH  | 4.5 | -      | 106.0 | 144.0 | 168.0 | 175.0 | 177.0 | 179.0 | 179.0 | 179.0 |      | 80.0              |
| 3                 | 10083           | HL  | 4.0 | -      | -     | 104.0 | 128.0 | 135.0 | 137.0 | 139.0 | 139.0 | 139.0 |      | 40.0              |
| 4                 | 10084           | LC  | 2.5 | -      | -     | -     | 106.0 | 113.0 | 115.0 | 117.0 | 117.0 | 117.0 |      | 22.0              |
| 5                 | 10085           | LC  | 7.0 | -      | -     | -     | -     | 107.0 | 109.0 | 111.0 | 111.0 | 111.0 |      | 6.0               |
| 6                 | 10086           | LC  | 7.0 | -      | -     | -     | -     | -     | 106.0 | 108.0 | 108.0 | 108.0 |      | 3.0               |
| 7                 | 10087           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | 106.0 | 106.0 | 106.0 |      | 2.0               |
| 8                 | 10088           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | 105.0 | 105.0 |      | 1.0               |
| 9                 | 10089           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | -     | 105.0 |      | 0.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.5   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.30  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 5mm                | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 941                   | 10001                 | 10002                 | 10003                    | 10004                 | 10005                 | 10006                 | 10007 | 10008 |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                       | LC                    | LC                    | LC                    | DFS   | DFS   |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                       | SL                    | SL                    | SL                    | NM    | NM    |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                       | 6                     | 6                     | 10                    | 13    | 11    |
| Power Setting      | IP  | 6.0                   | 7.0                   | 5.0                   | 12.0                     | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   |
| IP adjust          | ΔIP | 11                    | 9                     | 10                    | 10                       |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 10                       | 10                    | 10                    | 8                     | 2     | 2     |
| Stabilizer A       | SA  | 3                     | 4                     | 3                     | 1                        | 2                     | 1                     | 1                     | 6     | 6     |
| Stabilizer B       | SB  | 8                     | 6                     | 8                     | 10                       | 10                    | 9                     | 8                     | 1     | 1     |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                        | 1                     | 1                     | 1                     | 1     | 1     |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                     | 1                     | 1                     | 1     | 1     |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 56.0<br>(53.0 ~ 59.0) | 74.0<br>(72.0 ~ 76.0) | 110.0<br>(108.0 ~ 112.0) | 68.0<br>(66.0 ~ 70.0) | 84.0<br>(82.0 ~ 86.0) | 80.0<br>(78.0 ~ 82.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                      | OFF                   | ON                    | ON                    | OFF   | OFF   |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                       | OFF                   | OFF                   | OFF                   | OFF   | OFF   |
| Wire Speed         | WS  | 8                     | 9                     | 10                    | 10                       | 10                    | 10                    | 10                    | 10    | 10    |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       | 10                    | 10                    | 10                    | 10    | 10    |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                    | 14                    | 14                    | 14    | 14    |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                    | NM                    | NM                    | NM    | NM    |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                     | 4                     | 4                     | 4     | 4     |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                    | 10                    | 10                    | 10    | 10    |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                     | 0                     | 0                     | 0     | 0     |
| Feedrate Address   | FA  | 2.0                   | 6.0                   | 8.0                   | 8.0                      | 12.0                  | 10.5                  | 8.0                   | 8.0   | 8.0   |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 117.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 186.0 | 111.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 215.0 | 140.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 230.0 | 155.0 | 120.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 233.0 | 158.0 | 123.0 | 108.0 | 105.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 236.0 | 161.0 | 126.0 | 111.0 | 108.0 | 105.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 238.5 | 163.5 | 128.5 | 113.5 | 110.5 | 107.5 | 105.0 | ----- |
| Rough & 7 Skims    | ----- | 240.0 | 165.0 | 130.0 | 115.0 | 112.0 | 109.0 | 106.5 | 104.0 |
| Stepping Increment | ----- | ----- | 75.0  | 35.0  | 15.0  | 3.0   | 3.0   | 2.5   | 2.5   |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 9.3 ~ 11.4  | 13.4 ~ 16.3 | 14.1 ~ 17.3 | 11.2 ~ 13.1 | 10.2 ~ 10.6 | 7.2 ~ 8.8   | 8.0 ~ 8.0   | 8.0 ~ 8.0   |
| Average Voltage Gap  | V   |  | 45 ~ 67     | 69 ~ 80     | 110 ~ 122   | 79 ~ 91     | 94 ~ 106    | 119 ~ 129   |             |             |
| Avg. Linear Feedrate | ALF |  | 621.0       | 365.9       | 263.6       | 193.6       | 147.7       | 113.0       | 91.4        | 76.8        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 10.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 941                   | 10011                 | 10012                 | 10013                 | 10014                 | 10015                 | 10016                 | 10017 | 10018 | 10019 |
| Power Supply       | PS       | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 7                     | 4                     | 12                    | 7                     | 6                     | 10                    | 13    | 11    | 9     |
| Power Setting      | IP       | 6.0                   | 7.0                   | 5.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 9                     | 10                    | 12                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 8                     | 10                    | 10                    | 10                    | 8                     | 12    | 2     | 2     |
| Stabilizer A       | SA       | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 8                     | 7                     | 8                     | 10                    | 10                    | 9                     | 8                     | 1     | 1     | 1     |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 64.0<br>(62.0 ~ 66.0) | 88.0<br>(86.0 ~ 90.0) | 72.0<br>(70.0 ~ 74.0) | 72.0<br>(70.0 ~ 74.0) | 62.0<br>(60.0 ~ 64.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Wire Tension       | WT       | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     | 0     |
| Feedrate Address   | FA       | 2.0                   | 4.0                   | 8.0                   | 7.5                   | 11.0                  | 10.0                  | 7.5                   | 8.0   | 8.0   | 4.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 119.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 177.0 | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 209.0 | 139.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 224.0 | 154.0 | 119.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 228.0 | 158.0 | 123.0 | 109.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 230.0 | 160.0 | 125.0 | 111.0 | 108.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 233.0 | 163.0 | 128.0 | 114.0 | 111.0 | 108.0 | 105.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 236.0 | 166.0 | 131.0 | 117.0 | 114.0 | 111.0 | 108.0 | 106.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 236.5 | 166.5 | 131.5 | 117.5 | 114.5 | 111.5 | 108.5 | 106.5 | 105.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 70.0  | 35.0  | 14.0  | 3.0   | 3.0   | 3.0   | 2.0   | 1.5   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 4.6 ~ 5.7   | 12.3 ~ 15.1 | 12.0 ~ 14.7 | 10.5 ~ 12.1 | 9.5 ~ 10.2  | 6.9 ~ 8.5   | 8.0 ~ 8.0   | 8.0 ~ 8.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 35 ~ 56     | 54 ~ 72     | 81 ~ 95     | 80 ~ 91     | 84 ~ 94     | 100 ~ 112   |             |             |             |
| Avg. Linear Feedrate | ALF |  | 309.0       | 224.6       | 175.4       | 139.4       | 112.8       | 90.6        | 76.2        | 65.8        | 51.6        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 20.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 941                   | 10021                 | 10022                 | 10023                 | 10024                 | 10025                 | 10026                 | 10027 | 10028 | 10029 |
| Power Supply       | PS       | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 7                     | 4                     | 12                    | 8                     | 7                     | 11                    | 13    | 13    | 9     |
| Power Setting      | IP       | 6.0                   | 8.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 9                     | 10                    | 12                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 8                     | 9                     | 10                    | 10                    | 8                     | 12    | 12    | 12    |
| Stabilizer A       | SA       | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 8                     | 5                     | 8                     | 9                     | 10                    | 9                     | 8                     | 3     | 1     | 1     |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 60.0<br>(58.0 ~ 62.0) | 42.0<br>(39.0 ~ 45.0) | 60.0<br>(58.0 ~ 62.0) | 75.0<br>(73.0 ~ 77.0) | 72.0<br>(70.0 ~ 74.0) | 64.0<br>(62.0 ~ 66.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 11                    | 11                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     | 0     |
| Feedrate Address   | FA       | 2.0                   | 3.0                   | 6.0                   | 7.0                   | 10.5                  | 8.0                   | 7.0                   | 8.0   | 8.0   | 8.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 125.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 177.0 | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 208.0 | 138.0 | 103.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 222.0 | 152.0 | 117.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 226.0 | 156.0 | 121.0 | 109.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 229.0 | 159.0 | 124.0 | 112.0 | 108.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 231.0 | 161.0 | 126.0 | 114.0 | 110.0 | 107.0 | 105.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 233.0 | 163.0 | 128.0 | 116.0 | 112.0 | 109.0 | 107.0 | 106.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 233.0 | 163.0 | 128.0 | 116.0 | 112.0 | 109.0 | 107.0 | 106.0 | 105.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 70.0  | 35.0  | 12.0  | 4.0   | 3.0   | 2.0   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 3.4 ~ 4.1   | 9.2 ~ 11.2  | 9.5 ~ 11.6  | 10.0 ~ 11.5 | 7.5 ~ 8.7   | 6.5 ~ 7.9   | 8.0 ~ 8.0   | 8.0 ~ 8.0   | 8.0 ~ 8.0   |
| Average Voltage Gap  | V   |  | 34 ~ 48     | 53 ~ 65     | 70 ~ 81     | 78 ~ 89     | 74 ~ 84     | 85 ~ 96     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 225.0       | 164.5       | 130.6       | 108.6       | 88.8        | 73.6        | 63.8        | 56.3        | 50.4        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 30.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 942                   | 10031                 | 10032                 | 10033                 | 10034                 | 10035                 | 10036                 | 10037 | 10038 | 10039 |
| Power Supply       | PS       | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 7                     | 4                     | 12                    | 8                     | 8                     | 12                    | 14    | 14    | 9     |
| Power Setting      | IP       | 7.0                   | 8.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 9                     | 10                    | 12                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 8                     | 9                     | 10                    | 9                     | 6                     | 12    | 12    | 9     |
| Stabilizer A       | SA       | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 8                     | 5                     | 8                     | 9                     | 10                    | 9                     | 8                     | 4     | 3     | 1     |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 41.0<br>(38.0 ~ 44.0) | 60.0<br>(58.0 ~ 62.0) | 72.0<br>(70.0 ~ 74.0) | 53.0<br>(51.0 ~ 55.0) | 64.0<br>(62.0 ~ 66.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    | 8     | 8     | 8     |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Feedrate Address   | FA       | 1.0                   | 2.0                   | 5.0                   | 6.0                   | 10.5                  | 8.0                   | 6.0                   | 6.0   | 6.0   | 6.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 172.0 | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 199.0 | 134.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 212.0 | 147.0 | 117.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 215.0 | 150.0 | 120.0 | 108.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 217.0 | 152.0 | 122.0 | 110.0 | 107.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 219.0 | 154.0 | 124.0 | 112.0 | 109.0 | 107.0 | 105.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 220.0 | 155.0 | 125.0 | 113.0 | 110.0 | 108.0 | 106.0 | 105.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 221.0 | 156.0 | 126.0 | 114.0 | 111.0 | 109.0 | 107.0 | 106.0 | 105.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 30.0  | 12.0  | 3.0   | 2.0   | 2.0   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 2.7 ~ 3.8   | 7.9 ~ 9.6   | 8.5 ~ 10.5  | 10.0 ~ 11.2 | 7.5 ~ 8.7   | 5.5 ~ 6.5   | 6.0 ~ 6.0   | 6.0 ~ 6.0   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 33 ~ 48     | 54 ~ 66     | 68 ~ 77     | 59 ~ 72     | 68 ~ 79     | 73 ~ 85     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 195.0       | 142.2       | 113.8       | 96.5        | 80.5        | 65.8        | 55.6        | 48.2        | 42.5        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 40.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 | Skim8 | Skim9 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 10041                 | 10042                 | 10043                 | 10044                 | 10045                 | 10046                 | 10047 | 10048 | 10049 |       |
| Power Supply       | PS  | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 12                    | 10                    | 8                     | 14                    | 14    | 14    | 10    |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 11                    | 10                    | 10                    | 12                    |                       |                       |                       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 9                     | 10                    | 8                     | 6                     | 12    | 12    | 6     |       |
| Stabilizer A       | SA  | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |       |
| Stabilizer B       | SB  | 8                     | 6                     | 8                     | 9                     | 10                    | 8                     | 8                     | 6     | 3     | 1     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 60.0<br>(58.0 ~ 62.0) | 68.0<br>(66.0 ~ 70.0) | 34.0<br>(32.0 ~ 36.0) | 64.0<br>(62.0 ~ 66.0) | 62.0<br>(60.0 ~ 64.0) |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    | OFF   | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    | 8     | 8     | 8     |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |       |
| Feedrate Address   | FA  | 1.0                   | 2.0                   | 5.0                   | 5.0                   | 10.5                  | 8.5                   | 5.0                   | 6.0   | 6.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 168.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 190.0 | 130.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 203.0 | 143.0 | 118.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 206.0 | 146.0 | 121.0 | 107.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 208.0 | 148.0 | 123.0 | 109.0 | 107.0 | 105.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 209.0 | 149.0 | 124.0 | 110.0 | 108.0 | 106.0 | 104.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 211.5 | 151.5 | 126.5 | 112.5 | 110.5 | 108.5 | 106.5 | 105.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 212.5 | 152.5 | 127.5 | 113.5 | 111.5 | 109.5 | 107.5 | 106.0 | 105.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 25.0  | 14.0  | 2.0   | 2.0   | 2.0   | 1.5   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 2.0 ~ 2.5   | 6.6 ~ 8.0   | 7.9 ~ 9.7   | 10.0 ~ 11.0 | 7.9 ~ 8.7   | 4.8 ~ 5.3   | 6.0 ~ 6.0   | 6.0 ~ 6.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 32 ~ 48     | 56 ~ 67     | 62 ~ 74     | 41 ~ 55     | 62 ~ 74     | 61 ~ 74     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 135.0       | 103.2       | 86.3        | 75.9        | 65.9        | 54.1        | 47.0        | 41.6        | 35.5        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 50.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 943                   | 10051                 | 10052                 | 10053                 | 10054                 | 10055                 | 10056                 | 10057 | 10058 | 10059 |
| Power Supply       | PS       | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 7                     | 4                     | 12                    | 10                    | 8                     | 14                    | 14    | 14    | 10    |
| Power Setting      | IP       | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 10                    | 10                    | 12                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 8                     | 9                     | 10                    | 8                     | 6                     | 12    | 13    | 6     |
| Stabilizer A       | SA       | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 5                     | 8                     | 9                     | 10                    | 8                     | 8                     | 6     | 3     | 1     |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 39.0<br>(36.0 ~ 42.0) | 55.0<br>(53.0 ~ 57.0) | 57.0<br>(55.0 ~ 59.0) | 42.0<br>(40.0 ~ 44.0) | 64.0<br>(62.0 ~ 66.0) | 51.0<br>(49.0 ~ 53.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    | 8     | 8     | 8     |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Feedrate Address   | FA       | 0.7                   | 1.5                   | 4.5                   | 4.0                   | 6.0                   | 7.0                   | 6.0                   | 6.0   | 6.0   | 5.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 176.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 207.0 | 137.0 | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 220.0 | 150.0 | 120.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 222.0 | 152.0 | 122.0 | 108.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 225.0 | 155.0 | 125.0 | 111.0 | 109.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 226.0 | 156.0 | 126.0 | 112.0 | 110.0 | 107.0 | 105.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 227.5 | 157.5 | 127.5 | 113.5 | 111.5 | 108.5 | 106.5 | 105.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 229.0 | 159.0 | 129.0 | 115.0 | 113.0 | 110.0 | 108.0 | 106.5 | 105.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 70.0  | 30.0  | 14.0  | 2.0   | 3.0   | 2.0   | 1.5   | 1.5   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.6 ~ 2.2   | 4.7 ~ 5.7   | 3.0 ~ 4.0   | 6.5 ~ 7.5   | 7.0 ~ 8.0   | 5.2 ~ 6.0   | 6.0 ~ 6.0   | 6.0 ~ 6.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 32 ~ 47     | 50 ~ 63     | 56 ~ 68     | 49 ~ 62     | 67 ~ 79     | 59 ~ 71     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 114.0       | 83.5        | 59.7        | 52.3        | 46.9        | 41.1        | 36.9        | 33.5        | 30.1        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 60.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 943                   | 10061                 | 10062                 | 10063                 | 10064                 | 10065                 | 10066                 | 10067 | 10068 | 10069 |
| Power Supply       | PS       | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 7                     | 4                     | 12                    | 10                    | 14                    | 12                    | 15    | 13    | 10    |
| Power Setting      | IP       | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 3.0                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 11                    | 10                    | 12                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 8                     | 9                     | 10                    | 8                     | 6                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 5                     | 8                     | 9                     | 10                    | 8                     | 8                     | 9     | 1     | 1     |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 38.0<br>(35.0 ~ 41.0) | 51.0<br>(49.0 ~ 53.0) | 52.0<br>(50.0 ~ 54.0) | 50.0<br>(48.0 ~ 52.0) | 65.0<br>(63.0 ~ 67.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    | 8     | 8     | 8     |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 40                    | 40                    | 40                    | 40                    | 10                    | 10                    | 10    | 10    | 10    |
| Feedrate Address   | FA       | 0.7                   | 1.0                   | 4.5                   | 4.0                   | 2.5                   | 7.0                   | 7.0                   | 6.0   | 6.0   | 6.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 139.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 184.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 228.0 | 148.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 243.0 | 163.0 | 123.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 249.0 | 169.0 | 129.0 | 112.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 252.0 | 172.0 | 132.0 | 115.0 | 109.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 254.0 | 174.0 | 134.0 | 117.0 | 111.0 | 108.0 | 106.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 254.0 | 174.0 | 134.0 | 117.0 | 111.0 | 108.0 | 106.0 | 105.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 254.0 | 174.0 | 134.0 | 117.0 | 111.0 | 108.0 | 106.0 | 105.0 | 105.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 80.0  | 40.0  | 17.0  | 6.0   | 3.0   | 2.0   | 1.0   | 0.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.4 ~ 1.8   | 2.9 ~ 3.5   | 2.0 ~ 2.5   | 4.4 ~ 4.9   | 6.3 ~ 7.0   | 6.6 ~ 7.2   | 6.0 ~ 6.0   | 6.0 ~ 6.0   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 33 ~ 47     | 44 ~ 60     | 51 ~ 63     | 57 ~ 69     | 72 ~ 85     | 57 ~ 68     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 96.0        | 64.0        | 43.4        | 37.6        | 34.3        | 31.7        | 29.1        | 27.0        | 25.1        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 70.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 944                   | 10071                 | 10072                 | 10073                 | 10074                 | 10075                 | 10076                 | 10077 | 10078 | 10079 |
| Power Supply       | PS       | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 7                     | 4                     | 12                    | 10                    | 14                    | 12                    | 15    | 13    | 10    |
| Power Setting      | IP       | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 3.0                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 11                    | 10                    | 12                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 8                     | 9                     | 10                    | 8                     | 6                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 5                     | 8                     | 9                     | 10                    | 8                     | 8                     | 9     | 1     | 1     |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 38.0<br>(35.0 ~ 41.0) | 46.0<br>(44.0 ~ 48.0) | 42.0<br>(40.0 ~ 44.0) | 50.0<br>(48.0 ~ 52.0) | 65.0<br>(63.0 ~ 67.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    | 8     | 8     | 8     |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 40                    | 40                    | 40                    | 40                    | 10                    | 10                    | 10    | 10    | 10    |
| Feedrate Address   | FA       | 0.6                   | 1.0                   | 4.5                   | 4.0                   | 2.5                   | 7.0                   | 7.0                   | 5.0   | 5.0   | 5.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 137.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 185.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 225.0 | 145.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 245.0 | 165.0 | 125.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 251.0 | 171.0 | 131.0 | 112.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 254.0 | 174.0 | 134.0 | 115.0 | 109.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 256.0 | 176.0 | 136.0 | 117.0 | 111.0 | 108.0 | 106.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 256.0 | 176.0 | 136.0 | 117.0 | 111.0 | 108.0 | 106.0 | 105.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 256.0 | 176.0 | 136.0 | 117.0 | 111.0 | 108.0 | 106.0 | 105.0 | 105.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 80.0  | 40.0  | 19.0  | 6.0   | 3.0   | 2.0   | 1.0   | 0.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.2 ~ 1.5   | 3.2 ~ 4.0   | 2.0 ~ 2.5   | 2.4 ~ 3.5   | 6.2 ~ 7.0   | 6.6 ~ 7.2   | 5.0 ~ 5.0   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 30 ~ 47     | 40 ~ 56     | 40 ~ 49     | 56 ~ 62     | 69 ~ 77     | 57 ~ 69     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 81.0        | 58.9        | 41.0        | 33.3        | 30.7        | 28.6        | 26.1        | 24.0        | 22.2        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 80.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 944                   | 10081                 | 10082                 | 10083                 | 10084                 | 10085                 | 10086                 | 10087 | 10088 | 10089 |
| Power Supply       | PS       | RH                    | RH                    | RH                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 7                     | 4                     | 12                    | 10                    | 14                    | 12                    | 15    | 13    | 10    |
| Power Setting      | IP       | 7.0                   | 9.0                   | 6.0                   | 14.0                  | 2.5                   | 3.0                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 11                    | 10                    | 12                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 8                     | 9                     | 10                    | 8                     | 6                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 5                     | 3                     | 1                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 5                     | 8                     | 9                     | 10                    | 8                     | 8                     | 9     | 1     | 1     |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 38.0<br>(35.0 ~ 41.0) | 41.0<br>(39.0 ~ 43.0) | 32.0<br>(30.0 ~ 34.0) | 50.0<br>(48.0 ~ 52.0) | 65.0<br>(63.0 ~ 67.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    | 8     | 8     | 8     |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 50                    | 50                    | 50                    | 50                    | 20                    | 20                    | 20    | 20    | 20    |
| Feedrate Address   | FA       | 0.6                   | 1.0                   | 4.5                   | 4.0                   | 2.5                   | 7.0                   | 7.0                   | 5.0   | 5.0   | 5.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 142.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 186.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 224.0 | 144.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 248.0 | 168.0 | 128.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 255.0 | 175.0 | 135.0 | 113.0 | 107.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 257.0 | 177.0 | 137.0 | 115.0 | 109.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 259.0 | 179.0 | 139.0 | 117.0 | 111.0 | 108.0 | 106.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 259.0 | 179.0 | 139.0 | 117.0 | 111.0 | 108.0 | 106.0 | 105.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 259.0 | 179.0 | 139.0 | 117.0 | 111.0 | 108.0 | 106.0 | 105.0 | 105.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 80.0  | 40.0  | 22.0  | 6.0   | 3.0   | 2.0   | 1.0   | 0.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.1 ~ 1.3   | 3.7 ~ 4.6   | 2.0 ~ 2.5   | 1.4 ~ 1.7   | 6.2 ~ 6.9   | 6.6 ~ 7.2   | 5.0 ~ 5.0   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 25 ~ 47     | 35 ~ 51     | 26 ~ 39     | 45 ~ 56     | 58 ~ 70     | 58 ~ 70     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 72.0        | 55.9        | 39.5        | 27.7        | 25.9        | 24.4        | 22.5        | 21.0        | 19.6        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 2.2 ~ 2.8   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.27 ~ 0.45 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | WC-Co         | DFS   |

Thickness 5 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |     |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-----|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th | 10th |                   |
| A                 | 941             | RH  | 2.0 |        |       |       |       |       |       |       |       |     |      |                   |
| 1                 | 10201           | RL  | 2.5 | 133.0  | 176.0 | 224.0 | 240.0 | 244.0 | 245.0 | 246.0 | 246.0 |     |      | 0.0               |
| 2                 | 10202           | KL  | 5.5 | -      | 106.0 | 154.0 | 170.0 | 174.0 | 175.0 | 176.0 | 176.0 |     |      | 70.0              |
| 3                 | 10203           | RL  | 5.5 | -      | -     | 114.0 | 130.0 | 134.0 | 135.0 | 136.0 | 136.0 |     |      | 40.0              |
| 4                 | 10204           | LC  | 7.0 | -      | -     | -     | 107.0 | 111.0 | 112.0 | 113.0 | 113.0 |     |      | 23.0              |
| 5                 | 10205           | LC  | 7.0 | -      | -     | -     | -     | 108.0 | 109.0 | 110.0 | 110.0 |     |      | 3.0               |
| 6                 | 10206           | LC  | 7.0 | -      | -     | -     | -     | -     | 107.0 | 108.0 | 108.0 |     |      | 2.0               |
| 7                 | 10207           | DFS | 7.0 | -      | -     | -     | -     | -     | -     | 103.0 | 103.0 |     |      | 5.0               |
| 8                 | 10208           | DFS | 7.0 | -      | -     | -     | -     | -     | -     | -     | 102.0 |     |      | 1.0               |
| 9                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     |     |      |                   |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -   |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 13.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.2   | 0.9   |     |      |                   |
|                   |                 |     | Ra  | 2.50   | 1.80  | 1.80  | 0.80  | 0.30  | 0.28  | 0.15  | 0.13  |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |     |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-----|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th | 10th |                   |
| A                 | 941             | RH  | 2.0 |        |       |       |       |       |       |       |       |     |      |                   |
| 1                 | 10211           | RL  | 2.0 | 132.0  | 172.0 | 209.0 | 223.0 | 226.0 | 228.0 | 229.0 | 230.0 |     |      | 0.0               |
| 2                 | 10212           | KL  | 5.0 | -      | 107.0 | 144.0 | 158.0 | 161.0 | 163.0 | 164.0 | 165.0 |     |      | 65.0              |
| 3                 | 10213           | RL  | 5.0 | -      | -     | 113.0 | 127.0 | 130.0 | 132.0 | 133.0 | 134.0 |     |      | 31.0              |
| 4                 | 10214           | LC  | 7.0 | -      | -     | -     | 107.0 | 110.0 | 112.0 | 113.0 | 114.0 |     |      | 20.0              |
| 5                 | 10215           | LC  | 7.0 | -      | -     | -     | -     | 107.0 | 109.0 | 110.0 | 111.0 |     |      | 3.0               |
| 6                 | 10216           | LC  | 7.0 | -      | -     | -     | -     | -     | 108.0 | 109.0 | 110.0 |     |      | 1.0               |
| 7                 | 10217           | DFS | 7.0 | -      | -     | -     | -     | -     | -     | 104.0 | 105.0 |     |      | 5.0               |
| 8                 | 10218           | DFS | 7.0 | -      | -     | -     | -     | -     | -     | -     | 103.0 |     |      | 2.0               |
| 9                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     |     |      |                   |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -   |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 13.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.2   | 0.9   |     |      |                   |
|                   |                 |     | Ra  | 2.50   | 1.80  | 1.80  | 0.80  | 0.30  | 0.28  | 0.15  | 0.13  |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 941             | RH  | 2.0 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10221           | RL  | 2.0 | 137.0  | 170.0 | 199.0 | 213.0 | 217.0 | 219.0 | 220.0 | 220.0 | 221.0 |      | 0.0               |
| 2                 | 10222           | KL  | 5.0 | -      | 105.0 | 134.0 | 148.0 | 152.0 | 154.0 | 155.0 | 155.0 | 156.0 |      | 65.0              |
| 3                 | 10223           | RL  | 5.0 | -      | -     | 108.0 | 122.0 | 126.0 | 128.0 | 129.0 | 129.0 | 130.0 |      | 26.0              |
| 4                 | 10224           | LC  | 7.0 | -      | -     | -     | 104.0 | 108.0 | 110.0 | 111.0 | 111.0 | 112.0 |      | 18.0              |
| 5                 | 10225           | LC  | 7.0 | -      | -     | -     | -     | 105.0 | 107.0 | 108.0 | 108.0 | 109.0 |      | 3.0               |
| 6                 | 10226           | LC  | 7.0 | -      | -     | -     | -     | -     | 106.0 | 107.0 | 107.0 | 108.0 |      | 1.0               |
| 7                 | 10227           | DFS | 6.5 | -      | -     | -     | -     | -     | -     | 104.0 | 104.0 | 105.0 |      | 3.0               |
| 8                 | 10228           | DFS | 6.5 | -      | -     | -     | -     | -     | -     | -     | 103.0 | 104.0 |      | 1.0               |
| 9                 | 10229           | DFS | 6.5 | -      | -     | -     | -     | -     | -     | -     | -     | 103.0 |      | 1.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 13.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 1.80  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | WC-Co         | DFS   |

Thickness 30 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 942             | RH  | 1.0 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10231           | RL  | 1.6 | 138.0  | 170.0 | 198.0 | 210.0 | 213.0 | 214.0 | 216.0 | 217.0 | 217.0 |      | 0.0               |
| 2                 | 10232           | KL  | 4.2 | -      | 105.0 | 133.0 | 145.0 | 148.0 | 149.0 | 151.0 | 152.0 | 152.0 |      | 65.0              |
| 3                 | 10233           | RL  | 4.0 | -      | -     | 110.0 | 122.0 | 125.0 | 126.0 | 128.0 | 129.0 | 129.0 |      | 23.0              |
| 4                 | 10234           | LC  | 6.0 | -      | -     | -     | 106.0 | 109.0 | 110.0 | 112.0 | 113.0 | 113.0 |      | 16.0              |
| 5                 | 10235           | LC  | 6.0 | -      | -     | -     | -     | 106.0 | 107.0 | 109.0 | 110.0 | 110.0 |      | 3.0               |
| 6                 | 10236           | LC  | 6.0 | -      | -     | -     | -     | -     | 106.0 | 108.0 | 109.0 | 109.0 |      | 1.0               |
| 7                 | 10237           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 105.0 | 106.0 | 106.0 |      | 3.0               |
| 8                 | 10238           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | 105.0 | 105.0 |      | 1.0               |
| 9                 | 10239           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | -     | 104.0 |      | 1.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.20  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 942             | RH  | 1.0 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10241           | RL  | 1.2 | 140.0  | 169.0 | 194.0 | 206.0 | 208.0 | 210.0 | 213.0 | 214.0 | 214.0 |      | 0.0               |
| 2                 | 10242           | KL  | 3.5 | -      | 104.0 | 129.0 | 141.0 | 143.0 | 145.0 | 148.0 | 149.0 | 149.0 |      | 65.0              |
| 3                 | 10243           | RL  | 3.0 | -      | -     | 109.0 | 121.0 | 123.0 | 125.0 | 128.0 | 129.0 | 129.0 |      | 20.0              |
| 4                 | 10244           | LC  | 6.0 | -      | -     | -     | 107.0 | 109.0 | 111.0 | 114.0 | 115.0 | 115.0 |      | 14.0              |
| 5                 | 10245           | LC  | 6.0 | -      | -     | -     | -     | 106.0 | 108.0 | 111.0 | 112.0 | 112.0 |      | 3.0               |
| 6                 | 10246           | LC  | 6.0 | -      | -     | -     | -     | -     | 106.0 | 109.0 | 110.0 | 110.0 |      | 2.0               |
| 7                 | 10247           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | 106.0 | 107.0 | 107.0 |      | 3.0               |
| 8                 | 10248           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | 106.0 | 106.0 |      | 1.0               |
| 9                 | 10249           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | -     | 105.0 |      | 1.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.20  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 943             | RH  | 0.7 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10251           | RL  | 1.1 | 142.0  | 170.0 | 196.0 | 207.0 | 209.0 | 211.0 | 212.0 | 213.0 | 213.5 |      | 0.0               |
| 2                 | 10252           | KL  | 3.2 | -      | 105.0 | 131.0 | 142.0 | 144.0 | 146.0 | 147.0 | 148.0 | 148.5 |      | 65.0              |
| 3                 | 10253           | RL  | 2.7 | -      | -     | 111.0 | 122.0 | 124.0 | 126.0 | 127.0 | 128.0 | 128.5 |      | 20.0              |
| 4                 | 10254           | LC  | 6.0 | -      | -     | -     | 108.0 | 110.0 | 112.0 | 113.0 | 114.0 | 114.5 |      | 14.0              |
| 5                 | 10255           | LC  | 6.0 | -      | -     | -     | -     | 108.0 | 110.0 | 111.0 | 112.0 | 112.5 |      | 2.0               |
| 6                 | 10256           | LC  | 6.0 | -      | -     | -     | -     | -     | 108.0 | 109.0 | 110.0 | 110.5 |      | 2.0               |
| 7                 | 10257           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | 107.0 | 108.0 | 108.5 |      | 2.0               |
| 8                 | 10258           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | -     | 107.0 | 107.5 |      | 1.0               |
| 9                 | 10259           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | -     | -     | 106.0 |      | 1.5               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.20  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | WC-Co         | DFS   |

Thickness 60 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 943             | RH  | 0.7 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10261           | RL  | 1.0 | 144.0  | 170.0 | 198.0 | 208.0 | 211.0 | 210.0 | 214.0 | 214.0 | 214.5 |      | 0.0               |
| 2                 | 10262           | KL  | 3.0 | -      | 105.0 | 133.0 | 143.0 | 146.0 | 145.0 | 149.0 | 149.0 | 149.5 |      | 65.0              |
| 3                 | 10263           | RL  | 2.5 | -      | -     | 113.0 | 123.0 | 126.0 | 125.0 | 129.0 | 129.0 | 129.5 |      | 20.0              |
| 4                 | 10264           | LC  | 6.0 | -      | -     | -     | 109.0 | 112.0 | 111.0 | 115.0 | 115.0 | 115.5 |      | 14.0              |
| 5                 | 10265           | LC  | 6.0 | -      | -     | -     | -     | 110.0 | 109.0 | 113.0 | 113.0 | 113.5 |      | 2.0               |
| 6                 | 10266           | LC  | 6.0 | -      | -     | -     | -     | -     | 107.0 | 111.0 | 111.0 | 111.5 |      | 2.0               |
| 7                 | 10267           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | 109.0 | 109.0 | 109.5 |      | 2.0               |
| 8                 | 10268           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | -     | 108.0 | 108.5 |      | 1.0               |
| 9                 | 10269           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | -     | -     | 107.0 |      | 1.5               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.20  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 944             | RH  | 0.6 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10271           | RL  | 1.0 | 144.0  | 172.0 | 200.0 | 208.0 | 210.0 | 210.0 | 213.0 | 212.5 | 214.0 |      | 0.0               |
| 2                 | 10272           | KL  | 3.0 | -      | 107.0 | 135.0 | 143.0 | 145.0 | 145.0 | 148.0 | 147.5 | 149.0 |      | 65.0              |
| 3                 | 10273           | RL  | 2.5 | -      | -     | 115.0 | 123.0 | 125.0 | 125.0 | 128.0 | 127.5 | 129.0 |      | 20.0              |
| 4                 | 10274           | LC  | 6.0 | -      | -     | -     | 109.0 | 111.0 | 111.0 | 114.0 | 113.5 | 115.0 |      | 14.0              |
| 5                 | 10275           | LC  | 6.0 | -      | -     | -     | -     | 109.0 | 109.0 | 112.0 | 111.5 | 113.0 |      | 2.0               |
| 6                 | 10276           | LC  | 6.0 | -      | -     | -     | -     | -     | 107.0 | 110.0 | 109.5 | 111.0 |      | 2.0               |
| 7                 | 10277           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | 108.0 | 107.5 | 109.0 |      | 2.0               |
| 8                 | 10278           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | -     | 106.0 | 107.5 |      | 1.5               |
| 9                 | 10279           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | -     | -     | 106.0 |      | 1.5               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.20  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 944             | RH  | 0.6 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10281           | RL  | 1.0 | 145.0  | 174.0 | 203.0 | 208.0 | 210.0 | 210.0 | 212.0 | 212.0 | 213.5 |      | 0.0               |
| 2                 | 10282           | KL  | 3.0 | -      | 109.0 | 138.0 | 143.0 | 145.0 | 145.0 | 147.0 | 147.0 | 148.5 |      | 65.0              |
| 3                 | 10283           | RL  | 2.5 | -      | -     | 118.0 | 123.0 | 125.0 | 125.0 | 127.0 | 127.0 | 128.5 |      | 20.0              |
| 4                 | 10284           | LC  | 6.0 | -      | -     | -     | 109.0 | 111.0 | 111.0 | 113.0 | 113.0 | 114.5 |      | 14.0              |
| 5                 | 10285           | LC  | 6.0 | -      | -     | -     | -     | 109.0 | 109.0 | 111.0 | 111.0 | 112.5 |      | 2.0               |
| 6                 | 10286           | LC  | 6.0 | -      | -     | -     | -     | -     | 107.0 | 109.0 | 109.0 | 110.5 |      | 2.0               |
| 7                 | 10287           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | 107.0 | 107.0 | 108.5 |      | 2.0               |
| 8                 | 10288           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | -     | 105.0 | 106.5 |      | 2.0               |
| 9                 | 10289           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | -     | -     | 105.0 |      | 1.5               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.20  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 5mm                | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                   | Skim2                 | Skim3                 | Skim4                    | Skim5                    | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-------------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|
| E-pack Number      | Eno | 941                   | 10201                 | 10202                   | 10203                 | 10204                 | 10205                    | 10206                    | 10207 | 10208 |
| Power Supply       | PS  | RH                    | RL                    | KL                      | RL                    | LC                    | LC                       | LC                       | DFS   | DFS   |
| Servo              | SV  | NM                    | NM                    | NM                      | NM                    | SL                    | SL                       | SL                       | NM    | NM    |
| Voltage Open       | Vo  | 7                     | 4                     | 7                       | 4                     | 10                    | 14                       | 12                       | 13    | 11    |
| Power Setting      | IP  | 6.0                   | 10.0                  | 8.0                     | 7.0                   | 2.5                   | 2.5                      | 2.0                      | 1.0   | 1.0   |
| IP adjust          | ΔIP | 11                    | 12                    | 10                      | 10                    |                       |                          |                          |       |       |
| Off Time           | OFF | 6                     | 3                     | 3                       | 10                    | 10                    | 4                        | 3                        | 13    | 13    |
| Stabilizer A       | SA  | 3                     | 5                     | 5                       | 4                     | 2                     | 1                        | 1                        | 6     | 6     |
| Stabilizer B       | SB  | 8                     | 10                    | 12                      | 10                    | 10                    | 8                        | 8                        | 1     | 2     |
| Stabilizer C       | SC  | 7                     | 3                     | 1                       | 1                     | 1                     | 1                        | 1                        | 1     | 1     |
| Stabilizer E       | SE  | 4                     | 4                     | 1                       | 1                     | 1                     | 1                        | 1                        | 1     | 1     |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(57.0 ~ 63.0) | 100.0<br>(98.0 ~ 102.0) | 70.0<br>(68.0 ~ 72.0) | 90.0<br>(88.0 ~ 92.0) | 150.0<br>(148.0 ~ 152.0) | 135.0<br>(133.0 ~ 137.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                     | OFF                   | OFF                   | ON                       | ON                       | OFF   | OFF   |
| Digital AE         | DAE | OFF                   | OFF                   | ON                      | OFF                   | OFF                   | OFF                      | OFF                      | OFF   | OFF   |
| Wire Speed         | WS  | 8                     | 10                    | 10                      | 10                    | 10                    | 10                       | 10                       | 11    | 11    |
| Wire Tension       | WT  | 6                     | 8                     | 10                      | 10                    | 10                    | 10                       | 10                       | 8     | 8     |
| Pre-Tension        | PT  | 14                    | 14                    | 14                      | 14                    | 14                    | 14                       | 14                       | 14    | 14    |
| Flow Balance       | FB  | NM                    | NM                    | NM                      | NM                    | NM                    | NM                       | NM                       | NM    | NM    |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                       | 4                     | 4                     | 4                        | 4                        | 4     | 4     |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                      | 10                    | 10                    | 10                       | 10                       | 10    | 10    |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                       | 0                     | 0                     | 0                        | 0                        | 0     | 0     |
| Feedrate Address   | FA  | 2.0                   | 2.5                   | 5.5                     | 5.5                   | 7.0                   | 7.0                      | 7.0                      | 7.0   | 7.0   |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                     | 1.0                   | 1.0                   | 1.0                      | 1.0                      | 1.0   | 1.0   |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                     | 1.0                   | 1.0                   | 1.0                      | 1.0                      | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 176.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 224.0 | 154.0 | 114.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 240.0 | 170.0 | 130.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 244.0 | 174.0 | 134.0 | 111.0 | 108.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 245.0 | 175.0 | 135.0 | 112.0 | 109.0 | 107.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 246.0 | 176.0 | 136.0 | 113.0 | 110.0 | 108.0 | 103.0 | ----- |
| Rough & 7 Skims    | ----- | 246.0 | 176.0 | 136.0 | 113.0 | 110.0 | 108.0 | 103.0 | 102.0 |
| Stepping Increment | ----- | ----- | 70.0  | 40.0  | 23.0  | 3.0   | 2.0   | 5.0   | 1.0   |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 5.2 ~ 6.4   | 9.5 ~ 11.7  | 9.1 ~ 11.2  | 6.5 ~ 7.2   | 6.5 ~ 7.1   | 6.5 ~ 7.2   | 7.0 ~ 7.0   | 7.0 ~ 7.0   |
| Average Voltage Gap  | V   |  | 57 ~ 79     | 97 ~ 112    | 64 ~ 81     | 99 ~ 114    | 157 ~ 172   | 139 ~ 153   |             |             |
| Avg. Linear Feedrate | ALF |  | 348.0       | 224.9       | 164.3       | 117.4       | 91.1        | 74.6        | 63.3        | 55.0        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 10mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                   | Skim2                 | Skim3                 | Skim4                    | Skim5                   | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-------------------------|-----------------------|-----------------------|--------------------------|-------------------------|-------|-------|
| E-pack Number      | Eno | 941                   | 10211                 | 10212                   | 10213                 | 10214                 | 10215                    | 10216                   | 10217 | 10218 |
| Power Supply       | PS  | RH                    | RL                    | KL                      | RL                    | LC                    | LC                       | LC                      | DFS   | DFS   |
| Servo              | SV  | NM                    | NM                    | NM                      | NM                    | SL                    | SL                       | SL                      | NM    | NM    |
| Voltage Open       | Vo  | 7                     | 4                     | 7                       | 4                     | 10                    | 14                       | 12                      | 13    | 11    |
| Power Setting      | IP  | 6.0                   | 10.0                  | 8.0                     | 7.0                   | 2.5                   | 2.5                      | 2.0                     | 1.0   | 1.0   |
| IP adjust          | ΔIP | 11                    | 12                    | 10                      | 10                    |                       |                          |                         |       |       |
| Off Time           | OFF | 6                     | 3                     | 3                       | 10                    | 10                    | 4                        | 3                       | 13    | 13    |
| Stabilizer A       | SA  | 3                     | 6                     | 5                       | 4                     | 2                     | 1                        | 1                       | 6     | 6     |
| Stabilizer B       | SB  | 8                     | 10                    | 12                      | 10                    | 10                    | 8                        | 8                       | 1     | 2     |
| Stabilizer C       | SC  | 7                     | 3                     | 1                       | 1                     | 1                     | 1                        | 1                       | 1     | 1     |
| Stabilizer E       | SE  | 4                     | 4                     | 1                       | 1                     | 1                     | 1                        | 1                       | 1     | 1     |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 100.0<br>(98.0 ~ 102.0) | 60.0<br>(58.0 ~ 62.0) | 80.0<br>(78.0 ~ 82.0) | 120.0<br>(118.0 ~ 122.0) | 100.0<br>(98.0 ~ 102.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                     | OFF                   | OFF                   | ON                       | ON                      | OFF   | OFF   |
| Digital AE         | DAE | OFF                   | OFF                   | ON                      | OFF                   | OFF                   | OFF                      | OFF                     | OFF   | OFF   |
| Wire Speed         | WS  | 8                     | 11                    | 12                      | 10                    | 10                    | 10                       | 10                      | 12    | 12    |
| Wire Tension       | WT  | 6                     | 8                     | 10                      | 10                    | 10                    | 10                       | 10                      | 8     | 8     |
| Pre-Tension        | PT  | 14                    | 14                    | 14                      | 14                    | 14                    | 14                       | 14                      | 14    | 14    |
| Flow Balance       | FB  | NM                    | NM                    | NM                      | NM                    | NM                    | NM                       | NM                      | NM    | NM    |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                       | 4                     | 4                     | 4                        | 4                       | 4     | 4     |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                      | 10                    | 10                    | 10                       | 10                      | 10    | 10    |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                      | 20                    | 20                    | 20                       | 20                      | 0     | 0     |
| Feedrate Address   | FA  | 2.0                   | 2.0                   | 5.0                     | 5.0                   | 7.0                   | 7.0                      | 7.0                     | 7.0   | 7.0   |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                     | 1.0                   | 1.0                   | 1.0                      | 1.0                     | 1.0   | 1.0   |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                     | 1.0                   | 1.0                   | 1.0                      | 1.0                     | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 172.0 | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 209.0 | 144.0 | 113.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 223.0 | 158.0 | 127.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 226.0 | 161.0 | 130.0 | 110.0 | 107.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 228.0 | 163.0 | 132.0 | 112.0 | 109.0 | 108.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 229.0 | 164.0 | 133.0 | 113.0 | 110.0 | 109.0 | 104.0 | ----- |
| Rough & 7 Skims    | ----- | 230.0 | 165.0 | 134.0 | 114.0 | 111.0 | 110.0 | 105.0 | 103.0 |
| Stepping Increment | ----- | ----- | 65.0  | 31.0  | 20.0  | 3.0   | 1.0   | 5.0   | 2.0   |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 3.6 ~ 4.4   | 6.6 ~ 8.1   | 8.2 ~ 10.0  | 7.4 ~ 8.2   | 6.5 ~ 7.2   | 6.5 ~ 7.1   | 7.0 ~ 7.0   |
| Average Voltage Gap  | V   |  | 33 ~ 50     | 92 ~ 107    | 54 ~ 69     | 93 ~ 107    | 131 ~ 144   | 122 ~ 135   |             |
| Avg. Linear Feedrate | ALF |  | 240.0       | 155.4       | 121.0       | 96.1        | 77.9        | 65.4        | 56.6        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 20.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 941                   | 10221                 | 10222                 | 10223                 | 10224                 | 10225                 | 10226                 | 10227 | 10228 | 10229 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 7                     | 4                     | 10                    | 14                    | 12                    | 15    | 13    | 11    |
| Power Setting      | IP       | 6.0                   | 10.0                  | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 6                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 8                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     | 7     | 1     | 2     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 60.0<br>(58.0 ~ 62.0) | 35.0<br>(32.0 ~ 38.0) | 82.0<br>(80.0 ~ 84.0) | 45.0<br>(43.0 ~ 47.0) | 70.0<br>(68.0 ~ 72.0) | 85.0<br>(83.0 ~ 87.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 12                    | 12                    | 10                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    | 8     | 8     | 8     |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 2.0                   | 2.0                   | 5.0                   | 5.0                   | 7.0                   | 7.0                   | 7.0                   | 6.5   | 6.5   | 6.5   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 137.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 170.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 199.0 | 134.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 213.0 | 148.0 | 122.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 217.0 | 152.0 | 126.0 | 108.0 | 105.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 219.0 | 154.0 | 128.0 | 110.0 | 107.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 220.0 | 155.0 | 129.0 | 111.0 | 108.0 | 107.0 | 104.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 220.0 | 155.0 | 129.0 | 111.0 | 108.0 | 107.0 | 104.0 | 103.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 221.0 | 156.0 | 130.0 | 112.0 | 109.0 | 108.0 | 105.0 | 104.0 | 103.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 26.0  | 18.0  | 3.0   | 1.0   | 3.0   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 2.8 ~ 3.4   | 6.2 ~ 7.6   | 6.4 ~ 7.8   | 6.6 ~ 7.3   | 6.6 ~ 7.3   | 6.5 ~ 7.1   | 6.5 ~ 6.5   | 6.5 ~ 6.5   | 6.5 ~ 6.5   |
| Average Voltage Gap  | V   |  | 27 ~ 45     | 76 ~ 90     | 36 ~ 52     | 69 ~ 81     | 86 ~ 98     | 71 ~ 84     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 186.0       | 128.3       | 98.6        | 79.8        | 67.0        | 57.5        | 50.1        | 44.4        | 39.9        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 30.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 942                   | 10231                 | 10232                 | 10233                 | 10234                 | 10235                 | 10236                 | 10237 | 10238 | 10239 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 7                     | 4                     | 10                    | 14                    | 12                    | 15    | 13    | 11    |
| Power Setting      | IP       | 7.0                   | 10.0                  | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 6                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 8                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     | 7     | 1     | 2     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 37.0<br>(34.0 ~ 40.0) | 78.0<br>(76.0 ~ 80.0) | 45.0<br>(43.0 ~ 47.0) | 67.0<br>(65.0 ~ 69.0) | 65.0<br>(63.0 ~ 67.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 12                    | 12                    | 10                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    | 8     | 8     | 8     |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 40                    | 40                    | 40                    | 30                    | 30                    | 30                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 1.0                   | 1.6                   | 4.2                   | 4.0                   | 6.0                   | 6.0                   | 6.0                   | 6.0   | 6.0   | 6.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 138.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 170.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 198.0 | 133.0 | 110.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 210.0 | 145.0 | 122.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 213.0 | 148.0 | 125.0 | 109.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 214.0 | 149.0 | 126.0 | 110.0 | 107.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 216.0 | 151.0 | 128.0 | 112.0 | 109.0 | 108.0 | 105.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 217.0 | 152.0 | 129.0 | 113.0 | 110.0 | 109.0 | 106.0 | 105.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 217.0 | 152.0 | 129.0 | 113.0 | 110.0 | 109.0 | 106.0 | 105.0 | 104.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 23.0  | 16.0  | 3.0   | 1.0   | 3.0   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 2.2 ~ 2.7   | 5.3 ~ 6.6   | 4.8 ~ 5.9   | 5.5 ~ 6.2   | 5.5 ~ 6.5   | 6.0 ~ 6.6   | 6.0 ~ 6.0   | 6.0 ~ 6.0   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 27 ~ 43     | 71 ~ 86     | 36 ~ 53     | 66 ~ 79     | 78 ~ 87     | 61 ~ 75     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 147.0       | 104.1       | 78.6        | 64.2        | 54.5        | 47.6        | 42.1        | 37.7        | 34.1        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.98 ~ 3.30 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 40.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 942                   | 10241                 | 10242                 | 10243                 | 10244                 | 10245                 | 10246                 | 10247 | 10248 | 10249 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 7                     | 4                     | 10                    | 14                    | 12                    | 15    | 13    | 11    |
| Power Setting      | IP       | 7.0                   | 10.0                  | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 6                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 8                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     | 7     | 1     | 2     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 73.0<br>(71.0 ~ 75.0) | 45.0<br>(43.0 ~ 47.0) | 65.0<br>(63.0 ~ 67.0) | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 12                    | 12                    | 10                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    | 8     | 8     | 8     |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 40                    | 40                    | 40                    | 40                    | 40                    | 40                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 1.0                   | 1.2                   | 3.5                   | 3.0                   | 6.0                   | 6.0                   | 6.0                   | 5.0   | 5.0   | 5.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 140.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 169.0 | 104.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 194.0 | 129.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 206.0 | 141.0 | 121.0 | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 208.0 | 143.0 | 123.0 | 109.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 210.0 | 145.0 | 125.0 | 111.0 | 108.0 | 106.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 213.0 | 148.0 | 128.0 | 114.0 | 111.0 | 109.0 | 106.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 214.0 | 149.0 | 129.0 | 115.0 | 112.0 | 110.0 | 107.0 | 106.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 214.0 | 149.0 | 129.0 | 115.0 | 112.0 | 110.0 | 107.0 | 106.0 | 105.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 20.0  | 14.0  | 3.0   | 2.0   | 3.0   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.6 ~ 2.0   | 4.5 ~ 5.6   | 3.3 ~ 4.1   | 5.5 ~ 6.1   | 5.5 ~ 6.1   | 5.5 ~ 6.1   | 5.0 ~ 5.0   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 28 ~ 42     | 68 ~ 83     | 37 ~ 54     | 63 ~ 77     | 68 ~ 82     | 53 ~ 68     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 108.0       | 79.6        | 58.6        | 50.2        | 43.8        | 38.9        | 34.5        | 30.9        | 28.0        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.98 ~ 3.30 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 50.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 943                   | 10251                 | 10252                 | 10253                 | 10254                 | 10255                 | 10256                 | 10257 | 10258 | 10259 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 7                     | 4                     | 10                    | 14                    | 12                    | 15    | 13    | 11    |
| Power Setting      | IP       | 7.0                   | 10.0                  | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 6                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     | 7     | 1     | 2     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 37.0<br>(34.0 ~ 40.0) | 73.0<br>(71.0 ~ 75.0) | 46.0<br>(44.0 ~ 48.0) | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 12                    | 12                    | 10                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    | 8     | 8     | 8     |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 40                    | 40                    | 40                    | 40                    | 40                    | 40                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.7                   | 1.1                   | 3.2                   | 2.7                   | 6.0                   | 6.0                   | 6.0                   | 4.0   | 4.0   | 4.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 142.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 170.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 196.0 | 131.0 | 111.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 207.0 | 142.0 | 122.0 | 108.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 209.0 | 144.0 | 124.0 | 110.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 211.0 | 146.0 | 126.0 | 112.0 | 110.0 | 108.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 212.0 | 147.0 | 127.0 | 113.0 | 111.0 | 109.0 | 107.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 213.0 | 148.0 | 128.0 | 114.0 | 112.0 | 110.0 | 108.0 | 107.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 213.5 | 148.5 | 128.5 | 114.5 | 112.5 | 110.5 | 108.5 | 107.5 | 106.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 20.0  | 14.0  | 2.0   | 2.0   | 2.0   | 1.0   | 1.5   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.2 ~ 1.6   | 3.7 ~ 4.7   | 2.6 ~ 3.2   | 5.5 ~ 6.1   | 5.5 ~ 6.1   | 5.5 ~ 6.1   | 4.0 ~ 4.0   | 4.0 ~ 4.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 26 ~ 42     | 68 ~ 83     | 38 ~ 56     | 61 ~ 73     | 64 ~ 78     | 50 ~ 64     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 84.0        | 63.0        | 46.3        | 40.8        | 36.5        | 33.1        | 29.1        | 25.9        | 23.4        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.98 ~ 3.30 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 60.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 943                   | 10261                 | 10262                 | 10263                 | 10264                 | 10265                 | 10266                 | 10267 | 10268 | 10269 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 7                     | 4                     | 10                    | 14                    | 12                    | 15    | 13    | 11    |
| Power Setting      | IP       | 7.0                   | 10.0                  | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 6                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     | 7     | 1     | 2     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(32.0 ~ 38.0) | 73.0<br>(71.0 ~ 75.0) | 48.0<br>(46.0 ~ 50.0) | 55.0<br>(53.0 ~ 57.0) | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 12                    | 12                    | 10                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    | 8     | 8     | 8     |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 40                    | 40                    | 40                    | 40                    | 40                    | 40                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.7                   | 1.0                   | 3.0                   | 2.5                   | 6.0                   | 6.0                   | 6.0                   | 4.0   | 4.0   | 4.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 144.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 170.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 198.0 | 133.0 | 113.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 208.0 | 143.0 | 123.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 211.0 | 146.0 | 126.0 | 112.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 210.0 | 145.0 | 125.0 | 111.0 | 109.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 214.0 | 149.0 | 129.0 | 115.0 | 113.0 | 111.0 | 109.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 214.0 | 149.0 | 129.0 | 115.0 | 113.0 | 111.0 | 109.0 | 108.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 214.5 | 149.5 | 129.5 | 115.5 | 113.5 | 111.5 | 109.5 | 108.5 | 107.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 20.0  | 14.0  | 2.0   | 2.0   | 2.0   | 1.0   | 1.5   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.9 ~ 1.1   | 3.1 ~ 3.9   | 1.9 ~ 2.3   | 5.5 ~ 6.1   | 5.5 ~ 6.1   | 5.5 ~ 6.1   | 4.0 ~ 4.0   | 4.0 ~ 4.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 24 ~ 43     | 68 ~ 84     | 39 ~ 57     | 60 ~ 71     | 61 ~ 73     | 46 ~ 60     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 60.0        | 46.7        | 34.1        | 31.0        | 28.5        | 26.3        | 23.7        | 21.6        | 19.8        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.98 ~ 3.30 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 70.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 944                   | 10271                 | 10272                 | 10273                 | 10274                 | 10275                 | 10276                 | 10277 | 10278 | 10279 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 7                     | 4                     | 10                    | 14                    | 12                    | 15    | 13    | 11    |
| Power Setting      | IP       | 7.0                   | 10.0                  | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 6                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     | 7     | 1     | 2     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(32.0 ~ 38.0) | 73.0<br>(71.0 ~ 75.0) | 46.0<br>(44.0 ~ 48.0) | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(38.0 ~ 42.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 12                    | 12                    | 10                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    | 8     | 8     | 8     |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 40                    | 40                    | 40                    | 40                    | 40                    | 40                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.6                   | 1.0                   | 3.0                   | 2.5                   | 6.0                   | 6.0                   | 6.0                   | 4.0   | 4.0   | 4.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 144.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 172.0 | 107.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 200.0 | 135.0 | 115.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 208.0 | 143.0 | 123.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 210.0 | 145.0 | 125.0 | 111.0 | 109.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 210.0 | 145.0 | 125.0 | 111.0 | 109.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 213.0 | 148.0 | 128.0 | 114.0 | 112.0 | 110.0 | 108.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 212.5 | 147.5 | 127.5 | 113.5 | 111.5 | 109.5 | 107.5 | 106.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 214.0 | 149.0 | 129.0 | 115.0 | 113.0 | 111.0 | 109.0 | 107.5 | 106.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 20.0  | 14.0  | 2.0   | 2.0   | 2.0   | 1.5   | 1.5   |       |

| RESULTS              |     |             |             |             |             |             |             |             |             |             |  |
|----------------------|-----|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|--|
| Feedrate Cutting     | FC  | 0.7 ~ 0.9   | 2.6 ~ 3.4   | 1.8 ~ 2.2   | 5.5 ~ 6.1   | 5.5 ~ 6.1   | 5.5 ~ 6.1   | 4.0 ~ 4.0   | 4.0 ~ 4.0   | 4.0 ~ 4.0   |  |
| Average Voltage Gap  | V   | 24 ~ 42     | 67 ~ 82     | 36 ~ 55     | 55 ~ 65     | 55 ~ 66     | 43 ~ 55     |             |             |             |  |
| Avg. Linear Feedrate | ALF | 48.0        | 37.9        | 28.8        | 26.6        | 24.7        | 23.1        | 21.0        | 19.4        | 17.9        |  |
| Surface Finish(u m)  | Rz  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |  |
|                      | Ra  | 2.25 ~ 3.75 | 1.98 ~ 3.30 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | WC-Co         | 80.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 944                   | 10281                 | 10282                 | 10283                 | 10284                 | 10285                 | 10286                 | 10287 | 10288 | 10289 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 7                     | 4                     | 10                    | 14                    | 12                    | 15    | 13    | 11    |
| Power Setting      | IP       | 7.0                   | 10.0                  | 8.0                   | 7.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 6                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     | 7     | 1     | 2     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(32.0 ~ 38.0) | 73.0<br>(71.0 ~ 75.0) | 43.0<br>(41.0 ~ 45.0) | 45.0<br>(43.0 ~ 47.0) | 30.0<br>(28.0 ~ 32.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 12                    | 12                    | 10                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 6                     | 8                     | 10                    | 10                    | 10                    | 10                    | 10                    | 8     | 8     | 8     |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 60                    | 60                    | 60                    | 40                    | 40                    | 40                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.6                   | 1.0                   | 3.0                   | 2.5                   | 6.0                   | 6.0                   | 6.0                   | 4.0   | 4.0   | 4.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 145.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 174.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 203.0 | 138.0 | 118.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 208.0 | 143.0 | 123.0 | 109.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 210.0 | 145.0 | 125.0 | 111.0 | 109.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 210.0 | 145.0 | 125.0 | 111.0 | 109.0 | 107.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 212.0 | 147.0 | 127.0 | 113.0 | 111.0 | 109.0 | 107.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 212.0 | 147.0 | 127.0 | 113.0 | 111.0 | 109.0 | 107.0 | 105.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 213.5 | 148.5 | 128.5 | 114.5 | 112.5 | 110.5 | 108.5 | 106.5 | 105.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 20.0  | 14.0  | 2.0   | 2.0   | 2.0   | 2.0   | 1.5   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.6 ~ 0.8   | 2.3 ~ 2.9   | 1.7 ~ 2.0   | 5.6 ~ 6.1   | 5.5 ~ 6.1   | 5.5 ~ 6.1   | 4.0 ~ 4.0   | 4.0 ~ 4.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 25 ~ 41     | 67 ~ 81     | 33 ~ 52     | 49 ~ 61     | 49 ~ 61     | 39 ~ 50     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 42.0        | 33.1        | 25.5        | 23.8        | 22.2        | 20.9        | 19.2        | 17.8        | 16.6        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.98 ~ 3.30 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.10BS            | STEEL         | DFS   |

Thickness 5 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 931             | KL  | 1.0 |        |       |       |       |       |       |       |     |           |
| 1                 | 11011           | RH  | 2.4 | 57.0   | 125.0 | 162.0 | 180.0 | 188.0 | 192.0 | 195.0 |     | 0.0       |
| 2                 | 11012           | RL  | 5.0 | -      | 55.0  | 92.0  | 110.0 | 118.0 | 122.0 | 125.0 |     | 70.0      |
| 3                 | 11013           | RL  | 5.0 | -      | -     | 57.0  | 75.0  | 83.0  | 87.0  | 90.0  |     | 35.0      |
| 4                 | 11014           | LC  | 7.0 | -      | -     | -     | 56.0  | 64.0  | 68.0  | 71.0  |     | 19.0      |
| 5                 | 11015           | LA  | 7.0 | -      | -     | -     | -     | 58.0  | 62.0  | 65.0  |     | 6.0       |
| 6                 | 11016           | DFS | 5.0 | -      | -     | -     | -     | -     | 55.0  | 58.0  |     | 7.0       |
| 7                 | 11017           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | 55.0  |     | 3.0       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 11.0  | 3.5   | 2.0   | 1.8   | 1.2   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.50  | 0.48  | 0.28  | 0.20  | 0.15  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 931             | KL  | 1.0 |        |       |       |       |       |       |       |     |           |
| 1                 | 11021           | RH  | 1.3 | 62.0   | 114.0 | 144.0 | 161.0 | 168.0 | 172.0 | 173.0 |     | 0.0       |
| 2                 | 11022           | RL  | 4.5 | -      | 54.0  | 84.0  | 101.0 | 108.0 | 112.0 | 113.0 |     | 60.0      |
| 3                 | 11023           | RL  | 4.5 | -      | -     | 54.0  | 71.0  | 78.0  | 82.0  | 83.0  |     | 30.0      |
| 4                 | 11024           | LC  | 7.0 | -      | -     | -     | 52.0  | 59.0  | 63.0  | 64.0  |     | 19.0      |
| 5                 | 11025           | LA  | 7.0 | -      | -     | -     | -     | 53.0  | 57.0  | 58.0  |     | 6.0       |
| 6                 | 11026           | DFS | 5.0 | -      | -     | -     | -     | -     | 55.0  | 56.0  |     | 2.0       |
| 7                 | 11027           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | 54.0  |     | 2.0       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 11.0  | 3.5   | 2.0   | 1.8   | 1.2   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.50  | 0.48  | 0.28  | 0.20  | 0.15  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |     |     | Offset |      |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 931             | KL  | 1.0 |        |      |       |       |       |       |       |     |           |
| 1                 | 11031           | RL  | 0.9 | 62.0   | 97.0 | 118.0 | 130.0 | 134.0 | 138.0 | 140.0 |     | 0.0       |
| 2                 | 11032           | RL  | 4.0 | -      | 52.0 | 73.0  | 85.0  | 89.0  | 93.0  | 95.0  |     | 45.0      |
| 3                 | 11033           | RL  | 4.0 | -      | -    | 53.0  | 65.0  | 69.0  | 73.0  | 75.0  |     | 20.0      |
| 4                 | 11034           | LC  | 7.0 | -      | -    | -     | 56.0  | 60.0  | 64.0  | 66.0  |     | 9.0       |
| 5                 | 11035           | LA  | 7.0 | -      | -    | -     | -     | 54.0  | 58.0  | 60.0  |     | 6.0       |
| 6                 | 11036           | DFS | 5.0 | -      | -    | -     | -     | -     | 55.0  | 57.0  |     | 3.0       |
| 7                 | 11037           | DFS | 5.0 | -      | -    | -     | -     | -     | -     | 55.0  |     | 2.0       |
| 8                 |                 |     |     | -      | -    | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   | 1.8   | 1.2   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  | 0.20  | 0.15  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.10BS            | STEEL         | DFS   |

Thickness 30 mm

| No.               | Cutting process |     |     | Offset |      |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 932             | KL  | 0.6 |        |      |       |       |       |       |       |     |           |
| 1                 | 11041           | RL  | 0.7 | 67.0   | 99.0 | 119.0 | 130.0 | 134.0 | 138.0 | 139.0 |     | 0.0       |
| 2                 | 11042           | RL  | 3.8 | -      | 54.0 | 74.0  | 85.0  | 89.0  | 93.0  | 94.0  |     | 45.0      |
| 3                 | 11043           | RL  | 3.8 | -      | -    | 54.0  | 65.0  | 69.0  | 73.0  | 74.0  |     | 20.0      |
| 4                 | 11044           | LC  | 7.0 | -      | -    | -     | 56.0  | 60.0  | 64.0  | 65.0  |     | 9.0       |
| 5                 | 11045           | LA  | 7.0 | -      | -    | -     | -     | 54.0  | 58.0  | 59.0  |     | 6.0       |
| 6                 | 11046           | DFS | 5.0 | -      | -    | -     | -     | -     | 55.0  | 56.0  |     | 3.0       |
| 7                 | 11047           | DFS | 4.0 | -      | -    | -     | -     | -     | -     | 54.0  |     | 2.0       |
| 8                 |                 |     |     | -      | -    | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   | 1.8   | 1.2   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  | 0.20  | 0.15  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |     |     | Offset |      |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 932             | KL  | 0.6 |        |      |       |       |       |       |       |     |           |
| 1                 | 11051           | RL  | 0.5 | 73.0   | 98.0 | 121.0 | 131.0 | 134.0 | 137.0 | 138.0 |     | 0.0       |
| 2                 | 11052           | RL  | 3.6 | -      | 53.0 | 76.0  | 86.0  | 89.0  | 92.0  | 93.0  |     | 45.0      |
| 3                 | 11053           | RL  | 3.6 | -      | -    | 56.0  | 66.0  | 69.0  | 72.0  | 73.0  |     | 20.0      |
| 4                 | 11054           | LC  | 7.0 | -      | -    | -     | 57.0  | 60.0  | 63.0  | 64.0  |     | 9.0       |
| 5                 | 11055           | LA  | 7.0 | -      | -    | -     | -     | 54.0  | 57.0  | 58.0  |     | 6.0       |
| 6                 | 11056           | DFS | 5.0 | -      | -    | -     | -     | -     | 54.0  | 55.0  |     | 3.0       |
| 7                 | 11057           | DFS | 4.0 | -      | -    | -     | -     | -     | -     | 53.0  |     | 2.0       |
| 8                 |                 |     |     | -      | -    | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   | 1.8   | 1.2   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  | 0.20  | 0.15  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | STEEL         | 5mm                | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                    | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 11011                 | 11012                 | 11013                 | 11014                    | 11015                    | 11016 | 11017 |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                       | LA                       | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                       | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                       | 13                       | 16    | 9     |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 3.0                      | 2.0                      | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                          |                          |       |       |       |
| Off Time           | OFF | 1                     | 3                     | 4                     | 4                     | 1                        | 1                        | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 2                     | 1                     | 1                     | 1                        | 1                        | 5     | 5     |       |
| Stabilizer B       | SB  | 16                    | 12                    | 4                     | 4                     | 1                        | 1                        | 6     | 6     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                        | 1     | 1     |       |
| Stabilizer E       | SE  | 5                     | 4                     | 1                     | 1                     | 1                        | 1                        | 1     | 1     |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 50.0<br>(47.0 ~ 53.0) | 52.0<br>(50.0 ~ 54.0) | 50.0<br>(48.0 ~ 52.0) | 140.0<br>(138.0 ~ 142.0) | 125.0<br>(123.0 ~ 127.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                       | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                      | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 10                       | 10                       | 10    | 10    |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                        | 3                        | 3     | 3     |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                       | 13                       | 13    | 13    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                       | NM    | NM    |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 6                     | 4                        | 4                        | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                       | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                        | 0     | 0     |       |
| Feedrate Address   | FA  | 1.0                   | 2.4                   | 5.0                   | 5.0                   | 7.0                      | 7.0                      | 5.0   | 5.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 57.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 125.0 | 55.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 162.0 | 92.0  | 57.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 180.0 | 110.0 | 75.0  | 56.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 188.0 | 118.0 | 83.0  | 64.0  | 58.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 192.0 | 122.0 | 87.0  | 68.0  | 62.0  | 55.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 195.0 | 125.0 | 90.0  | 71.0  | 65.0  | 58.0  | 55.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 70.0  | 35.0  | 19.0  | 6.0   | 7.0   | 3.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 4.5 ~ 5.6   | 6.2 ~ 7.6   | 7.3 ~ 8.9   | 6.8 ~ 7.5   | 6.8 ~ 7.6   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 43 ~ 64     | 46 ~ 75     | 66 ~ 84     | 178 ~ 189   | 170 ~ 181   |             |             |
| Avg. Linear Feedrate | ALF |  | 303.0       | 175.0       | 128.6       | 99.0        | 80.5        | 63.5        | 52.4        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | STEEL         | 10mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                    | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 11021                 | 11022                 | 11023                 | 11024                    | 11025                    | 11026 | 11027 |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                       | LA                       | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                       | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                       | 13                       | 16    | 9     |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 3.0                      | 2.0                      | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                          |                          |       |       |       |
| Off Time           | OFF | 1                     | 3                     | 4                     | 4                     | 1                        | 1                        | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 2                     | 1                     | 1                     | 1                        | 1                        | 5     | 5     |       |
| Stabilizer B       | SB  | 16                    | 12                    | 4                     | 4                     | 1                        | 1                        | 6     | 6     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                        | 1     | 1     |       |
| Stabilizer E       | SE  | 5                     | 4                     | 1                     | 1                     | 1                        | 1                        | 1     | 1     |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 57.0<br>(54.0 ~ 60.0) | 52.0<br>(50.0 ~ 54.0) | 50.0<br>(48.0 ~ 52.0) | 140.0<br>(138.0 ~ 142.0) | 125.0<br>(123.0 ~ 127.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                       | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                      | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 10                       | 10                       | 10    | 10    |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                        | 3                        | 3     | 3     |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                       | 13                       | 13    | 13    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                       | NM    | NM    |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 6                     | 4                        | 4                        | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                       | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                        | 0     | 0     |       |
| Feedrate Address   | FA  | 1.0                   | 1.3                   | 4.5                   | 4.5                   | 7.0                      | 7.0                      | 5.0   | 5.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 62.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 114.0 | 54.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 144.0 | 84.0  | 54.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 161.0 | 101.0 | 71.0  | 52.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 168.0 | 108.0 | 78.0  | 59.0  | 53.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 172.0 | 112.0 | 82.0  | 63.0  | 57.0  | 55.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 173.0 | 113.0 | 83.0  | 64.0  | 58.0  | 56.0  | 54.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 30.0  | 19.0  | 6.0   | 2.0   | 2.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 2.5 ~ 3.0   | 4.8 ~ 5.9   | 9.4 ~ 10.9  | 6.6 ~ 7.3   | 6.6 ~ 7.3   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 46 ~ 68     | 43 ~ 58     | 49 ~ 63     | 149 ~ 159   | 128 ~ 138   |             |             |
| Avg. Linear Feedrate | ALF |  | 165.0       | 109.0       | 92.4        | 75.7        | 64.0        | 52.8        | 44.9        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | STEEL         | 20mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 11031                 | 11032                 | 11033                 | 11034                 | 11035                 | 11036 | 11037 |       |
| Power Supply       | PS  | KL                    | RL                    | RL                    | RL                    | LC                    | LA                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 13                    | 16    | 10    |       |
| Power Setting      | IP  | 4.0                   | 5.0                   | 5.0                   | 4.0                   | 3.0                   | 2.0                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 15                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 1                     | 4                     | 4                     | 4                     | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 16                    | 12                    | 4                     | 4                     | 1                     | 1                     | 7     | 7     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     | 1     | 1     |       |
| Stabilizer E       | SE  | 5                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 52.0<br>(49.0 ~ 55.0) | 42.0<br>(40.0 ~ 44.0) | 35.0<br>(33.0 ~ 37.0) | 80.0<br>(78.0 ~ 82.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 10                    | 10                    | 10    | 10    |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                     | 3                     | 3     | 3     |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                    | 13                    | 13    | 13    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 6                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 10                    | 10                    | 10                    | 10                    | 0     | 0     |       |
| Feedrate Address   | FA  | 1.0                   | 0.9                   | 4.0                   | 4.0                   | 7.0                   | 7.0                   | 5.0   | 5.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 62.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 97.0  | 52.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 118.0 | 73.0  | 53.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 130.0 | 85.0  | 65.0  | 56.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 134.0 | 89.0  | 69.0  | 60.0  | 54.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 138.0 | 93.0  | 73.0  | 64.0  | 58.0  | 55.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 140.0 | 95.0  | 75.0  | 66.0  | 60.0  | 57.0  | 55.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 45.0  | 20.0  | 9.0   | 6.0   | 3.0   | 2.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.2 ~ 1.6   | 7.0 ~ 8.6   | 8.6 ~ 10.5  | 7.0 ~ 7.5   | 7.0 ~ 7.5   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 46 ~ 63     | 35 ~ 50     | 36 ~ 51     | 130 ~ 142   | 110 ~ 123   |             |             |
| Avg. Linear Feedrate | ALF |  | 84.0        | 71.2        | 63.3        | 55.3        | 49.1        | 42.2        | 37.0        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | STEEL         | 30mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 932                   | 11041                 | 11042                 | 11043                 | 11044                 | 11045                 | 11046 | 11047 |       |
| Power Supply       | PS  | KL                    | RL                    | RL                    | RL                    | LC                    | LA                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 13                    | 16    | 10    |       |
| Power Setting      | IP  | 4.0                   | 5.0                   | 5.0                   | 4.0                   | 3.0                   | 2.0                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 15                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 1                     | 4                     | 4                     | 4                     | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 15                    | 12                    | 4                     | 4                     | 1                     | 1                     | 7     | 7     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     | 1     | 1     |       |
| Stabilizer E       | SE  | 5                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 56.0<br>(53.0 ~ 59.0) | 42.0<br>(40.0 ~ 44.0) | 35.0<br>(33.0 ~ 37.0) | 80.0<br>(78.0 ~ 82.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 10                    | 10                    | 10    | 10    |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                     | 3                     | 3     | 3     |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                    | 13                    | 13    | 13    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 6                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 10                    | 10                    | 10                    | 10                    | 0     | 0     |       |
| Feedrate Address   | FA  | 0.6                   | 0.7                   | 3.8                   | 3.8                   | 7.0                   | 7.0                   | 5.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 67.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 99.0  | 54.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 119.0 | 74.0  | 54.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 130.0 | 85.0  | 65.0  | 56.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 134.0 | 89.0  | 69.0  | 60.0  | 54.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 138.0 | 93.0  | 73.0  | 64.0  | 58.0  | 55.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 139.0 | 94.0  | 74.0  | 65.0  | 59.0  | 56.0  | 54.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 45.0  | 20.0  | 9.0   | 6.0   | 3.0   | 2.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.9 ~ 1.2   | 5.4 ~ 6.6   | 7.3 ~ 9.0   | 7.0 ~ 7.5   | 7.0 ~ 7.5   | 5.0 ~ 5.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 46 ~ 63     | 33 ~ 52     | 32 ~ 47     | 110 ~ 125   | 98 ~ 115    |             |             |
| Avg. Linear Feedrate | ALF |  | 63.0        | 53.6        | 48.3        | 43.5        | 39.5        | 34.9        | 30.5        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | STEEL         | 40mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 932                   | 11051                 | 11052                 | 11053                 | 11054                 | 11055                 | 11056 | 11057 |       |
| Power Supply       | PS  | KL                    | RL                    | RL                    | RL                    | LC                    | LA                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 13                    | 16    | 10    |       |
| Power Setting      | IP  | 4.0                   | 5.0                   | 5.0                   | 4.0                   | 3.0                   | 2.0                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 15                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 1                     | 4                     | 4                     | 4                     | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 15                    | 12                    | 4                     | 4                     | 1                     | 1                     | 7     | 7     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     | 1     | 1     |       |
| Stabilizer E       | SE  | 5                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 60.0<br>(57.0 ~ 63.0) | 42.0<br>(40.0 ~ 44.0) | 35.0<br>(33.0 ~ 37.0) | 80.0<br>(78.0 ~ 82.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 10                    | 12                    | 12                    | 10                    | 10                    | 10    | 10    |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                     | 3                     | 3     | 3     |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                    | 13                    | 13    | 13    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 6                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 20                    | 20                    | 20                    | 20                    | 0     | 0     |       |
| Feedrate Address   | FA  | 0.6                   | 0.5                   | 3.6                   | 3.6                   | 7.0                   | 7.0                   | 5.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 73.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 98.0  | 53.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 121.0 | 76.0  | 56.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 131.0 | 86.0  | 66.0  | 57.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 134.0 | 89.0  | 69.0  | 60.0  | 54.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 137.0 | 92.0  | 72.0  | 63.0  | 57.0  | 54.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 138.0 | 93.0  | 73.0  | 64.0  | 58.0  | 55.0  | 53.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 45.0  | 20.0  | 9.0   | 6.0   | 3.0   | 2.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.6 ~ 0.8   | 3.8 ~ 4.6   | 6.1 ~ 7.5   | 7.0 ~ 7.5   | 7.0 ~ 7.5   | 5.0 ~ 5.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 49 ~ 62     | 32 ~ 54     | 29 ~ 45     | 97 ~ 110    | 83 ~ 95     |             |             |
| Avg. Linear Feedrate | ALF |  | 42.0        | 36.0        | 33.1        | 30.7        | 28.7        | 26.2        | 23.6        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.10BS            | WC-Co         | DFS   |

Thickness 5 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 931             | KL  | 1.0 |        |       |       |       |       |       |       |     |           |
| 1                 | 11111           | RH  | 2.0 | 63.0   | 120.0 | 146.0 | 161.0 | 166.0 | 165.0 | 167.0 |     | 0.0       |
| 2                 | 11112           | RL  | 5.0 | -      | 60.0  | 86.0  | 101.0 | 106.0 | 105.0 | 107.0 |     | 60.0      |
| 3                 | 11113           | RL  | 5.0 | -      | -     | 56.0  | 71.0  | 76.0  | 75.0  | 77.0  |     | 30.0      |
| 4                 | 11114           | LC  | 8.0 | -      | -     | -     | 58.0  | 63.0  | 62.0  | 64.0  |     | 13.0      |
| 5                 | 11115           | LA  | 6.0 | -      | -     | -     | -     | 60.0  | 59.0  | 61.0  |     | 3.0       |
| 6                 | 11116           | DFS | 6.0 | -      | -     | -     | -     | -     | 55.0  | 57.0  |     | 4.0       |
| 7                 | 11117           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 53.0  |     | 4.0       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 11.0  | 2.5   | 2.0   | 1.5   | 0.9   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.50  | 0.30  | 0.28  | 0.18  | 0.13  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 931             | KL  | 1.0 |        |       |       |       |       |       |       |     |           |
| 1                 | 11121           | RH  | 1.0 | 55.0   | 114.0 | 138.0 | 151.0 | 157.0 | 158.0 | 159.0 |     | 0.0       |
| 2                 | 11122           | RL  | 4.5 | -      | 54.0  | 78.0  | 91.0  | 97.0  | 98.0  | 99.0  |     | 60.0      |
| 3                 | 11123           | RL  | 4.0 | -      | -     | 53.0  | 66.0  | 72.0  | 73.0  | 74.0  |     | 25.0      |
| 4                 | 11124           | LC  | 8.0 | -      | -     | -     | 53.0  | 59.0  | 60.0  | 61.0  |     | 13.0      |
| 5                 | 11125           | LA  | 6.0 | -      | -     | -     | -     | 56.0  | 57.0  | 58.0  |     | 3.0       |
| 6                 | 11126           | DFS | 6.0 | -      | -     | -     | -     | -     | 53.0  | 54.0  |     | 4.0       |
| 7                 | 11127           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 53.0  |     | 1.0       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 11.0  | 2.5   | 2.0   | 1.5   | 0.9   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.50  | 0.30  | 0.28  | 0.18  | 0.13  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 931             | KL  | 1.0 |        |       |       |       |       |       |       |     |           |
| 1                 | 11131           | RH  | 0.8 | 60.0   | 102.0 | 129.0 | 141.0 | 145.0 | 147.0 | 148.0 |     | 0.0       |
| 2                 | 11132           | RL  | 3.5 | -      | 52.0  | 79.0  | 91.0  | 95.0  | 97.0  | 98.0  |     | 50.0      |
| 3                 | 11133           | RL  | 4.0 | -      | -     | 59.0  | 71.0  | 75.0  | 77.0  | 78.0  |     | 20.0      |
| 4                 | 11134           | LC  | 8.0 | -      | -     | -     | 53.0  | 57.0  | 59.0  | 60.0  |     | 18.0      |
| 5                 | 11135           | LA  | 5.0 | -      | -     | -     | -     | 54.0  | 56.0  | 57.0  |     | 3.0       |
| 6                 | 11136           | DFS | 5.0 | -      | -     | -     | -     | -     | 54.0  | 55.0  |     | 2.0       |
| 7                 | 11137           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | 54.0  |     | 1.0       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 11.0  | 2.5   | 2.0   | 1.5   | 0.9   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.50  | 0.30  | 0.28  | 0.18  | 0.13  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.10BS            | WC-Co         | DFS   |

Thickness 30 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 932             | KL  | 0.6 |        |       |       |       |       |       |       |     |           |
| 1                 | 11141           | RH  | 0.5 | 64.0   | 107.0 | 128.0 | 137.0 | 141.0 | 143.0 | 144.0 |     | 0.0       |
| 2                 | 11142           | RL  | 3.2 | -      | 57.0  | 78.0  | 87.0  | 91.0  | 93.0  | 94.0  |     | 50.0      |
| 3                 | 11143           | RL  | 3.5 | -      | -     | 58.0  | 67.0  | 71.0  | 73.0  | 74.0  |     | 20.0      |
| 4                 | 11144           | LC  | 8.0 | -      | -     | -     | 54.0  | 58.0  | 60.0  | 61.0  |     | 13.0      |
| 5                 | 11145           | LA  | 5.0 | -      | -     | -     | -     | 55.0  | 57.0  | 58.0  |     | 3.0       |
| 6                 | 11146           | DFS | 5.0 | -      | -     | -     | -     | -     | 55.0  | 56.0  |     | 2.0       |
| 7                 | 11147           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | 54.0  |     | 2.0       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 11.0  | 2.5   | 2.0   | 1.5   | 0.9   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.50  | 0.30  | 0.28  | 0.18  | 0.13  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 932             | KL  | 0.6 |        |       |       |       |       |       |       |     |           |
| 1                 | 11151           | RH  | 0.3 | 66.0   | 102.0 | 128.0 | 139.0 | 142.0 | 144.0 | 145.0 |     | 0.0       |
| 2                 | 11152           | RL  | 3.0 | -      | 52.0  | 78.0  | 89.0  | 92.0  | 94.0  | 95.0  |     | 50.0      |
| 3                 | 11153           | RL  | 3.0 | -      | -     | 58.0  | 69.0  | 72.0  | 74.0  | 75.0  |     | 20.0      |
| 4                 | 11154           | LC  | 8.0 | -      | -     | -     | 56.0  | 59.0  | 61.0  | 62.0  |     | 13.0      |
| 5                 | 11155           | LA  | 5.0 | -      | -     | -     | -     | 56.0  | 58.0  | 59.0  |     | 3.0       |
| 6                 | 11156           | DFS | 5.0 | -      | -     | -     | -     | -     | 56.0  | 57.0  |     | 2.0       |
| 7                 | 11157           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | 54.0  |     | 3.0       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 11.0  | 2.5   | 2.0   | 1.5   | 0.9   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.50  | 0.30  | 0.28  | 0.18  | 0.13  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | WC-Co         | 5mm                | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                    | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 11111                 | 11112                 | 11113                 | 11114                    | 11115                    | 11116 | 11117 |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                       | LA                       | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                       | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                       | 15                       | 15    | 10    |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 4.0                   | 3.0                      | 2.0                      | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                          |                          |       |       |       |
| Off Time           | OFF | 1                     | 4                     | 6                     | 6                     | 1                        | 1                        | 8     | 8     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 2                     | 1                     | 1                        | 1                        | 4     | 4     |       |
| Stabilizer B       | SB  | 16                    | 10                    | 6                     | 6                     | 1                        | 1                        | 4     | 2     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                        | 1     | 1     |       |
| Stabilizer E       | SE  | 5                     | 5                     | 1                     | 1                     | 1                        | 1                        | 1     | 1     |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 52.0<br>(49.0 ~ 55.0) | 52.0<br>(50.0 ~ 54.0) | 70.0<br>(68.0 ~ 72.0) | 140.0<br>(138.0 ~ 142.0) | 160.0<br>(158.0 ~ 162.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                       | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                      | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                       | 10                       | 10    | 10    |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                        | 3                        | 3     | 3     |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                       | 13                       | 13    | 13    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                       | NM    | NM    |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 4                     | 4                        | 4                        | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                       | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                        | 0     | 0     |       |
| Feedrate Address   | FA  | 1.0                   | 2.0                   | 5.0                   | 5.0                   | 8.0                      | 6.0                      | 6.0   | 6.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                      | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 63.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 120.0 | 60.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 146.0 | 86.0  | 56.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 161.0 | 101.0 | 71.0  | 58.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 166.0 | 106.0 | 76.0  | 63.0  | 60.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 165.0 | 105.0 | 75.0  | 62.0  | 59.0  | 55.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 167.0 | 107.0 | 77.0  | 64.0  | 61.0  | 57.0  | 53.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 30.0  | 13.0  | 3.0   | 4.0   | 4.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.6 ~ 1.9   | 7.6 ~ 9.3   | 6.1 ~ 7.5   | 7.9 ~ 8.7   | 5.9 ~ 6.5   | 6.0 ~ 6.0   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 41 ~ 63     | 45 ~ 63     | 61 ~ 79     | 168 ~ 180   | 177 ~ 189   |             |             |
| Avg. Linear Feedrate | ALF |  | 105.0       | 87.0        | 71.7        | 62.7        | 53.6        | 46.7        | 41.3        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | WC-Co         | 10mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                   | Skim4                    | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------------------------|--------------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 11121                 | 11122                 | 11123                 | 11124                   | 11125                    | 11126 | 11127 |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                      | LA                       | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                      | SL                       | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                      | 15                       | 15    | 10    |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 4.0                   | 3.0                     | 2.0                      | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                         |                          |       |       |       |
| Off Time           | OFF | 1                     | 4                     | 6                     | 6                     | 1                       | 1                        | 8     | 8     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 2                     | 1                     | 1                       | 1                        | 4     | 4     |       |
| Stabilizer B       | SB  | 16                    | 11                    | 6                     | 6                     | 1                       | 1                        | 4     | 3     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                       | 4                        | 1     | 1     |       |
| Stabilizer E       | SE  | 5                     | 5                     | 1                     | 1                     | 1                       | 1                        | 1     | 1     |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 46.0<br>(43.0 ~ 49.0) | 35.0<br>(33.0 ~ 37.0) | 50.0<br>(48.0 ~ 52.0) | 100.0<br>(98.0 ~ 102.0) | 110.0<br>(108.0 ~ 112.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                      | ON                       | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                     | OFF                      | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                      | 10                       | 10    | 10    |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                       | 3                        | 3     | 3     |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                      | 13                       | 13    | 13    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                      | NM                       | NM    | NM    |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 4                     | 4                       | 4                        | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                      | 10                       | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                       | 0                        | 0     | 0     |       |
| Feedrate Address   | FA  | 1.0                   | 1.0                   | 4.5                   | 4.0                   | 8.0                     | 6.0                      | 6.0   | 6.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                      | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                      | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 55.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 114.0 | 54.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 138.0 | 78.0  | 53.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 151.0 | 91.0  | 66.0  | 53.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 157.0 | 97.0  | 72.0  | 59.0  | 56.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 158.0 | 98.0  | 73.0  | 60.0  | 57.0  | 53.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 159.0 | 99.0  | 74.0  | 61.0  | 58.0  | 54.0  | 53.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 60.0  | 25.0  | 13.0  | 3.0   | 4.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.9 ~ 1.2   | 5.2 ~ 6.4   | 3.4 ~ 4.1   | 7.9 ~ 8.8   | 5.9 ~ 6.6   | 6.0 ~ 6.0   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 30 ~ 59     | 27 ~ 43     | 41 ~ 58     | 136 ~ 147   | 134 ~ 146   |             |             |
| Avg. Linear Feedrate | ALF |  | 63.0        | 53.3        | 43.1        | 39.7        | 35.9        | 32.6        | 29.9        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | WC-Co         | 20mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 931                   | 11131                 | 11132                 | 11133                 | 11134                 | 11135                 | 11136 | 11137 |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                    | LA                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 15                    | 15    | 10    |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 4.0                   | 3.0                   | 2.0                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 1                     | 4                     | 6                     | 6                     | 1                     | 1                     | 8     | 8     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 2                     | 1                     | 1                     | 1                     | 4     | 4     |       |
| Stabilizer B       | SB  | 16                    | 10                    | 6                     | 6                     | 1                     | 1                     | 4     | 3     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     | 1     | 1     |       |
| Stabilizer E       | SE  | 5                     | 5                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 46.0<br>(43.0 ~ 49.0) | 40.0<br>(38.0 ~ 42.0) | 50.0<br>(48.0 ~ 52.0) | 80.0<br>(78.0 ~ 82.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10    | 10    |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                     | 3                     | 3     | 3     |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                    | 13                    | 13    | 13    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 25                    | 25                    | 25                    | 25                    | 25                    | 0     | 0     |       |
| Feedrate Address   | FA  | 1.0                   | 0.8                   | 3.5                   | 4.0                   | 8.0                   | 5.0                   | 5.0   | 5.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 60.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 102.0 | 52.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 129.0 | 79.0  | 59.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 141.0 | 91.0  | 71.0  | 53.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 145.0 | 95.0  | 75.0  | 57.0  | 54.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 147.0 | 97.0  | 77.0  | 59.0  | 56.0  | 54.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 148.0 | 98.0  | 78.0  | 60.0  | 57.0  | 55.0  | 54.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 50.0  | 20.0  | 18.0  | 3.0   | 2.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.5 ~ 0.6   | 3.1 ~ 3.8   | 1.9 ~ 2.3   | 7.8 ~ 8.6   | 5.2 ~ 5.8   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 36 ~ 52     | 27 ~ 47     | 45 ~ 59     | 102 ~ 113   | 94 ~ 107    |             |             |
| Avg. Linear Feedrate | ALF |  | 33.0        | 28.5        | 23.2        | 22.2        | 20.8        | 19.4        | 18.2        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | WC-Co         | 30mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 932                   | 11141                 | 11142                 | 11143                 | 11144                 | 11145                 | 11146 | 11147 |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                    | LA                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 15                    | 15    | 10    |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 4.0                   | 3.0                   | 2.0                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 1                     | 4                     | 6                     | 6                     | 1                     | 1                     | 8     | 8     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 2                     | 1                     | 1                     | 1                     | 4     | 4     |       |
| Stabilizer B       | SB  | 15                    | 10                    | 6                     | 6                     | 1                     | 1                     | 4     | 3     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     | 1     | 1     |       |
| Stabilizer E       | SE  | 5                     | 5                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 46.0<br>(43.0 ~ 49.0) | 40.0<br>(38.0 ~ 42.0) | 42.0<br>(40.0 ~ 44.0) | 60.0<br>(58.0 ~ 62.0) | 62.0<br>(60.0 ~ 64.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10    | 10    |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                     | 3                     | 3     | 3     |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                    | 13                    | 13    | 13    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 0     | 0     |       |
| Feedrate Address   | FA  | 0.6                   | 0.5                   | 3.2                   | 3.5                   | 8.0                   | 5.0                   | 5.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 64.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 107.0 | 57.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 128.0 | 78.0  | 58.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 137.0 | 87.0  | 67.0  | 54.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 141.0 | 91.0  | 71.0  | 58.0  | 55.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 143.0 | 93.0  | 73.0  | 60.0  | 57.0  | 55.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 144.0 | 94.0  | 74.0  | 61.0  | 58.0  | 56.0  | 54.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 50.0  | 20.0  | 13.0  | 3.0   | 2.0   | 2.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.3 ~ 0.5   | 2.2 ~ 2.9   | 1.6 ~ 2.0   | 7.6 ~ 8.4   | 5.0 ~ 5.6   | 5.0 ~ 5.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 38 ~ 54     | 28 ~ 49     | 36 ~ 51     | 80 ~ 100    | 80 ~ 90     |             |             |
| Avg. Linear Feedrate | ALF |  | 24.0        | 20.7        | 17.4        | 16.8        | 16.0        | 15.1        | 14.2        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.10BS           | WC-Co         | 40mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 932                   | 11151                 | 11152                 | 11153                 | 11154                 | 11155                 | 11156 | 11157 |       |
| Power Supply       | PS  | KL                    | RH                    | RL                    | RL                    | LC                    | LA                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 4                     | 4                     | 11                    | 15                    | 15    | 10    |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 4.0                   | 3.0                   | 2.0                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 1                     | 4                     | 6                     | 6                     | 1                     | 1                     | 8     | 8     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 2                     | 1                     | 1                     | 1                     | 4     | 4     |       |
| Stabilizer B       | SB  | 15                    | 11                    | 6                     | 6                     | 1                     | 1                     | 4     | 3     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     | 1     | 1     |       |
| Stabilizer E       | SE  | 5                     | 5                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 80.0<br>(78.0 ~ 82.0) | 46.0<br>(43.0 ~ 49.0) | 40.0<br>(38.0 ~ 42.0) | 35.0<br>(33.0 ~ 37.0) | 40.0<br>(38.0 ~ 42.0) | 45.0<br>(43.0 ~ 47.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10    | 10    |       |
| Wire Tension       | WT  | 3                     | 3                     | 3                     | 3                     | 3                     | 3                     | 3     | 3     |       |
| Pre-Tension        | PT  | 8                     | 9                     | 13                    | 13                    | 13                    | 13                    | 13    | 13    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 8                     | 12                    | 6                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 0     | 0     |       |
| Feedrate Address   | FA  | 0.6                   | 0.3                   | 3.0                   | 3.0                   | 8.0                   | 5.0                   | 5.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 66.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 102.0 | 52.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 128.0 | 78.0  | 58.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 139.0 | 89.0  | 69.0  | 56.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 142.0 | 92.0  | 72.0  | 59.0  | 56.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 144.0 | 94.0  | 74.0  | 61.0  | 58.0  | 56.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 145.0 | 95.0  | 75.0  | 62.0  | 59.0  | 57.0  | 54.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 50.0  | 20.0  | 13.0  | 3.0   | 2.0   | 3.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.2 ~ 0.4   | 1.5 ~ 1.9   | 1.3 ~ 1.6   | 7.4 ~ 8.2   | 5.0 ~ 5.5   | 5.0 ~ 5.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 40 ~ 56     | 31 ~ 51     | 27 ~ 44     | 76 ~ 88     | 70 ~ 81     |             |             |
| Avg. Linear Feedrate | ALF |  | 18.0        | 15.3        | 13.0        | 12.7        | 12.2        | 11.7        | 11.2        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | DFS   |

Thickness 5 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | Increment |
| A                 | 951             | RH  | 2.0 |        |       |       |       |       |       |       |       |           |
| 1                 | 10401           | RH  | 4.0 | 158.0  | 241.0 | 284.0 | 302.0 | 307.0 | 310.0 | 311.0 | 313.0 | 0.0       |
| 2                 | 10402           | RL  | 6.0 | -      | 141.0 | 184.0 | 202.0 | 207.0 | 210.0 | 211.0 | 213.0 | 100.0     |
| 3                 | 10403           | HL  | 6.0 | -      | -     | 134.0 | 152.0 | 157.0 | 160.0 | 161.0 | 163.0 | 50.0      |
| 4                 | 10404           | LC  | 5.0 | -      | -     | -     | 132.0 | 137.0 | 140.0 | 141.0 | 143.0 | 20.0      |
| 5                 | 10405           | LC  | 7.0 | -      | -     | -     | -     | 131.0 | 134.0 | 135.0 | 137.0 | 6.0       |
| 6                 | 10406           | LC  | 7.0 | -      | -     | -     | -     | -     | 132.0 | 133.0 | 135.0 | 2.0       |
| 7                 | 10407           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 129.0 | 131.0 | 4.0       |
| 8                 | 10408           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | 126.0 | 5.0       |
| Surface roughness |                 |     | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.0   | 1.5   | 1.2   |           |
|                   |                 |     | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.28  | 0.18  | 0.15  |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | Increment |
| A                 | 951             | RH  | 2.0 |        |       |       |       |       |       |       |       |           |
| 1                 | 10411           | RH  | 4.0 | 160.0  | 244.0 | 281.0 | 301.0 | 308.0 | 311.0 | 312.0 | 313.0 | 0.0       |
| 2                 | 10412           | RL  | 6.0 | -      | 144.0 | 181.0 | 201.0 | 208.0 | 211.0 | 212.0 | 213.0 | 100.0     |
| 3                 | 10413           | HL  | 6.0 | -      | -     | 131.0 | 151.0 | 158.0 | 161.0 | 162.0 | 163.0 | 50.0      |
| 4                 | 10414           | LC  | 5.0 | -      | -     | -     | 131.0 | 138.0 | 141.0 | 142.0 | 143.0 | 20.0      |
| 5                 | 10415           | LC  | 7.0 | -      | -     | -     | -     | 132.0 | 135.0 | 136.0 | 137.0 | 6.0       |
| 6                 | 10416           | LC  | 7.0 | -      | -     | -     | -     | -     | 133.0 | 134.0 | 135.0 | 2.0       |
| 7                 | 10417           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 129.0 | 130.0 | 5.0       |
| 8                 | 10418           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | 128.0 | 2.0       |
| Surface roughness |                 |     | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.0   | 1.5   | 1.2   |           |
|                   |                 |     | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.28  | 0.18  | 0.15  |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | Increment |
| A                 | 951             | RH  | 2.0 |        |       |       |       |       |       |       |       |           |
| 1                 | 10421           | RH  | 3.0 | 163.0  | 244.0 | 278.0 | 299.0 | 306.0 | 309.0 | 311.0 | 311.5 | 0.0       |
| 2                 | 10422           | RL  | 5.0 | -      | 144.0 | 178.0 | 199.0 | 206.0 | 209.0 | 211.0 | 211.5 | 100.0     |
| 3                 | 10423           | HL  | 5.0 | -      | -     | 128.0 | 149.0 | 156.0 | 159.0 | 161.0 | 161.5 | 50.0      |
| 4                 | 10424           | LC  | 4.0 | -      | -     | -     | 129.0 | 136.0 | 139.0 | 141.0 | 141.5 | 20.0      |
| 5                 | 10425           | LC  | 7.0 | -      | -     | -     | -     | 130.0 | 133.0 | 135.0 | 135.5 | 6.0       |
| 6                 | 10426           | LC  | 7.0 | -      | -     | -     | -     | -     | 131.0 | 133.0 | 133.5 | 2.0       |
| 7                 | 10427           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 130.0 | 130.5 | 3.0       |
| 8                 | 10428           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | 129.0 | 1.5       |
| Surface roughness |                 |     | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.0   | 1.5   | 1.2   |           |
|                   |                 |     | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.28  | 0.18  | 0.15  |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | DFS   |

Thickness 30 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 952             | RH  | 1.0 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10431           | RH  | 2.5 | 168.0  | 238.0 | 281.0 | 300.0 | 305.0 | 308.0 | 310.0 | 311.0 | 311.0 |      | 0.0               |
| 2                 | 10432           | RL  | 4.8 | -      | 138.0 | 181.0 | 200.0 | 205.0 | 208.0 | 210.0 | 211.0 | 211.0 |      | 100.0             |
| 3                 | 10433           | HL  | 4.5 | -      | -     | 131.0 | 150.0 | 155.0 | 158.0 | 160.0 | 161.0 | 161.0 |      | 50.0              |
| 4                 | 10434           | LC  | 3.8 | -      | -     | -     | 130.0 | 135.0 | 138.0 | 140.0 | 141.0 | 141.0 |      | 20.0              |
| 5                 | 10435           | LC  | 6.5 | -      | -     | -     | -     | 129.0 | 132.0 | 134.0 | 135.0 | 135.0 |      | 6.0               |
| 6                 | 10436           | LC  | 6.5 | -      | -     | -     | -     | -     | 130.0 | 132.0 | 133.0 | 133.0 |      | 2.0               |
| 7                 | 10437           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 129.0 | 130.0 | 130.0 |      | 3.0               |
| 8                 | 10438           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | 129.0 | 129.0 |      | 1.0               |
| 9                 | 10439           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | -     | 128.0 |      | 1.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.0   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.28  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 952             | RH  | 1.0 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10441           | RH  | 2.0 | 172.0  | 234.0 | 284.0 | 300.0 | 305.0 | 308.0 | 309.0 | 311.0 | 311.0 |      | 0.0               |
| 2                 | 10442           | RL  | 4.5 | -      | 134.0 | 184.0 | 200.0 | 205.0 | 208.0 | 209.0 | 211.0 | 211.0 |      | 100.0             |
| 3                 | 10443           | HL  | 4.0 | -      | -     | 134.0 | 150.0 | 155.0 | 158.0 | 159.0 | 161.0 | 161.0 |      | 50.0              |
| 4                 | 10444           | LC  | 3.5 | -      | -     | -     | 130.0 | 135.0 | 138.0 | 139.0 | 141.0 | 141.0 |      | 20.0              |
| 5                 | 10445           | LC  | 6.0 | -      | -     | -     | -     | 129.0 | 132.0 | 133.0 | 135.0 | 135.0 |      | 6.0               |
| 6                 | 10446           | LC  | 6.0 | -      | -     | -     | -     | -     | 130.0 | 131.0 | 133.0 | 133.0 |      | 2.0               |
| 7                 | 10447           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 128.0 | 130.0 | 130.0 |      | 3.0               |
| 8                 | 10448           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | 129.0 | 129.0 |      | 1.0               |
| 9                 | 10449           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | -     | 128.0 |      | 1.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.0   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.28  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 953             | RH  | 0.7 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10451           | RH  | 1.8 | 171.0  | 230.0 | 284.0 | 300.0 | 305.0 | 307.0 | 309.0 | 310.0 | 310.0 |      | 0.0               |
| 2                 | 10452           | RL  | 4.3 | -      | 130.0 | 184.0 | 200.0 | 205.0 | 207.0 | 209.0 | 210.0 | 210.0 |      | 100.0             |
| 3                 | 10453           | HL  | 3.8 | -      | -     | 134.0 | 150.0 | 155.0 | 157.0 | 159.0 | 160.0 | 160.0 |      | 50.0              |
| 4                 | 10454           | LC  | 3.3 | -      | -     | -     | 130.0 | 135.0 | 137.0 | 139.0 | 140.0 | 140.0 |      | 20.0              |
| 5                 | 10455           | LC  | 6.0 | -      | -     | -     | -     | 129.0 | 131.0 | 133.0 | 134.0 | 134.0 |      | 6.0               |
| 6                 | 10456           | LC  | 6.0 | -      | -     | -     | -     | -     | 129.0 | 131.0 | 132.0 | 132.0 |      | 2.0               |
| 7                 | 10457           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 129.0 | 130.0 | 130.0 |      | 2.0               |
| 8                 | 10458           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | 129.0 | 129.0 |      | 1.0               |
| 9                 | 10459           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | -     | 128.0 |      | 1.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.0   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.28  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | DFS   |

Thickness 60 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 953             | RH  | 0.7 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10461           | RH  | 1.6 | 171.0  | 226.0 | 284.0 | 300.0 | 305.0 | 307.0 | 309.0 | 310.0 | 310.0 |      | 0.0               |
| 2                 | 10462           | RL  | 4.0 | -      | 126.0 | 184.0 | 200.0 | 205.0 | 207.0 | 209.0 | 210.0 | 210.0 |      | 100.0             |
| 3                 | 10463           | HL  | 3.5 | -      | -     | 134.0 | 150.0 | 155.0 | 157.0 | 159.0 | 160.0 | 160.0 |      | 50.0              |
| 4                 | 10464           | LC  | 3.0 | -      | -     | -     | 130.0 | 135.0 | 137.0 | 139.0 | 140.0 | 140.0 |      | 20.0              |
| 5                 | 10465           | LC  | 6.0 | -      | -     | -     | -     | 129.0 | 131.0 | 133.0 | 134.0 | 134.0 |      | 6.0               |
| 6                 | 10466           | LC  | 6.0 | -      | -     | -     | -     | -     | 129.0 | 131.0 | 132.0 | 132.0 |      | 2.0               |
| 7                 | 10467           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 129.0 | 130.0 | 130.0 |      | 2.0               |
| 8                 | 10468           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | 129.0 | 129.0 |      | 1.0               |
| 9                 | 10469           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | -     | 128.0 |      | 1.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.0   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.28  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 954             | RH  | 0.6 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10471           | RH  | 1.4 | 170.0  | 227.0 | 285.0 | 300.0 | 306.0 | 308.0 | 309.0 | 310.0 | 310.0 |      | 0.0               |
| 2                 | 10472           | RL  | 3.8 | -      | 127.0 | 185.0 | 200.0 | 206.0 | 208.0 | 209.0 | 210.0 | 210.0 |      | 100.0             |
| 3                 | 10473           | HL  | 3.3 | -      | -     | 135.0 | 150.0 | 156.0 | 158.0 | 159.0 | 160.0 | 160.0 |      | 50.0              |
| 4                 | 10474           | LC  | 2.8 | -      | -     | -     | 130.0 | 136.0 | 138.0 | 139.0 | 140.0 | 140.0 |      | 20.0              |
| 5                 | 10475           | LC  | 6.0 | -      | -     | -     | -     | 130.0 | 132.0 | 133.0 | 134.0 | 134.0 |      | 6.0               |
| 6                 | 10476           | LC  | 6.0 | -      | -     | -     | -     | -     | 130.0 | 131.0 | 132.0 | 132.0 |      | 2.0               |
| 7                 | 10477           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 129.0 | 130.0 | 130.0 |      | 2.0               |
| 8                 | 10478           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | 129.0 | 129.0 |      | 1.0               |
| 9                 | 10479           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | -     | 128.0 |      | 1.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.0   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.28  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 954             | RH  | 0.6 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10481           | RH  | 1.2 | 169.0  | 229.0 | 286.0 | 303.0 | 307.0 | 310.0 | 310.5 | 311.5 | 312.5 |      | 0.0               |
| 2                 | 10482           | RL  | 3.5 | -      | 129.0 | 186.0 | 203.0 | 207.0 | 210.0 | 210.5 | 211.5 | 212.5 |      | 100.0             |
| 3                 | 10483           | HL  | 3.0 | -      | -     | 136.0 | 153.0 | 157.0 | 160.0 | 160.5 | 161.5 | 162.5 |      | 50.0              |
| 4                 | 10484           | LC  | 2.5 | -      | -     | -     | 133.0 | 137.0 | 140.0 | 140.5 | 141.5 | 142.5 |      | 20.0              |
| 5                 | 10485           | LC  | 6.0 | -      | -     | -     | -     | 131.0 | 134.0 | 134.5 | 135.5 | 136.5 |      | 6.0               |
| 6                 | 10486           | LC  | 6.0 | -      | -     | -     | -     | -     | 132.0 | 132.5 | 133.5 | 134.5 |      | 2.0               |
| 7                 | 10487           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 129.0 | 130.0 | 131.0 |      | 3.5               |
| 8                 | 10488           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | 129.0 | 130.0 |      | 1.0               |
| 9                 | 10489           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | -     | 129.0 |      | 1.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.0   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.28  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | STEEL         | DFS   |

Thickness 90 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 955             | RH  | 0.5 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10491           | RH  | 1.0 | 176.0  | 229.0 | 286.0 | 303.0 | 309.0 | 311.0 | 311.5 | 312.5 | 313.5 |      | 0.0               |
| 2                 | 10492           | RL  | 3.0 | -      | 129.0 | 186.0 | 203.0 | 209.0 | 211.0 | 211.5 | 212.5 | 213.5 |      | 100.0             |
| 3                 | 10493           | HL  | 2.8 | -      | -     | 136.0 | 153.0 | 159.0 | 161.0 | 161.5 | 162.5 | 163.5 |      | 50.0              |
| 4                 | 10494           | LC  | 2.8 | -      | -     | -     | 133.0 | 139.0 | 141.0 | 141.5 | 142.5 | 143.5 |      | 20.0              |
| 5                 | 10495           | LC  | 6.0 | -      | -     | -     | -     | 133.0 | 135.0 | 135.5 | 136.5 | 137.5 |      | 6.0               |
| 6                 | 10496           | LC  | 6.0 | -      | -     | -     | -     | -     | 133.0 | 133.5 | 134.5 | 135.5 |      | 2.0               |
| 7                 | 10497           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 130.0 | 131.0 | 132.0 |      | 3.5               |
| 8                 | 10498           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | 130.0 | 131.0 |      | 1.0               |
| 9                 | 10499           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | -     | 130.0 |      | 1.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.0   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.28  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 955             | RH  | 0.5 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10701           | RH  | 0.8 | 185.0  | 228.0 | 285.0 | 305.0 | 311.0 | 312.0 | 312.5 | 313.5 | 314.5 |      | 0.0               |
| 2                 | 10702           | RL  | 2.5 | -      | 128.0 | 185.0 | 205.0 | 211.0 | 212.0 | 212.5 | 213.5 | 214.5 |      | 100.0             |
| 3                 | 10703           | HL  | 2.5 | -      | -     | 135.0 | 155.0 | 161.0 | 162.0 | 162.5 | 163.5 | 164.5 |      | 50.0              |
| 4                 | 10704           | LC  | 3.0 | -      | -     | -     | 135.0 | 141.0 | 142.0 | 142.5 | 143.5 | 144.5 |      | 20.0              |
| 5                 | 10705           | LC  | 6.0 | -      | -     | -     | -     | 135.0 | 136.0 | 136.5 | 137.5 | 138.5 |      | 6.0               |
| 6                 | 10706           | LC  | 6.0 | -      | -     | -     | -     | -     | 134.0 | 134.5 | 135.5 | 136.5 |      | 2.0               |
| 7                 | 10707           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 131.0 | 132.0 | 133.0 |      | 3.5               |
| 8                 | 10708           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | 131.0 | 132.0 |      | 1.0               |
| 9                 | 10709           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | -     | -     | 131.0 |      | 1.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 18.0   | 15.0  | 13.0  | 6.0   | 2.8   | 2.0   | 1.8   | 1.5   | 1.2   |      |                   |
|                   |                 |     | Ra  | 2.70   | 2.50  | 1.80  | 0.80  | 0.34  | 0.28  | 0.20  | 0.18  | 0.15  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |     |      |                   |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |     |      |                   |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |     |      |                   |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |     |      |                   |
| 9                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   | -   |     |      |                   |
| 10                |                 |    |    | -      | -   | -   | -   | -   | -   | -   | -   | -   |      |                   |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 5mm                | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3                    | Skim4                    | Skim5                    | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|--------------------------|--------------------------|--------------------------|-------|-------|
| E-pack Number      | Eno | 951                   | 10401                 | 10402                 | 10403                    | 10404                    | 10405                    | 10406                    | 10407 | 10408 |
| Power Supply       | PS  | RH                    | RH                    | RL                    | HL                       | LC                       | LC                       | LC                       | DFS   | DFS   |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                       | SL                       | SL                       | SL                       | NM    | NM    |
| Voltage Open       | Vo  | 7                     | 7                     | 6                     | 12                       | 14                       | 14                       | 12                       | 12    | 10    |
| Power Setting      | IP  | 7.0                   | 9.0                   | 11.0                  | 14.0                     | 3.0                      | 3.0                      | 2.0                      | 1.0   | 1.0   |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    | 12                       |                          |                          |                          |       |       |
| Off Time           | OFF | 6                     | 5                     | 8                     | 9                        | 8                        | 8                        | 6                        | 13    | 13    |
| Stabilizer A       | SA  | 3                     | 5                     | 4                     | 1                        | 1                        | 1                        | 1                        | 6     | 6     |
| Stabilizer B       | SB  | 8                     | 7                     | 8                     | 9                        | 8                        | 8                        | 8                        | 1     | 1     |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                        | 1                        | 1                        | 1                        | 1     | 1     |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        | 1                        | 1                        | 1                        | 1     | 1     |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 54.0<br>(51.0 ~ 57.0) | 76.0<br>(74.0 ~ 78.0) | 103.0<br>(101.0 ~ 105.0) | 150.0<br>(148.0 ~ 152.0) | 150.0<br>(148.0 ~ 152.0) | 120.0<br>(118.0 ~ 122.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                      | ON                       | ON                       | ON                       | OFF   | OFF   |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      | OFF                      | OFF                      | OFF                      | OFF   | OFF   |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                       | 10                       | 10                       | 10                       | 10    | 10    |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                       | 14                       | 14                       | 14                       | 10    | 10    |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       | 14                       | 14                       | 14                       | 14    | 14    |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       | NM                       | NM                       | NM                       | NM    | NM    |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        | 4                        | 4                        | 4                        | 4     | 4     |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       | 10                       | 10                       | 10                       | 10    | 10    |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        | 0                        | 0                        | 0                        | 0     | 0     |
| Feedrate Address   | FA  | 2.0                   | 4.0                   | 6.0                   | 6.0                      | 5.0                      | 7.0                      | 7.0                      | 6.0   | 6.0   |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      | 1.0                      | 1.0                      | 1.0   | 1.0   |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      | 1.0                      | 1.0                      | 1.0                      | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 158.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 241.0 | 141.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 284.0 | 184.0 | 134.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 302.0 | 202.0 | 152.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 307.0 | 207.0 | 157.0 | 137.0 | 131.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 310.0 | 210.0 | 160.0 | 140.0 | 134.0 | 132.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 311.0 | 211.0 | 161.0 | 141.0 | 135.0 | 133.0 | 129.0 | ----- |
| Rough & 7 Skims    | ----- | 313.0 | 213.0 | 163.0 | 143.0 | 137.0 | 135.0 | 131.0 | 126.0 |
| Stepping Increment | ----- | ----- | 100.0 | 50.0  | 20.0  | 6.0   | 2.0   | 4.0   | 5.0   |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 8.3 ~ 11.0  | 13.0 ~ 18.9 | 12.1 ~ 15.3 | 5.1 ~ 5.8   | 6.7 ~ 7.5   | 6.8 ~ 7.6   | 6.0 ~ 6.0   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 49 ~ 77     | 80 ~ 110    | 132 ~ 151   | 155 ~ 168   | 158 ~ 170   | 133 ~ 146   |             |             |
| Avg. Linear Feedrate | ALF |  | 579.0       | 360.7       | 250.7       | 141.9       | 106.4       | 85.4        | 69.0        | 57.9        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 10mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                   | Skim4                    | Skim5                    | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------------------------|--------------------------|--------------------------|-------|-------|
| E-pack Number      | Eno | 951                   | 10411                 | 10412                 | 10413                 | 10414                   | 10415                    | 10416                    | 10417 | 10418 |
| Power Supply       | PS  | RH                    | RH                    | RL                    | HL                    | LC                      | LC                       | LC                       | DFS   | DFS   |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                      | SL                       | SL                       | NM    | NM    |
| Voltage Open       | Vo  | 7                     | 7                     | 6                     | 12                    | 14                      | 14                       | 12                       | 12    | 10    |
| Power Setting      | IP  | 7.0                   | 10.0                  | 11.0                  | 14.0                  | 3.0                     | 3.0                      | 2.0                      | 1.0   | 1.0   |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    | 12                    |                         |                          |                          |       |       |
| Off Time           | OFF | 6                     | 5                     | 8                     | 9                     | 8                       | 8                        | 6                        | 13    | 13    |
| Stabilizer A       | SA  | 3                     | 6                     | 4                     | 1                     | 1                       | 1                        | 1                        | 6     | 6     |
| Stabilizer B       | SB  | 8                     | 7                     | 8                     | 9                     | 8                       | 8                        | 8                        | 1     | 1     |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                       | 1                        | 1                        | 1     | 1     |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                       | 1                        | 1                        | 1     | 1     |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 54.0<br>(51.0 ~ 57.0) | 56.0<br>(54.0 ~ 58.0) | 48.0<br>(46.0 ~ 50.0) | 100.0<br>(98.0 ~ 102.0) | 135.0<br>(133.0 ~ 137.0) | 125.0<br>(123.0 ~ 127.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                      | ON                       | ON                       | OFF   | OFF   |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                     | OFF                      | OFF                      | OFF   | OFF   |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                      | 10                       | 10                       | 10    | 10    |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                      | 14                       | 14                       | 10    | 10    |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                      | 14                       | 14                       | 14    | 14    |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                      | NM                       | NM                       | NM    | NM    |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                       | 4                        | 4                        | 4     | 4     |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                      | 10                       | 10                       | 10    | 10    |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                       | 0                        | 0                        | 0     | 0     |
| Feedrate Address   | FA  | 2.0                   | 4.0                   | 6.0                   | 6.0                   | 5.0                     | 7.0                      | 7.0                      | 6.0   | 6.0   |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                      | 1.0                      | 1.0   | 1.0   |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                      | 1.0                      | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 160.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 244.0 | 144.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 281.0 | 181.0 | 131.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 301.0 | 201.0 | 151.0 | 131.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 308.0 | 208.0 | 158.0 | 138.0 | 132.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 311.0 | 211.0 | 161.0 | 141.0 | 135.0 | 133.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 312.0 | 212.0 | 162.0 | 142.0 | 136.0 | 134.0 | 129.0 | ----- |
| Rough & 7 Skims    | ----- | 313.0 | 213.0 | 163.0 | 143.0 | 137.0 | 135.0 | 130.0 | 128.0 |
| Stepping Increment | ----- | ----- | 100.0 | 50.0  | 20.0  | 6.0   | 2.0   | 5.0   | 2.0   |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 7.0 ~ 9.0   | 14.5 ~ 19.3 | 13.7 ~ 17.8 | 7.0 ~ 8.2   | 6.7 ~ 7.4   | 6.7 ~ 7.4   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 47 ~ 67     | 81 ~ 96     | 100 ~ 118   | 129 ~ 144   | 136 ~ 150   | 124 ~ 137   |             |
| Avg. Linear Feedrate | ALF |  | 480.0       | 325.8       | 242.3       | 158.2       | 115.1       | 90.5        | 60.2        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   | 1.4 ~ 1.6   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 | 0.16 ~ 0.27 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 20mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 951                   | 10421                 | 10422                 | 10423                 | 10424                 | 10425                 | 10426                 | 10427 | 10428 |
| Power Supply       | PS  | RH                    | RH                    | RL                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    |
| Voltage Open       | Vo  | 7                     | 7                     | 6                     | 12                    | 14                    | 14                    | 12                    | 13    | 10    |
| Power Setting      | IP  | 7.0                   | 10.0                  | 11.0                  | 14.0                  | 3.0                   | 3.0                   | 2.0                   | 1.0   | 1.0   |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    | 12                    |                       |                       |                       |       |       |
| Off Time           | OFF | 6                     | 4                     | 8                     | 9                     | 8                     | 8                     | 6                     | 13    | 13    |
| Stabilizer A       | SA  | 3                     | 7                     | 4                     | 1                     | 1                     | 1                     | 1                     | 6     | 6     |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 9                     | 8                     | 8                     | 8                     | 1     | 1     |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 56.0<br>(54.0 ~ 58.0) | 58.0<br>(56.0 ~ 60.0) | 90.0<br>(88.0 ~ 92.0) | 75.0<br>(73.0 ~ 77.0) | 65.0<br>(63.0 ~ 67.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    | OFF   | OFF   |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 10    | 10    |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |
| Straightness cmp.  | CC  | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 0     | 0     |
| Feedrate Address   | FA  | 2.0                   | 3.0                   | 5.0                   | 5.0                   | 4.0                   | 7.0                   | 7.0                   | 6.0   | 6.0   |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 163.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 244.0 | 144.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 278.0 | 178.0 | 128.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 299.0 | 199.0 | 149.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 306.0 | 206.0 | 156.0 | 136.0 | 130.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 309.0 | 209.0 | 159.0 | 139.0 | 133.0 | 131.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 311.0 | 211.0 | 161.0 | 141.0 | 135.0 | 133.0 | 130.0 | ----- |
| Rough & 7 Skims    | ----- | 311.5 | 211.5 | 161.5 | 141.5 | 135.5 | 133.5 | 130.5 | 129.0 |
| Stepping Increment | ----- | ----- | 100.0 | 50.0  | 20.0  | 6.0   | 2.0   | 3.0   | 1.5   |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 5.4 ~ 6.7   | 10.8 ~ 14.0 | 8.8 ~ 11.3  | 5.2 ~ 6.0   | 7.0 ~ 7.7   | 6.9 ~ 7.7   | 6.0 ~ 6.0   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 30 ~ 55     | 65 ~ 82     | 52 ~ 72     | 104 ~ 119   | 109 ~ 122   | 96 ~ 111    |             |             |
| Avg. Linear Feedrate | ALF |  | 363.0       | 244.0       | 173.7       | 114.5       | 90.9        | 75.3        | 62.3        | 53.1        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 30.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 952                   | 10431                 | 10432                 | 10433                 | 10434                 | 10435                 | 10436                 | 10437 | 10438 | 10439 |
| Power Supply       | PS       | RH                    | RH                    | RL                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 7                     | 6                     | 12                    | 14                    | 14                    | 12                    | 13    | 11    | 7     |
| Power Setting      | IP       | 8.0                   | 10.0                  | 11.0                  | 14.0                  | 3.0                   | 3.0                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 11                    | 12                    | 12                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 8                     | 9                     | 8                     | 8                     | 6                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 7                     | 4                     | 1                     | 1                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 8                     | 4                     | 8                     | 9                     | 8                     | 8                     | 8                     | 9     | 1     | 1     |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(42.0 ~ 48.0) | 56.0<br>(54.0 ~ 58.0) | 58.0<br>(56.0 ~ 60.0) | 85.0<br>(83.0 ~ 87.0) | 70.0<br>(68.0 ~ 72.0) | 57.0<br>(55.0 ~ 59.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 12    | 12    | 12    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 1.0                   | 2.5                   | 4.8                   | 4.5                   | 3.8                   | 6.5                   | 6.5                   | 6.0   | 6.0   | 6.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 168.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 238.0 | 138.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 281.0 | 181.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 300.0 | 200.0 | 150.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 305.0 | 205.0 | 155.0 | 135.0 | 129.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 308.0 | 208.0 | 158.0 | 138.0 | 132.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 310.0 | 210.0 | 160.0 | 140.0 | 134.0 | 132.0 | 129.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 311.0 | 211.0 | 161.0 | 141.0 | 135.0 | 133.0 | 130.0 | 129.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 311.0 | 211.0 | 161.0 | 141.0 | 135.0 | 133.0 | 130.0 | 129.0 | 128.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 100.0 | 50.0  | 20.0  | 6.0   | 2.0   | 3.0   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 4.3 ~ 5.6   | 9.5 ~ 12.4  | 5.7 ~ 7.5   | 4.5 ~ 5.2   | 6.4 ~ 7.1   | 6.4 ~ 7.1   | 6.0 ~ 6.0   | 6.0 ~ 6.0   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 32 ~ 55     | 57 ~ 74     | 50 ~ 69     | 93 ~ 106    | 94 ~ 108    | 81 ~ 95     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 297.0       | 204.5       | 134.9       | 92.2        | 75.1        | 63.3        | 53.9        | 46.9        | 41.5        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 40.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 952                   | 10441                 | 10442                 | 10443                 | 10444                 | 10445                 | 10446                 | 10447 | 10448 | 10449 |
| Power Supply       | PS       | RH                    | RH                    | RL                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 7                     | 6                     | 12                    | 14                    | 14                    | 12                    | 13    | 11    | 7     |
| Power Setting      | IP       | 8.0                   | 10.0                  | 11.0                  | 14.0                  | 3.0                   | 3.0                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 11                    | 12                    | 12                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 3                     | 8                     | 9                     | 8                     | 8                     | 6                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 7                     | 4                     | 1                     | 1                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 8                     | 4                     | 8                     | 9                     | 8                     | 8                     | 8                     | 9     | 1     | 1     |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 44.0<br>(41.0 ~ 47.0) | 56.0<br>(54.0 ~ 58.0) | 58.0<br>(56.0 ~ 60.0) | 80.0<br>(78.0 ~ 82.0) | 65.0<br>(63.0 ~ 67.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 12    | 12    | 12    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 1.0                   | 2.0                   | 4.5                   | 4.0                   | 3.5                   | 6.0                   | 6.0                   | 6.0   | 6.0   | 6.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 172.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 234.0 | 134.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 284.0 | 184.0 | 134.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 300.0 | 200.0 | 150.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 305.0 | 205.0 | 155.0 | 135.0 | 129.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 308.0 | 208.0 | 158.0 | 138.0 | 132.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 309.0 | 209.0 | 159.0 | 139.0 | 133.0 | 131.0 | 128.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 311.0 | 211.0 | 161.0 | 141.0 | 135.0 | 133.0 | 130.0 | 129.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 311.0 | 211.0 | 161.0 | 141.0 | 135.0 | 133.0 | 130.0 | 129.0 | 128.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 100.0 | 50.0  | 20.0  | 6.0   | 2.0   | 3.0   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 3.2 ~ 4.4   | 8.1 ~ 10.7  | 2.6 ~ 3.6   | 3.7 ~ 4.4   | 5.8 ~ 6.5   | 5.8 ~ 6.5   | 6.0 ~ 6.0   | 6.0 ~ 6.0   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 35 ~ 55     | 49 ~ 67     | 49 ~ 66     | 82 ~ 94     | 80 ~ 93     | 66 ~ 80     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 228.0       | 162.4       | 86.7        | 63.9        | 54.5        | 47.5        | 41.9        | 37.6        | 34.0        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 50.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 953                   | 10451                 | 10452                 | 10453                 | 10454                 | 10455                 | 10456                 | 10457 | 10458 | 10459 |
| Power Supply       | PS       | RH                    | RH                    | RL                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 7                     | 6                     | 12                    | 12                    | 14                    | 12                    | 15    | 12    | 8     |
| Power Setting      | IP       | 8.0                   | 11.0                  | 11.0                  | 14.0                  | 2.5                   | 3.0                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 12                    | 12                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 4                     | 8                     | 9                     | 10                    | 8                     | 6                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 6                     | 4                     | 1                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 6                     | 8                     | 9                     | 10                    | 8                     | 8                     | 9     | 1     | 1     |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 39.0<br>(36.0 ~ 42.0) | 56.0<br>(54.0 ~ 58.0) | 60.0<br>(58.0 ~ 62.0) | 73.0<br>(71.0 ~ 75.0) | 61.0<br>(59.0 ~ 63.0) | 44.0<br>(42.0 ~ 46.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 12    | 12    | 12    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.7                   | 1.8                   | 4.3                   | 3.8                   | 3.3                   | 6.0                   | 6.0                   | 6.0   | 6.0   | 6.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 171.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 230.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 284.0 | 184.0 | 134.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 300.0 | 200.0 | 150.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 305.0 | 205.0 | 155.0 | 135.0 | 129.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 307.0 | 207.0 | 157.0 | 137.0 | 131.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 309.0 | 209.0 | 159.0 | 139.0 | 133.0 | 131.0 | 129.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 310.0 | 210.0 | 160.0 | 140.0 | 134.0 | 132.0 | 130.0 | 129.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 310.0 | 210.0 | 160.0 | 140.0 | 134.0 | 132.0 | 130.0 | 129.0 | 128.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 100.0 | 50.0  | 20.0  | 6.0   | 2.0   | 2.0   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 2.6 ~ 3.6   | 7.3 ~ 9.6   | 2.1 ~ 2.8   | 4.6 ~ 5.4   | 5.8 ~ 6.5   | 5.9 ~ 6.5   | 6.0 ~ 6.0   | 6.0 ~ 6.0   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 29 ~ 47     | 48 ~ 66     | 51 ~ 67     | 71 ~ 84     | 76 ~ 89     | 59 ~ 73     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 186.0       | 136.1       | 70.7        | 57.2        | 49.5        | 43.7        | 39.0        | 35.2        | 32.0        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 60.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 953                   | 10461                 | 10462                 | 10463                 | 10464                 | 10465                 | 10466                 | 10467 | 10468 | 10469 |
| Power Supply       | PS       | RH                    | RH                    | RL                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 7                     | 6                     | 12                    | 12                    | 14                    | 12                    | 15    | 13    | 9     |
| Power Setting      | IP       | 8.0                   | 11.0                  | 11.0                  | 14.0                  | 2.5                   | 3.0                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 12                    | 12                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 4                     | 8                     | 9                     | 10                    | 8                     | 6                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 6                     | 4                     | 1                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 6                     | 8                     | 9                     | 10                    | 8                     | 8                     | 9     | 1     | 1     |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 34.0<br>(31.0 ~ 37.0) | 56.0<br>(54.0 ~ 58.0) | 61.0<br>(59.0 ~ 63.0) | 66.0<br>(64.0 ~ 68.0) | 58.0<br>(56.0 ~ 60.0) | 38.0<br>(36.0 ~ 40.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 12    | 12    | 12    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.7                   | 1.6                   | 4.0                   | 3.5                   | 3.0                   | 6.0                   | 6.0                   | 6.0   | 6.0   | 6.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 171.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 226.0 | 126.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 284.0 | 184.0 | 134.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 300.0 | 200.0 | 150.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 305.0 | 205.0 | 155.0 | 135.0 | 129.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 307.0 | 207.0 | 157.0 | 137.0 | 131.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 309.0 | 209.0 | 159.0 | 139.0 | 133.0 | 131.0 | 129.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 310.0 | 210.0 | 160.0 | 140.0 | 134.0 | 132.0 | 130.0 | 129.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 310.0 | 210.0 | 160.0 | 140.0 | 134.0 | 132.0 | 130.0 | 129.0 | 128.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 100.0 | 50.0  | 20.0  | 6.0   | 2.0   | 2.0   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 2.0 ~ 2.8   | 6.5 ~ 8.4   | 1.5 ~ 2.0   | 5.5 ~ 6.4   | 5.8 ~ 6.5   | 5.9 ~ 6.5   | 6.0 ~ 6.0   | 6.0 ~ 6.0   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 22 ~ 39     | 47 ~ 66     | 53 ~ 68     | 61 ~ 74     | 71 ~ 85     | 52 ~ 66     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 144.0       | 108.9       | 53.5        | 46.5        | 41.3        | 37.2        | 33.7        | 30.8        | 28.4        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 70.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 954                   | 10471                 | 10472                 | 10473                 | 10474                 | 10475                 | 10476                 | 10477 | 10478 | 10479 |
| Power Supply       | PS       | RH                    | RH                    | RL                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 7                     | 6                     | 12                    | 12                    | 14                    | 12                    | 15    | 13    | 9     |
| Power Setting      | IP       | 8.0                   | 11.0                  | 11.0                  | 14.0                  | 2.5                   | 3.0                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 12                    | 12                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 4                     | 8                     | 9                     | 10                    | 8                     | 6                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 6                     | 4                     | 1                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 6                     | 8                     | 9                     | 10                    | 8                     | 8                     | 9     | 1     | 1     |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 34.0<br>(31.0 ~ 37.0) | 56.0<br>(54.0 ~ 58.0) | 57.0<br>(55.0 ~ 59.0) | 63.0<br>(61.0 ~ 65.0) | 55.0<br>(53.0 ~ 57.0) | 35.0<br>(33.0 ~ 37.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 12    | 12    | 12    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.6                   | 1.4                   | 3.8                   | 3.3                   | 2.8                   | 6.0                   | 6.0                   | 6.0   | 6.0   | 6.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 170.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 227.0 | 127.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 285.0 | 185.0 | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 300.0 | 200.0 | 150.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 306.0 | 206.0 | 156.0 | 136.0 | 130.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 308.0 | 208.0 | 158.0 | 138.0 | 132.0 | 130.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 309.0 | 209.0 | 159.0 | 139.0 | 133.0 | 131.0 | 129.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 310.0 | 210.0 | 160.0 | 140.0 | 134.0 | 132.0 | 130.0 | 129.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 310.0 | 210.0 | 160.0 | 140.0 | 134.0 | 132.0 | 130.0 | 129.0 | 128.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 100.0 | 50.0  | 20.0  | 6.0   | 2.0   | 2.0   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.6 ~ 2.4   | 5.5 ~ 7.3   | 1.4 ~ 1.9   | 4.6 ~ 5.4   | 5.8 ~ 6.5   | 5.9 ~ 6.5   | 6.0 ~ 6.0   | 6.0 ~ 6.0   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 23 ~ 42     | 47 ~ 67     | 50 ~ 66     | 58 ~ 71     | 65 ~ 77     | 51 ~ 65     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 120.0       | 91.4        | 47.5        | 41.0        | 36.9        | 33.6        | 30.7        | 28.3        | 26.2        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 80.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 954                   | 10481                 | 10482                 | 10483                 | 10484                 | 10485                 | 10486                 | 10487 | 10488 | 10489 |
| Power Supply       | PS       | RH                    | RH                    | RL                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 7                     | 6                     | 12                    | 12                    | 14                    | 12                    | 16    | 14    | 10    |
| Power Setting      | IP       | 8.0                   | 11.0                  | 11.0                  | 14.0                  | 2.5                   | 3.0                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 12                    | 12                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 4                     | 8                     | 9                     | 10                    | 8                     | 6                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 6                     | 4                     | 1                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 6                     | 8                     | 9                     | 10                    | 8                     | 8                     | 9     | 1     | 1     |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 34.0<br>(31.0 ~ 37.0) | 56.0<br>(54.0 ~ 58.0) | 53.0<br>(51.0 ~ 55.0) | 61.0<br>(59.0 ~ 63.0) | 53.0<br>(51.0 ~ 55.0) | 33.0<br>(31.0 ~ 35.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 12    | 12    | 12    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.6                   | 1.2                   | 3.5                   | 3.0                   | 2.5                   | 6.0                   | 6.0                   | 6.0   | 6.0   | 6.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 169.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 229.0 | 129.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 286.0 | 186.0 | 136.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 303.0 | 203.0 | 153.0 | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 307.0 | 207.0 | 157.0 | 137.0 | 131.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 310.0 | 210.0 | 160.0 | 140.0 | 134.0 | 132.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 310.5 | 210.5 | 160.5 | 140.5 | 134.5 | 132.5 | 129.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 311.5 | 211.5 | 161.5 | 141.5 | 135.5 | 133.5 | 130.0 | 129.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 312.5 | 212.5 | 162.5 | 142.5 | 136.5 | 134.5 | 131.0 | 130.0 | 129.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 100.0 | 50.0  | 20.0  | 6.0   | 2.0   | 3.5   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.1 ~ 1.9   | 4.5 ~ 6.1   | 1.3 ~ 1.8   | 3.7 ~ 4.3   | 5.7 ~ 6.4   | 5.9 ~ 6.5   | 6.0 ~ 6.0   | 6.0 ~ 6.0   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 25 ~ 45     | 47 ~ 68     | 46 ~ 62     | 55 ~ 68     | 60 ~ 73     | 50 ~ 63     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 90.0        | 70.1        | 40.0        | 34.3        | 31.3        | 28.9        | 26.7        | 24.9        | 23.3        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 90.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 955                   | 10491                 | 10492                 | 10493                 | 10494                 | 10495                 | 10496                 | 10497 | 10498 | 10499 |
| Power Supply       | PS       | RH                    | RH                    | RL                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 7                     | 6                     | 12                    | 12                    | 14                    | 12                    | 16    | 14    | 10    |
| Power Setting      | IP       | 8.0                   | 11.0                  | 11.0                  | 14.0                  | 2.5                   | 3.0                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 12                    | 12                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 4                     | 8                     | 9                     | 10                    | 8                     | 6                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 6                     | 4                     | 1                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 6                     | 6                     | 8                     | 9                     | 10                    | 8                     | 8                     | 9     | 1     | 1     |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 56.0<br>(54.0 ~ 58.0) | 49.0<br>(47.0 ~ 51.0) | 53.0<br>(51.0 ~ 55.0) | 46.0<br>(44.0 ~ 48.0) | 31.0<br>(29.0 ~ 33.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 12    | 12    | 12    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.5                   | 1.0                   | 3.0                   | 2.8                   | 2.8                   | 6.0                   | 6.0                   | 6.0   | 6.0   | 6.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 176.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 229.0 | 129.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 286.0 | 186.0 | 136.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 303.0 | 203.0 | 153.0 | 133.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 309.0 | 209.0 | 159.0 | 139.0 | 133.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 311.0 | 211.0 | 161.0 | 141.0 | 135.0 | 133.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 311.5 | 211.5 | 161.5 | 141.5 | 135.5 | 133.5 | 130.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 312.5 | 212.5 | 162.5 | 142.5 | 136.5 | 134.5 | 131.0 | 130.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 313.5 | 213.5 | 163.5 | 143.5 | 137.5 | 135.5 | 132.0 | 131.0 | 130.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 100.0 | 50.0  | 20.0  | 6.0   | 2.0   | 3.5   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.0 ~ 1.7   | 4.5 ~ 6.0   | 1.1 ~ 1.6   | 4.7 ~ 5.4   | 5.8 ~ 6.4   | 5.9 ~ 6.5   | 6.0 ~ 6.0   | 6.0 ~ 6.0   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 30 ~ 50     | 48 ~ 66     | 42 ~ 57     | 48 ~ 61     | 54 ~ 67     | 43 ~ 55     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 81.0        | 64.4        | 35.9        | 32.1        | 29.5        | 27.3        | 25.4        | 23.7        | 22.3        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | STEEL         | 100.00             | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 955                   | 10701                 | 10702                 | 10703                 | 10704                 | 10705                 | 10706                 | 10707 | 10708 | 10709 |
| Power Supply       | PS       | RH                    | RH                    | RL                    | HL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 7                     | 6                     | 12                    | 12                    | 14                    | 12                    | 16    | 14    | 10    |
| Power Setting      | IP       | 8.0                   | 12.0                  | 11.0                  | 14.0                  | 2.5                   | 3.0                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 11                    | 12                    | 12                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 4                     | 8                     | 9                     | 10                    | 8                     | 6                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 8                     | 4                     | 1                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 6                     | 5                     | 8                     | 9                     | 10                    | 8                     | 8                     | 9     | 1     | 1     |
| Stabilizer C       | SC       | 7                     | 7                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 5                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 46.0<br>(43.0 ~ 49.0) | 56.0<br>(54.0 ~ 58.0) | 45.0<br>(43.0 ~ 47.0) | 45.0<br>(43.0 ~ 47.0) | 40.0<br>(38.0 ~ 42.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 10                    | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 12    | 12    | 12    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 30                    | 30                    | 30                    | 30                    | 30                    | 30                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.5                   | 0.8                   | 2.5                   | 2.5                   | 3.0                   | 6.0                   | 6.0                   | 6.0   | 6.0   | 6.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 185.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 228.0 | 128.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 285.0 | 185.0 | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 305.0 | 205.0 | 155.0 | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 311.0 | 211.0 | 161.0 | 141.0 | 135.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 312.0 | 212.0 | 162.0 | 142.0 | 136.0 | 134.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 312.5 | 212.5 | 162.5 | 142.5 | 136.5 | 134.5 | 131.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 313.5 | 213.5 | 163.5 | 143.5 | 137.5 | 135.5 | 132.0 | 131.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 314.5 | 214.5 | 164.5 | 144.5 | 138.5 | 136.5 | 133.0 | 132.0 | 131.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 100.0 | 50.0  | 20.0  | 6.0   | 2.0   | 3.5   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.4   | 4.4 ~ 5.9   | 0.9 ~ 1.4   | 5.7 ~ 6.4   | 5.8 ~ 6.4   | 5.8 ~ 6.4   | 6.0 ~ 6.0   | 6.0 ~ 6.0   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 35 ~ 56     | 50 ~ 65     | 38 ~ 52     | 43 ~ 55     | 48 ~ 62     | 36 ~ 48     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 66.0        | 54.4        | 30.4        | 28.1        | 26.1        | 24.3        | 22.8        | 21.4        | 20.2        |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.5 ~ 3.1   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.4 ~ 1.6   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.43 ~ 4.05 | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.31 ~ 0.51 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.16 ~ 0.27 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | WC-Co         | DFS   |

Thickness 5 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |     |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-----|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th | 10th |                   |
| A                 | 951             | RH  | 2.0 |        |       |       |       |       |       |       |       |     |      |                   |
| 1                 | 10601           | KL  | 3.7 | 156.0  | 204.0 | 242.0 | 260.0 | 265.0 | 268.0 | 268.0 | 268.0 |     |      | 0.0               |
| 2                 | 10602           | KL  | 6.0 | -      | 134.0 | 172.0 | 190.0 | 195.0 | 198.0 | 198.0 | 198.0 |     |      | 70.0              |
| 3                 | 10603           | RL  | 6.0 | -      | -     | 136.0 | 154.0 | 159.0 | 162.0 | 162.0 | 162.0 |     |      | 36.0              |
| 4                 | 10604           | LC  | 7.0 | -      | -     | -     | 129.0 | 134.0 | 137.0 | 137.0 | 137.0 |     |      | 25.0              |
| 5                 | 10605           | LC  | 7.0 | -      | -     | -     | -     | 129.0 | 132.0 | 132.0 | 132.0 |     |      | 5.0               |
| 6                 | 10606           | LC  | 7.0 | -      | -     | -     | -     | -     | 130.0 | 130.0 | 130.0 |     |      | 2.0               |
| 7                 | 10607           | DFS | 6.5 | -      | -     | -     | -     | -     | -     | 128.0 | 128.0 |     |      | 2.0               |
| 8                 | 10608           | DFS | 6.5 | -      | -     | -     | -     | -     | -     | -     | 127.0 |     |      | 1.0               |
| 9                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     |     |      |                   |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -   |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.2   | 0.9   |     |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  | 0.15  | 0.13  |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |     |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-----|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th | 10th |                   |
| A                 | 951             | RH  | 2.0 |        |       |       |       |       |       |       |       |     |      |                   |
| 1                 | 10611           | KL  | 2.7 | 155.0  | 196.0 | 228.0 | 245.0 | 250.0 | 252.0 | 254.0 | 255.0 |     |      | 0.0               |
| 2                 | 10612           | KL  | 5.0 | -      | 131.0 | 163.0 | 180.0 | 185.0 | 187.0 | 189.0 | 190.0 |     |      | 65.0              |
| 3                 | 10613           | RL  | 5.0 | -      | -     | 137.0 | 154.0 | 159.0 | 161.0 | 163.0 | 164.0 |     |      | 26.0              |
| 4                 | 10614           | LC  | 7.0 | -      | -     | -     | 129.0 | 134.0 | 136.0 | 138.0 | 139.0 |     |      | 25.0              |
| 5                 | 10615           | LC  | 7.0 | -      | -     | -     | -     | 129.0 | 131.0 | 133.0 | 134.0 |     |      | 5.0               |
| 6                 | 10616           | LC  | 7.0 | -      | -     | -     | -     | -     | 129.0 | 131.0 | 132.0 |     |      | 2.0               |
| 7                 | 10617           | DFS | 6.5 | -      | -     | -     | -     | -     | -     | 126.0 | 127.0 |     |      | 5.0               |
| 8                 | 10618           | DFS | 6.5 | -      | -     | -     | -     | -     | -     | -     | 125.0 |     |      | 2.0               |
| 9                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     |     |      |                   |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -   |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.2   | 0.9   |     |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  | 0.15  | 0.13  |     |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 951             | RH  | 2.0 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10621           | RL  | 2.5 | 156.0  | 194.0 | 231.0 | 245.0 | 248.0 | 250.0 | 252.0 | 252.0 | 252.0 |      | 0.0               |
| 2                 | 10622           | KL  | 5.0 | -      | 129.0 | 166.0 | 180.0 | 183.0 | 185.0 | 187.0 | 187.0 | 187.0 |      | 65.0              |
| 3                 | 10623           | RL  | 5.0 | -      | -     | 140.0 | 154.0 | 157.0 | 159.0 | 161.0 | 161.0 | 161.0 |      | 26.0              |
| 4                 | 10624           | LC  | 7.0 | -      | -     | -     | 129.0 | 132.0 | 134.0 | 136.0 | 136.0 | 136.0 |      | 25.0              |
| 5                 | 10625           | LC  | 7.0 | -      | -     | -     | -     | 129.0 | 131.0 | 133.0 | 133.0 | 133.0 |      | 3.0               |
| 6                 | 10626           | LC  | 7.0 | -      | -     | -     | -     | -     | 129.0 | 131.0 | 131.0 | 131.0 |      | 2.0               |
| 7                 | 10627           | DFS | 6.5 | -      | -     | -     | -     | -     | -     | 128.0 | 128.0 | 128.0 |      | 3.0               |
| 8                 | 10628           | DFS | 6.5 | -      | -     | -     | -     | -     | -     | -     | 127.0 | 127.0 |      | 1.0               |
| 9                 | 10629           | DFS | 6.5 | -      | -     | -     | -     | -     | -     | -     | -     | 126.0 |      | 1.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | WC-Co         | DFS   |

Thickness 30 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 952             | RH  | 1.0 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10631           | RL  | 2.1 | 160.0  | 192.0 | 232.0 | 246.0 | 250.0 | 251.0 | 253.0 | 253.5 | 253.0 |      | 0.0               |
| 2                 | 10632           | KL  | 4.5 | -      | 127.0 | 167.0 | 181.0 | 185.0 | 186.0 | 188.0 | 188.5 | 188.0 |      | 65.0              |
| 3                 | 10633           | RL  | 4.0 | -      | -     | 141.0 | 155.0 | 159.0 | 160.0 | 162.0 | 162.5 | 162.0 |      | 26.0              |
| 4                 | 10634           | LC  | 6.5 | -      | -     | -     | 130.0 | 134.0 | 135.0 | 137.0 | 137.5 | 137.0 |      | 25.0              |
| 5                 | 10635           | LC  | 6.5 | -      | -     | -     | -     | 129.0 | 130.0 | 132.0 | 132.5 | 132.0 |      | 5.0               |
| 6                 | 10636           | LC  | 6.5 | -      | -     | -     | -     | -     | 128.0 | 130.0 | 130.5 | 130.0 |      | 2.0               |
| 7                 | 10637           | DFS | 5.5 | -      | -     | -     | -     | -     | -     | 128.0 | 128.5 | 128.0 |      | 2.0               |
| 8                 | 10638           | DFS | 5.5 | -      | -     | -     | -     | -     | -     | -     | 128.0 | 127.5 |      | 0.5               |
| 9                 | 10639           | DFS | 5.5 | -      | -     | -     | -     | -     | -     | -     | -     | 127.0 |      | 0.5               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 952             | RH  | 1.0 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10641           | RL  | 1.7 | 164.0  | 191.0 | 232.0 | 247.0 | 250.0 | 251.0 | 253.0 | 253.5 | 254.0 |      | 0.0               |
| 2                 | 10642           | KL  | 4.0 | -      | 126.0 | 167.0 | 182.0 | 185.0 | 186.0 | 188.0 | 188.5 | 189.0 |      | 65.0              |
| 3                 | 10643           | RL  | 3.0 | -      | -     | 141.0 | 156.0 | 159.0 | 160.0 | 162.0 | 162.5 | 163.0 |      | 26.0              |
| 4                 | 10644           | LC  | 6.0 | -      | -     | -     | 131.0 | 134.0 | 135.0 | 137.0 | 137.5 | 138.0 |      | 25.0              |
| 5                 | 10645           | LC  | 6.0 | -      | -     | -     | -     | 129.0 | 130.0 | 132.0 | 132.5 | 133.0 |      | 5.0               |
| 6                 | 10646           | LC  | 6.0 | -      | -     | -     | -     | -     | 128.0 | 130.0 | 130.5 | 131.0 |      | 2.0               |
| 7                 | 10647           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | 128.0 | 128.5 | 129.0 |      | 2.0               |
| 8                 | 10648           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | 128.0 | 128.5 |      | 0.5               |
| 9                 | 10649           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | -     | 128.0 |      | 0.5               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 953             | RH  | 0.7 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10651           | RL  | 1.4 | 164.0  | 191.0 | 235.0 | 246.0 | 249.0 | 250.0 | 252.0 | 252.5 | 253.0 |      | 0.0               |
| 2                 | 10652           | KL  | 3.7 | -      | 126.0 | 170.0 | 181.0 | 184.0 | 185.0 | 187.0 | 187.5 | 188.0 |      | 65.0              |
| 3                 | 10653           | RL  | 2.7 | -      | -     | 144.0 | 155.0 | 158.0 | 159.0 | 161.0 | 161.5 | 162.0 |      | 26.0              |
| 4                 | 10654           | LC  | 6.0 | -      | -     | -     | 130.0 | 133.0 | 134.0 | 136.0 | 136.5 | 137.0 |      | 25.0              |
| 5                 | 10655           | LC  | 6.0 | -      | -     | -     | -     | 128.0 | 129.0 | 131.0 | 131.5 | 132.0 |      | 5.0               |
| 6                 | 10656           | LC  | 6.0 | -      | -     | -     | -     | -     | 127.0 | 129.0 | 129.5 | 130.0 |      | 2.0               |
| 7                 | 10657           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | 127.0 | 127.5 | 128.0 |      | 2.0               |
| 8                 | 10658           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | 127.0 | 127.5 |      | 0.5               |
| 9                 | 10659           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | -     | 127.0 |      | 0.5               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | WC-Co         | DFS   |

Thickness 60 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 953             | RH  | 0.7 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10661           | RL  | 1.2 | 164.0  | 191.0 | 235.0 | 246.0 | 249.0 | 250.0 | 251.0 | 252.5 | 253.0 |      | 0.0               |
| 2                 | 10662           | KL  | 3.5 | -      | 126.0 | 170.0 | 181.0 | 184.0 | 185.0 | 186.0 | 187.5 | 188.0 |      | 65.0              |
| 3                 | 10663           | RL  | 2.5 | -      | -     | 144.0 | 155.0 | 158.0 | 159.0 | 160.0 | 161.5 | 162.0 |      | 26.0              |
| 4                 | 10664           | LC  | 6.0 | -      | -     | -     | 130.0 | 133.0 | 134.0 | 135.0 | 136.5 | 137.0 |      | 25.0              |
| 5                 | 10665           | LC  | 6.0 | -      | -     | -     | -     | 128.0 | 129.0 | 130.0 | 131.5 | 132.0 |      | 5.0               |
| 6                 | 10666           | LC  | 6.0 | -      | -     | -     | -     | -     | 127.0 | 128.0 | 129.5 | 130.0 |      | 2.0               |
| 7                 | 10667           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | 126.0 | 127.5 | 128.0 |      | 2.0               |
| 8                 | 10668           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | 127.0 | 127.5 |      | 0.5               |
| 9                 | 10669           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | -     | 127.0 |      | 0.5               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 70 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 954             | RH  | 0.6 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10671           | RL  | 1.2 | 168.0  | 191.0 | 235.0 | 246.0 | 249.0 | 250.0 | 251.0 | 252.5 | 253.0 |      | 0.0               |
| 2                 | 10672           | KL  | 3.2 | -      | 126.0 | 170.0 | 181.0 | 184.0 | 185.0 | 186.0 | 187.5 | 188.0 |      | 65.0              |
| 3                 | 10673           | RL  | 2.3 | -      | -     | 144.0 | 155.0 | 158.0 | 159.0 | 160.0 | 161.5 | 162.0 |      | 26.0              |
| 4                 | 10674           | LC  | 6.0 | -      | -     | -     | 130.0 | 133.0 | 134.0 | 135.0 | 136.5 | 137.0 |      | 25.0              |
| 5                 | 10675           | LC  | 6.0 | -      | -     | -     | -     | 128.0 | 129.0 | 130.0 | 131.5 | 132.0 |      | 5.0               |
| 6                 | 10676           | LC  | 6.0 | -      | -     | -     | -     | -     | 127.0 | 128.0 | 129.5 | 130.0 |      | 2.0               |
| 7                 | 10677           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | 126.0 | 127.5 | 128.0 |      | 2.0               |
| 8                 | 10678           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | 127.0 | 127.5 |      | 0.5               |
| 9                 | 10679           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | -     | 127.0 |      | 0.5               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 954             | RH  | 0.6 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10681           | RL  | 1.1 | 173.0  | 194.0 | 235.0 | 246.0 | 248.0 | 249.0 | 250.0 | 250.5 | 251.0 |      | 0.0               |
| 2                 | 10682           | KL  | 3.0 | -      | 129.0 | 170.0 | 181.0 | 183.0 | 184.0 | 185.0 | 185.5 | 186.0 |      | 65.0              |
| 3                 | 10683           | RL  | 2.2 | -      | -     | 144.0 | 155.0 | 157.0 | 158.0 | 159.0 | 159.5 | 160.0 |      | 26.0              |
| 4                 | 10684           | LC  | 6.0 | -      | -     | -     | 130.0 | 132.0 | 133.0 | 134.0 | 134.5 | 135.0 |      | 25.0              |
| 5                 | 10685           | LC  | 6.0 | -      | -     | -     | -     | 127.0 | 128.0 | 129.0 | 129.5 | 130.0 |      | 5.0               |
| 6                 | 10686           | LC  | 6.0 | -      | -     | -     | -     | -     | 126.0 | 127.0 | 127.5 | 128.0 |      | 2.0               |
| 7                 | 10687           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | 126.0 | 126.5 | 127.0 |      | 1.0               |
| 8                 | 10688           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | 126.0 | 126.5 |      | 0.5               |
| 9                 | 10689           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | -     | 126.0 |      | 0.5               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R

## Digest

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.25BS            | WC-Co         | DFS   |

Thickness 90 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 955             | RH  | 0.5 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10691           | RL  | 1.1 | 179.0  | 197.0 | 235.0 | 245.0 | 247.0 | 248.0 | 250.0 | 250.0 | 250.5 |      | 0.0               |
| 2                 | 10692           | KL  | 3.0 | -      | 132.0 | 170.0 | 180.0 | 182.0 | 183.0 | 185.0 | 185.0 | 185.5 |      | 65.0              |
| 3                 | 10693           | RL  | 2.1 | -      | -     | 144.0 | 154.0 | 156.0 | 157.0 | 159.0 | 159.0 | 159.5 |      | 26.0              |
| 4                 | 10694           | LC  | 6.0 | -      | -     | -     | 129.0 | 131.0 | 132.0 | 134.0 | 134.0 | 134.5 |      | 25.0              |
| 5                 | 10695           | LC  | 6.0 | -      | -     | -     | -     | 127.0 | 128.0 | 130.0 | 130.0 | 130.5 |      | 4.0               |
| 6                 | 10696           | LC  | 6.0 | -      | -     | -     | -     | -     | 126.0 | 128.0 | 128.0 | 128.5 |      | 2.0               |
| 7                 | 10697           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | 127.0 | 127.0 | 127.5 |      | 1.0               |
| 8                 | 10698           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | 126.0 | 126.5 |      | 1.0               |
| 9                 | 10699           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | -     | 126.0 |      | 0.5               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 100 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       |       |      | Step<br>Increment |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-------|------|-------------------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | 9th   | 10th |                   |
| A                 | 955             | RH  | 0.5 |        |       |       |       |       |       |       |       |       |      |                   |
| 1                 | 10711           | RL  | 1.0 | 186.0  | 200.0 | 234.0 | 244.0 | 246.0 | 247.0 | 252.0 | 252.0 | 253.0 |      | 0.0               |
| 2                 | 10712           | KL  | 3.0 | -      | 135.0 | 169.0 | 179.0 | 181.0 | 182.0 | 187.0 | 187.0 | 188.0 |      | 65.0              |
| 3                 | 10713           | RL  | 2.0 | -      | -     | 143.0 | 153.0 | 155.0 | 156.0 | 161.0 | 161.0 | 162.0 |      | 26.0              |
| 4                 | 10714           | LC  | 6.0 | -      | -     | -     | 128.0 | 130.0 | 131.0 | 136.0 | 136.0 | 137.0 |      | 25.0              |
| 5                 | 10715           | LC  | 6.0 | -      | -     | -     | -     | 127.0 | 128.0 | 133.0 | 133.0 | 134.0 |      | 3.0               |
| 6                 | 10716           | LC  | 6.0 | -      | -     | -     | -     | -     | 126.0 | 131.0 | 131.0 | 132.0 |      | 2.0               |
| 7                 | 10717           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | 129.0 | 129.0 | 130.0 |      | 2.0               |
| 8                 | 10718           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | 127.0 | 128.0 |      | 2.0               |
| 9                 | 10719           | DFS | 5.0 | -      | -     | -     | -     | -     | -     | -     | -     | 127.0 |      | 1.0               |
| 10                |                 |     |     | -      | -     | -     | -     | -     | -     | -     | -     | -     |      |                   |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 13.0  | 6.0   | 2.5   | 2.0   | 1.5   | 1.2   | 0.9   |      |                   |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.80  | 0.80  | 0.30  | 0.28  | 0.18  | 0.15  | 0.13  |      |                   |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     |     |      | Step<br>Increment |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----|------|-------------------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | 9th | 10th |                   |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |     |      |                   |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |     |      |                   |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |     |      |                   |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |     |      |                   |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |     |      |                   |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |     |      |                   |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |     |      |                   |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |     |      |                   |
| 9                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   | -   |     |      |                   |
| 10                |                 |    |    | -      | -   | -   | -   | -   | -   | -   | -   | -   |      |                   |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |     |      |                   |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |     |      |                   |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 5mm                | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                    | Skim2                 | Skim3                 | Skim4                    | Skim5                    | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|--------------------------|-----------------------|-----------------------|--------------------------|--------------------------|-------|-------|
| E-pack Number      | Eno | 951                   | 10601                 | 10602                    | 10603                 | 10604                 | 10605                    | 10606                    | 10607 | 10608 |
| Power Supply       | PS  | RH                    | KL                    | KL                       | RL                    | LC                    | LC                       | LC                       | DFS   | DFS   |
| Servo              | SV  | NM                    | NM                    | NM                       | NM                    | SL                    | SL                       | SL                       | NM    | NM    |
| Voltage Open       | Vo  | 7                     | 4                     | 8                        | 4                     | 10                    | 14                       | 14                       | 13    | 10    |
| Power Setting      | IP  | 7.0                   | 12.0                  | 9.0                      | 7.0                   | 2.5                   | 2.5                      | 2.0                      | 1.0   | 1.0   |
| IP adjust          | ΔIP | 11                    | 13                    | 10                       | 10                    |                       |                          |                          |       |       |
| Off Time           | OFF | 6                     | 1                     | 3                        | 10                    | 10                    | 4                        | 3                        | 13    | 13    |
| Stabilizer A       | SA  | 3                     | 7                     | 5                        | 4                     | 2                     | 1                        | 1                        | 6     | 6     |
| Stabilizer B       | SB  | 8                     | 9                     | 12                       | 10                    | 10                    | 8                        | 8                        | 1     | 1     |
| Stabilizer C       | SC  | 7                     | 3                     | 1                        | 1                     | 1                     | 1                        | 1                        | 1     | 1     |
| Stabilizer E       | SE  | 4                     | 4                     | 1                        | 1                     | 1                     | 1                        | 1                        | 1     | 1     |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(57.0 ~ 63.0) | 103.0<br>(101.0 ~ 105.0) | 65.0<br>(63.0 ~ 67.0) | 75.0<br>(73.0 ~ 77.0) | 120.0<br>(118.0 ~ 122.0) | 110.0<br>(108.0 ~ 112.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   | ON                       | ON                       | OFF   | OFF   |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                      | OFF                   | OFF                   | OFF                      | OFF                      | OFF   | OFF   |
| Wire Speed         | WS  | 8                     | 9                     | 10                       | 10                    | 10                    | 10                       | 10                       | 10    | 10    |
| Wire Tension       | WT  | 9                     | 10                    | 14                       | 14                    | 14                    | 14                       | 14                       | 10    | 10    |
| Pre-Tension        | PT  | 14                    | 14                    | 14                       | 14                    | 14                    | 14                       | 14                       | 14    | 14    |
| Flow Balance       | FB  | NM                    | NM                    | NM                       | NM                    | NM                    | NM                       | NM                       | NM    | NM    |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                        | 4                     | 4                     | 4                        | 4                        | 4     | 4     |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                       | 10                    | 10                    | 10                       | 10                       | 10    | 10    |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                        | 0                     | 0                     | 0                        | 0                        | 0     | 0     |
| Feedrate Address   | FA  | 2.0                   | 3.7                   | 6.0                      | 6.0                   | 7.0                   | 7.0                      | 7.0                      | 6.5   | 6.5   |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   | 1.0                      | 1.0                      | 1.0   | 1.0   |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                      | 1.0                   | 1.0                   | 1.0                      | 1.0                      | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 156.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 204.0 | 134.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 242.0 | 172.0 | 136.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 260.0 | 190.0 | 154.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 265.0 | 195.0 | 159.0 | 134.0 | 129.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 268.0 | 198.0 | 162.0 | 137.0 | 132.0 | 130.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 268.0 | 198.0 | 162.0 | 137.0 | 132.0 | 130.0 | 128.0 | ----- |
| Rough & 7 Skims    | ----- | 268.0 | 198.0 | 162.0 | 137.0 | 132.0 | 130.0 | 128.0 | 127.0 |
| Stepping Increment | ----- | ----- | 70.0  | 36.0  | 25.0  | 5.0   | 2.0   | 2.0   | 1.0   |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 7.2 ~ 9.6   | 11.4 ~ 14.8 | 11.5 ~ 15.2 | 6.8 ~ 7.6   | 6.8 ~ 7.5   | 6.8 ~ 7.6   | 6.5 ~ 6.5   | 6.5 ~ 6.5   |
| Average Voltage Gap  | V   |  | 63 ~ 75     | 109 ~ 130   | 66 ~ 82     | 88 ~ 102    | 132 ~ 144   | 127 ~ 141   |             |             |
| Avg. Linear Feedrate | ALF |  | 504.0       | 307.1       | 222.0       | 146.6       | 109.3       | 87.2        | 71.3        | 60.3        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 10mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                    | Skim5                 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|
| E-pack Number      | Eno | 951                   | 10611                 | 10612                 | 10613                 | 10614                 | 10615                    | 10616                 | 10617 | 10618 |
| Power Supply       | PS  | RH                    | KL                    | KL                    | RL                    | LC                    | LC                       | LC                    | DFS   | DFS   |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                       | SL                    | NM    | NM    |
| Voltage Open       | Vo  | 7                     | 4                     | 8                     | 4                     | 10                    | 14                       | 14                    | 13    | 11    |
| Power Setting      | IP  | 7.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                      | 2.0                   | 1.0   | 1.0   |
| IP adjust          | ΔIP | 11                    | 13                    | 10                    | 10                    |                       |                          |                       |       |       |
| Off Time           | OFF | 6                     | 1                     | 3                     | 10                    | 10                    | 4                        | 3                     | 13    | 13    |
| Stabilizer A       | SA  | 3                     | 7                     | 5                     | 4                     | 2                     | 1                        | 1                     | 6     | 6     |
| Stabilizer B       | SB  | 8                     | 9                     | 12                    | 10                    | 10                    | 8                        | 8                     | 1     | 2     |
| Stabilizer C       | SC  | 7                     | 3                     | 1                     | 1                     | 1                     | 1                        | 1                     | 1     | 1     |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                        | 1                     | 1     | 1     |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(57.0 ~ 63.0) | 83.0<br>(81.0 ~ 85.0) | 60.0<br>(58.0 ~ 62.0) | 80.0<br>(78.0 ~ 82.0) | 105.0<br>(103.0 ~ 107.0) | 90.0<br>(88.0 ~ 92.0) |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    | OFF   | OFF   |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                      | OFF                   | OFF   | OFF   |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 10                    | 10                       | 10                    | 12    | 12    |
| Wire Tension       | WT  | 9                     | 10                    | 14                    | 14                    | 14                    | 14                       | 14                    | 10    | 10    |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    | 14                    | 14                       | 14                    | 14    | 14    |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    | NM    | NM    |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     | 4                     | 4                        | 4                     | 4     | 4     |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    | 10    | 10    |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     | 0     | 0     |
| Feedrate Address   | FA  | 2.0                   | 2.7                   | 5.0                   | 5.0                   | 7.0                   | 7.0                      | 7.0                   | 6.5   | 6.5   |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0   | 1.0   |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 155.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 196.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 228.0 | 163.0 | 137.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 245.0 | 180.0 | 154.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 250.0 | 185.0 | 159.0 | 134.0 | 129.0 | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 252.0 | 187.0 | 161.0 | 136.0 | 131.0 | 129.0 | ----- | ----- |
| Rough & 6 Skims    | ----- | 254.0 | 189.0 | 163.0 | 138.0 | 133.0 | 131.0 | 126.0 | ----- |
| Rough & 7 Skims    | ----- | 255.0 | 190.0 | 164.0 | 139.0 | 134.0 | 132.0 | 127.0 | 125.0 |
| Stepping Increment | ----- | ----- | 65.0  | 26.0  | 25.0  | 5.0   | 2.0   | 5.0   | 2.0   |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 3.2 ~ 4.3   | 11.9 ~ 14.9 | 9.9 ~ 13.1  | 6.7 ~ 7.5   | 6.7 ~ 7.5   | 6.8 ~ 7.5   | 6.5 ~ 6.5   |
| Average Voltage Gap  | V   |  | 65 ~ 79     | 100 ~ 114   | 62 ~ 79     | 85 ~ 99     | 111 ~ 126   | 101 ~ 117   |             |
| Avg. Linear Feedrate | ALF |  | 225.0       | 175.8       | 140.1       | 105.4       | 84.5        | 70.6        | 51.8        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 20.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 951                   | 10621                 | 10622                 | 10623                 | 10624                 | 10625                 | 10626                 | 10627 | 10628 | 10629 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 8                     | 4                     | 10                    | 14                    | 14                    | 16    | 14    | 12    |
| Power Setting      | IP       | 7.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 4                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 8                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 8                     | 5                     | 12                    | 10                    | 10                    | 8                     | 8                     | 7     | 1     | 2     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 60.0<br>(58.0 ~ 62.0) | 30.0<br>(27.0 ~ 33.0) | 78.0<br>(76.0 ~ 80.0) | 65.0<br>(63.0 ~ 67.0) | 55.0<br>(53.0 ~ 57.0) | 80.0<br>(78.0 ~ 82.0) | 70.0<br>(68.0 ~ 72.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 10    | 10    | 10    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     | 0     |
| Feedrate Address   | FA       | 2.0                   | 2.5                   | 5.0                   | 5.0                   | 7.0                   | 7.0                   | 7.0                   | 6.5   | 6.5   | 6.5   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 156.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 194.0 | 129.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 231.0 | 166.0 | 140.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 245.0 | 180.0 | 154.0 | 129.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 248.0 | 183.0 | 157.0 | 132.0 | 129.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 250.0 | 185.0 | 159.0 | 134.0 | 131.0 | 129.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 252.0 | 187.0 | 161.0 | 136.0 | 133.0 | 131.0 | 128.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 252.0 | 187.0 | 161.0 | 136.0 | 133.0 | 131.0 | 128.0 | 127.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 252.0 | 187.0 | 161.0 | 136.0 | 133.0 | 131.0 | 128.0 | 127.0 | 126.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 26.0  | 25.0  | 3.0   | 2.0   | 3.0   | 1.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 2.9 ~ 4.0   | 11.1 ~ 14.2 | 4.2 ~ 5.8   | 6.9 ~ 7.6   | 6.8 ~ 7.6   | 6.8 ~ 7.6   | 6.5 ~ 6.5   | 6.5 ~ 6.5   | 6.5 ~ 6.5   |
| Average Voltage Gap  | V   |  | 19 ~ 45     | 89 ~ 104    | 56 ~ 74     | 79 ~ 91     | 95 ~ 109    | 86 ~ 100    |             |             |             |
| Avg. Linear Feedrate | ALF |  | 207.0       | 162.6       | 105.5       | 84.9        | 70.9        | 60.9        | 52.7        | 46.4        | 41.5        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 30.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 952                   | 10631                 | 10632                 | 10633                 | 10634                 | 10635                 | 10636                 | 10637 | 10638 | 10639 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 8                     | 4                     | 10                    | 14                    | 14                    | 16    | 14    | 12    |
| Power Setting      | IP       | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 4                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 9                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 8                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     | 7     | 1     | 2     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(27.0 ~ 33.0) | 75.0<br>(73.0 ~ 77.0) | 62.0<br>(60.0 ~ 64.0) | 52.0<br>(50.0 ~ 54.0) | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 10    | 10    | 10    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 1.0                   | 2.1                   | 4.5                   | 4.0                   | 6.5                   | 6.5                   | 6.5                   | 5.5   | 5.5   | 5.5   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 160.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 192.0 | 127.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 232.0 | 167.0 | 141.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 246.0 | 181.0 | 155.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 250.0 | 185.0 | 159.0 | 134.0 | 129.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 251.0 | 186.0 | 160.0 | 135.0 | 130.0 | 128.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 253.0 | 188.0 | 162.0 | 137.0 | 132.0 | 130.0 | 128.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 253.5 | 188.5 | 162.5 | 137.5 | 132.5 | 130.5 | 128.5 | 128.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 253.0 | 188.0 | 162.0 | 137.0 | 132.0 | 130.0 | 128.0 | 127.5 | 127.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 26.0  | 25.0  | 5.0   | 2.0   | 2.0   | 0.5   | 0.5   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 2.3 ~ 3.2   | 9.6 ~ 12.3  | 3.0 ~ 4.3   | 6.4 ~ 7.1   | 6.4 ~ 7.1   | 6.3 ~ 6.9   | 5.5 ~ 5.5   | 5.5 ~ 5.5   | 5.5 ~ 5.5   |
| Average Voltage Gap  | V   |  | 20 ~ 42     | 82 ~ 97     | 54 ~ 73     | 71 ~ 84     | 80 ~ 95     | 71 ~ 84     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 165.0       | 131.9       | 82.3        | 68.4        | 58.5        | 51.0        | 44.2        | 39.0        | 34.8        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 40.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 952                   | 10641                 | 10642                 | 10643                 | 10644                 | 10645                 | 10646                 | 10647 | 10648 | 10649 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 8                     | 4                     | 10                    | 14                    | 14                    | 16    | 14    | 12    |
| Power Setting      | IP       | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 4                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 9                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 8                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     | 7     | 1     | 2     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(27.0 ~ 33.0) | 73.0<br>(71.0 ~ 75.0) | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(43.0 ~ 47.0) | 35.0<br>(33.0 ~ 37.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 10    | 10    | 10    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 1.0                   | 1.7                   | 4.0                   | 3.0                   | 6.0                   | 6.0                   | 6.0                   | 5.0   | 5.0   | 5.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 164.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 191.0 | 126.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 232.0 | 167.0 | 141.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 247.0 | 182.0 | 156.0 | 131.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 250.0 | 185.0 | 159.0 | 134.0 | 129.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 251.0 | 186.0 | 160.0 | 135.0 | 130.0 | 128.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 253.0 | 188.0 | 162.0 | 137.0 | 132.0 | 130.0 | 128.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 253.5 | 188.5 | 162.5 | 137.5 | 132.5 | 130.5 | 128.5 | 128.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 254.0 | 189.0 | 163.0 | 138.0 | 133.0 | 131.0 | 129.0 | 128.5 | 128.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 26.0  | 25.0  | 5.0   | 2.0   | 2.0   | 0.5   | 0.5   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.6 ~ 2.3   | 8.0 ~ 10.3  | 1.8 ~ 2.8   | 5.8 ~ 6.5   | 5.9 ~ 6.5   | 5.8 ~ 6.1   | 5.0 ~ 5.0   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 21 ~ 38     | 75 ~ 89     | 52 ~ 71     | 62 ~ 76     | 65 ~ 81     | 55 ~ 67     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 117.0       | 96.4        | 56.8        | 49.2        | 43.5        | 38.7        | 34.3        | 30.8        | 27.9        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 50.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 953                   | 10651                 | 10652                 | 10653                 | 10654                 | 10655                 | 10656                 | 10657 | 10658 | 10659 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 8                     | 4                     | 10                    | 14                    | 14                    | 16    | 14    | 12    |
| Power Setting      | IP       | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 4                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 9                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 3                     | 12                    | 10                    | 10                    | 8                     | 8                     | 7     | 1     | 2     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(27.0 ~ 33.0) | 73.0<br>(71.0 ~ 75.0) | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(43.0 ~ 47.0) | 35.0<br>(33.0 ~ 37.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 10    | 10    | 10    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.7                   | 1.4                   | 3.7                   | 2.7                   | 6.0                   | 6.0                   | 6.0                   | 5.0   | 5.0   | 5.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 164.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 191.0 | 126.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 235.0 | 170.0 | 144.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 246.0 | 181.0 | 155.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 249.0 | 184.0 | 158.0 | 133.0 | 128.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 250.0 | 185.0 | 159.0 | 134.0 | 129.0 | 127.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 252.0 | 187.0 | 161.0 | 136.0 | 131.0 | 129.0 | 127.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 252.5 | 187.5 | 161.5 | 136.5 | 131.5 | 129.5 | 127.5 | 127.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 253.0 | 188.0 | 162.0 | 137.0 | 132.0 | 130.0 | 128.0 | 127.5 | 127.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 26.0  | 25.0  | 5.0   | 2.0   | 2.0   | 0.5   | 0.5   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.2 ~ 1.9   | 6.5 ~ 8.4   | 1.5 ~ 2.4   | 5.8 ~ 6.4   | 5.9 ~ 6.5   | 5.8 ~ 6.1   | 5.0 ~ 5.0   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 23 ~ 37     | 70 ~ 85     | 52 ~ 70     | 58 ~ 72     | 59 ~ 73     | 50 ~ 62     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 93.0        | 77.0        | 46.4        | 41.2        | 37.1        | 33.6        | 30.2        | 27.5        | 25.2        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 60.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 953                   | 10661                 | 10662                 | 10663                 | 10664                 | 10665                 | 10666                 | 10667 | 10668 | 10669 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 8                     | 4                     | 10                    | 14                    | 14                    | 16    | 14    | 12    |
| Power Setting      | IP       | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 4                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 9                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 3                     | 12                    | 10                    | 10                    | 8                     | 8                     | 7     | 1     | 2     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(27.0 ~ 33.0) | 73.0<br>(71.0 ~ 75.0) | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(48.0 ~ 52.0) | 45.0<br>(43.0 ~ 47.0) | 35.0<br>(33.0 ~ 37.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 10    | 10    | 10    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 20                    | 20                    | 20                    | 20                    | 20                    | 20                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.7                   | 1.2                   | 3.5                   | 2.5                   | 6.0                   | 6.0                   | 6.0                   | 5.0   | 5.0   | 5.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 164.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 191.0 | 126.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 235.0 | 170.0 | 144.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 246.0 | 181.0 | 155.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 249.0 | 184.0 | 158.0 | 133.0 | 128.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 250.0 | 185.0 | 159.0 | 134.0 | 129.0 | 127.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 251.0 | 186.0 | 160.0 | 135.0 | 130.0 | 128.0 | 126.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 252.5 | 187.5 | 161.5 | 136.5 | 131.5 | 129.5 | 127.5 | 127.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 253.0 | 188.0 | 162.0 | 137.0 | 132.0 | 130.0 | 128.0 | 127.5 | 127.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 26.0  | 25.0  | 5.0   | 2.0   | 2.0   | 0.5   | 0.5   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.5   | 5.0 ~ 6.5   | 1.2 ~ 1.9   | 5.7 ~ 6.3   | 5.8 ~ 6.4   | 5.8 ~ 6.1   | 5.0 ~ 5.0   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 24 ~ 35     | 65 ~ 80     | 52 ~ 69     | 54 ~ 67     | 53 ~ 65     | 44 ~ 56     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 69.0        | 57.5        | 35.5        | 32.3        | 29.7        | 27.4        | 25.1        | 23.2        | 21.5        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 70.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 954                   | 10671                 | 10672                 | 10673                 | 10674                 | 10675                 | 10676                 | 10677 | 10678 | 10679 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 8                     | 4                     | 10                    | 14                    | 14                    | 16    | 14    | 12    |
| Power Setting      | IP       | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 4                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 9                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 3                     | 12                    | 10                    | 10                    | 8                     | 8                     | 7     | 1     | 2     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 35.0<br>(32.0 ~ 38.0) | 70.0<br>(68.0 ~ 72.0) | 57.0<br>(55.0 ~ 59.0) | 40.0<br>(38.0 ~ 42.0) | 37.0<br>(35.0 ~ 39.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 10    | 10    | 10    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 20                    | 30                    | 30                    | 30                    | 30                    | 30                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.6                   | 1.2                   | 3.2                   | 2.3                   | 6.0                   | 6.0                   | 6.0                   | 5.0   | 5.0   | 5.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 168.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 191.0 | 126.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 235.0 | 170.0 | 144.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 246.0 | 181.0 | 155.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 249.0 | 184.0 | 158.0 | 133.0 | 128.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 250.0 | 185.0 | 159.0 | 134.0 | 129.0 | 127.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 251.0 | 186.0 | 160.0 | 135.0 | 130.0 | 128.0 | 126.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 252.5 | 187.5 | 161.5 | 136.5 | 131.5 | 129.5 | 127.5 | 127.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 253.0 | 188.0 | 162.0 | 137.0 | 132.0 | 130.0 | 128.0 | 127.5 | 127.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 26.0  | 25.0  | 5.0   | 2.0   | 2.0   | 0.5   | 0.5   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.4   | 5.9 ~ 7.6   | 1.2 ~ 1.9   | 5.8 ~ 6.4   | 5.8 ~ 6.4   | 5.8 ~ 6.3   | 5.0 ~ 5.0   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 30 ~ 42     | 70 ~ 85     | 50 ~ 67     | 48 ~ 61     | 48 ~ 60     | 39 ~ 52     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 66.0        | 56.8        | 35.2        | 32.1        | 29.6        | 27.3        | 25.0        | 23.1        | 21.5        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 80.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 954                   | 10681                 | 10682                 | 10683                 | 10684                 | 10685                 | 10686                 | 10687 | 10688 | 10689 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 8                     | 4                     | 10                    | 14                    | 14                    | 16    | 14    | 12    |
| Power Setting      | IP       | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 4                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 9                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 7                     | 3                     | 12                    | 10                    | 10                    | 8                     | 8                     | 7     | 1     | 2     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 68.0<br>(66.0 ~ 70.0) | 55.0<br>(53.0 ~ 57.0) | 30.0<br>(28.0 ~ 32.0) | 30.0<br>(28.0 ~ 32.0) | 25.0<br>(23.0 ~ 27.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 10    | 10    | 10    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 40                    | 40                    | 40                    | 40                    | 40                    | 40                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.6                   | 1.1                   | 3.0                   | 2.2                   | 6.0                   | 6.0                   | 6.0                   | 5.0   | 5.0   | 5.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 173.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 194.0 | 129.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 235.0 | 170.0 | 144.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 246.0 | 181.0 | 155.0 | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 248.0 | 183.0 | 157.0 | 132.0 | 127.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 249.0 | 184.0 | 158.0 | 133.0 | 128.0 | 126.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 250.0 | 185.0 | 159.0 | 134.0 | 129.0 | 127.0 | 126.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 250.5 | 185.5 | 159.5 | 134.5 | 129.5 | 127.5 | 126.5 | 126.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 251.0 | 186.0 | 160.0 | 135.0 | 130.0 | 128.0 | 127.0 | 126.5 | 126.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 26.0  | 25.0  | 5.0   | 2.0   | 1.0   | 0.5   | 0.5   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.2   | 6.7 ~ 8.6   | 1.1 ~ 1.9   | 5.8 ~ 6.4   | 5.8 ~ 6.4   | 5.8 ~ 6.4   | 5.0 ~ 5.0   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 35 ~ 49     | 74 ~ 89     | 48 ~ 65     | 42 ~ 54     | 42 ~ 54     | 34 ~ 47     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 60.0        | 53.1        | 33.4        | 30.6        | 28.2        | 26.2        | 24.1        | 22.3        | 20.8        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 90.00              | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 955                   | 10691                 | 10692                 | 10693                 | 10694                 | 10695                 | 10696                 | 10697 | 10698 | 10699 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 8                     | 4                     | 11                    | 14                    | 14                    | 16    | 14    | 12    |
| Power Setting      | IP       | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 12                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 4                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 9                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 6                     | 3                     | 12                    | 10                    | 10                    | 8                     | 8                     | 7     | 1     | 2     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 68.0<br>(66.0 ~ 70.0) | 55.0<br>(53.0 ~ 57.0) | 30.0<br>(28.0 ~ 32.0) | 27.0<br>(25.0 ~ 29.0) | 25.0<br>(23.0 ~ 27.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 10    | 10    | 10    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 40                    | 40                    | 40                    | 40                    | 40                    | 40                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.5                   | 1.1                   | 3.0                   | 2.1                   | 6.0                   | 6.0                   | 6.0                   | 5.0   | 5.0   | 5.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 179.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 197.0 | 132.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 235.0 | 170.0 | 144.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 245.0 | 180.0 | 154.0 | 129.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 247.0 | 182.0 | 156.0 | 131.0 | 127.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 248.0 | 183.0 | 157.0 | 132.0 | 128.0 | 126.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 250.0 | 185.0 | 159.0 | 134.0 | 130.0 | 128.0 | 127.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 250.0 | 185.0 | 159.0 | 134.0 | 130.0 | 128.0 | 127.0 | 126.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 250.5 | 185.5 | 159.5 | 134.5 | 130.5 | 128.5 | 127.5 | 126.5 | 126.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 26.0  | 25.0  | 4.0   | 2.0   | 1.0   | 1.0   | 0.5   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.6 ~ 1.3   | 6.8 ~ 8.7   | 1.0 ~ 1.7   | 5.8 ~ 6.4   | 5.8 ~ 6.4   | 5.8 ~ 6.4   | 5.0 ~ 5.0   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 35 ~ 48     | 77 ~ 92     | 46 ~ 65     | 42 ~ 54     | 40 ~ 52     | 33 ~ 45     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 57.0        | 50.8        | 31.2        | 28.8        | 26.7        | 24.9        | 23.0        | 21.3        | 19.9        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.25BS           | WC-Co         | 100.00             | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    | Start Up | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5                 | Skim6                 | Skim7 | Skim8 | Skim9 |
|--------------------|----------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno      | 955                   | 10711                 | 10712                 | 10713                 | 10714                 | 10715                 | 10716                 | 10717 | 10718 | 10719 |
| Power Supply       | PS       | RH                    | RL                    | KL                    | RL                    | LC                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV       | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo       | 7                     | 4                     | 8                     | 4                     | 12                    | 14                    | 14                    | 16    | 15    | 13    |
| Power Setting      | IP       | 8.0                   | 12.0                  | 9.0                   | 8.0                   | 2.5                   | 2.5                   | 2.0                   | 2.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP      | 11                    | 14                    | 10                    | 10                    |                       |                       |                       |       |       |       |
| Off Time           | OFF      | 6                     | 4                     | 3                     | 10                    | 10                    | 4                     | 3                     | 13    | 13    | 13    |
| Stabilizer A       | SA       | 3                     | 9                     | 5                     | 4                     | 2                     | 1                     | 1                     | 6     | 6     | 6     |
| Stabilizer B       | SB       | 6                     | 4                     | 12                    | 10                    | 10                    | 8                     | 8                     | 6     | 1     | 1     |
| Stabilizer C       | SC       | 7                     | 3                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Stabilizer E       | SE       | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG       | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 68.0<br>(66.0 ~ 70.0) | 55.0<br>(53.0 ~ 57.0) | 30.0<br>(28.0 ~ 32.0) | 25.0<br>(23.0 ~ 27.0) | 25.0<br>(23.0 ~ 27.0) |       |       |       |
| Fine machining     | FM       | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE      | OFF                   | OFF                   | ON                    | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS       | 8                     | 9                     | 12                    | 12                    | 10                    | 10                    | 10                    | 12    | 12    | 12    |
| Wire Tension       | WT       | 9                     | 10                    | 14                    | 14                    | 14                    | 14                    | 14                    | 10    | 10    | 10    |
| Pre-Tension        | PT       | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14                    | 14    | 14    | 14    |
| Flow Balance       | FB       | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ       | 11                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR       | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC       | 0                     | 40                    | 40                    | 40                    | 40                    | 40                    | 40                    | 0     | 0     | 0     |
| Feedrate Address   | FA       | 0.5                   | 1.0                   | 3.0                   | 2.0                   | 6.0                   | 6.0                   | 6.0                   | 5.0   | 5.0   | 5.0   |
| Upper Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |          | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 186.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 200.0 | 135.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 234.0 | 169.0 | 143.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 244.0 | 179.0 | 153.0 | 128.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 246.0 | 181.0 | 155.0 | 130.0 | 127.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 247.0 | 182.0 | 156.0 | 131.0 | 128.0 | 126.0 | ----- | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- | 252.0 | 187.0 | 161.0 | 136.0 | 133.0 | 131.0 | 129.0 | ----- | ----- | ----- |
| Rough & 7 Skims    | ----- | 252.0 | 187.0 | 161.0 | 136.0 | 133.0 | 131.0 | 129.0 | 127.0 | ----- | ----- |
| Rough & 8 Skims    | ----- | 253.0 | 188.0 | 162.0 | 137.0 | 134.0 | 132.0 | 130.0 | 128.0 | 127.0 | ----- |
| Rough & 9 Skims    | ----- |       |       |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 26.0  | 25.0  | 3.0   | 2.0   | 2.0   | 2.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.3 ~ 1.3   | 6.8 ~ 8.7   | 0.8 ~ 1.5   | 5.8 ~ 6.4   | 5.8 ~ 6.4   | 5.8 ~ 6.4   | 5.0 ~ 5.0   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 35 ~ 47     | 80 ~ 94     | 44 ~ 64     | 41 ~ 54     | 38 ~ 50     | 31 ~ 43     |             |             |             |
| Avg. Linear Feedrate | ALF |  | 48.0        | 43.5        | 26.7        | 24.9        | 23.3        | 21.9        | 20.4        | 19.1        | 18.0        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 11.7 ~ 14.3 | 5.4 ~ 6.6   | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 1.1 ~ 1.3   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.62 ~ 2.70 | 0.72 ~ 1.20 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.14 ~ 0.23 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.15BS            | STEEL         | DFS   |

Thickness 5 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 971             | RH  | 1.0 |        |       |       |       |       |       |       |     |           |
| 1                 | 11611           | RH  | 3.2 | 101.0  | 119.0 | 145.0 | 162.0 | 166.0 | 167.0 | 170.0 |     | 0.0       |
| 2                 | 11612           | RL  | 9.0 | -      | 79.0  | 105.0 | 122.0 | 126.0 | 127.0 | 130.0 |     | 40.0      |
| 3                 | 11613           | HL  | 9.0 | -      | -     | 75.0  | 92.0  | 96.0  | 97.0  | 100.0 |     | 30.0      |
| 4                 | 11614           | LC  | 7.0 | -      | -     | -     | 82.0  | 86.0  | 87.0  | 90.0  |     | 10.0      |
| 5                 | 11615           | LC  | 7.0 | -      | -     | -     | -     | 80.0  | 81.0  | 84.0  |     | 6.0       |
| 6                 | 11616           | DFS | 6.0 | -      | -     | -     | -     | -     | 76.0  | 79.0  |     | 5.0       |
| 7                 | 11617           | DFS | 6.0 | -      | -     | -     | -     | -     | -     | 76.0  |     | 3.0       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 11.0  | 3.5   | 2.0   | 1.8   | 1.2   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.50  | 0.48  | 0.28  | 0.20  | 0.15  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 971             | RH  | 1.0 |        |       |       |       |       |       |       |     |           |
| 1                 | 11621           | RH  | 4.0 | 102.0  | 120.0 | 141.0 | 157.0 | 161.0 | 161.0 | 162.5 |     | 0.0       |
| 2                 | 11622           | RL  | 7.0 | -      | 80.0  | 101.0 | 117.0 | 121.0 | 121.0 | 122.5 |     | 40.0      |
| 3                 | 11623           | HL  | 7.0 | -      | -     | 76.0  | 92.0  | 96.0  | 96.0  | 97.5  |     | 25.0      |
| 4                 | 11624           | LC  | 6.5 | -      | -     | -     | 82.0  | 86.0  | 86.0  | 87.5  |     | 10.0      |
| 5                 | 11625           | LC  | 6.5 | -      | -     | -     | -     | 84.0  | 84.0  | 85.5  |     | 2.0       |
| 6                 | 11626           | DFS | 6.0 | -      | -     | -     | -     | -     | 79.0  | 80.5  |     | 5.0       |
| 7                 | 11627           | DFS | 5.5 | -      | -     | -     | -     | -     | -     | 78.0  |     | 2.5       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 11.0  | 3.5   | 2.0   | 1.8   | 1.2   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.50  | 0.48  | 0.28  | 0.20  | 0.15  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 971             | RH  | 1.0 |        |       |       |       |       |       |       |     |           |
| 1                 | 11631           | RH  | 2.5 | 106.0  | 120.0 | 142.0 | 158.0 | 160.0 | 162.0 | 165.0 |     | 0.0       |
| 2                 | 11632           | RL  | 6.0 | -      | 80.0  | 102.0 | 118.0 | 120.0 | 122.0 | 125.0 |     | 40.0      |
| 3                 | 11633           | HL  | 6.0 | -      | -     | 77.0  | 93.0  | 95.0  | 97.0  | 100.0 |     | 25.0      |
| 4                 | 11634           | LC  | 6.0 | -      | -     | -     | 81.0  | 83.0  | 85.0  | 88.0  |     | 12.0      |
| 5                 | 11635           | LC  | 6.0 | -      | -     | -     | -     | 80.0  | 82.0  | 85.0  |     | 3.0       |
| 6                 | 11636           | DFS | 5.0 | -      | -     | -     | -     | -     | 77.0  | 80.0  |     | 5.0       |
| 7                 | 11637           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | 78.0  |     | 2.0       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 11.0  | 3.5   | 2.0   | 1.8   | 1.2   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.50  | 0.48  | 0.28  | 0.20  | 0.15  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.15BS            | STEEL         | DFS   |

Thickness 30 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 972             | RH  | 0.6 |        |       |       |       |       |       |       |     |           |
| 1                 | 11641           | RH  | 1.8 | 106.0  | 122.0 | 143.0 | 160.0 | 162.0 | 165.0 | 167.0 |     | 0.0       |
| 2                 | 11642           | RL  | 5.0 | -      | 80.0  | 101.0 | 118.0 | 120.0 | 123.0 | 125.0 |     | 42.0      |
| 3                 | 11643           | HL  | 5.0 | -      | -     | 76.0  | 93.0  | 95.0  | 98.0  | 100.0 |     | 25.0      |
| 4                 | 11644           | LC  | 5.7 | -      | -     | -     | 81.0  | 83.0  | 86.0  | 88.0  |     | 12.0      |
| 5                 | 11645           | LC  | 5.7 | -      | -     | -     | -     | 80.0  | 83.0  | 85.0  |     | 3.0       |
| 6                 | 11646           | DFS | 5.0 | -      | -     | -     | -     | -     | 79.0  | 81.0  |     | 4.0       |
| 7                 | 11647           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | 79.0  |     | 2.0       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 11.0  | 3.5   | 2.0   | 1.8   | 1.2   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.50  | 0.48  | 0.28  | 0.20  | 0.15  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |       | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-------|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th   | Increment |
| A                 | 972             | RH  | 0.6 |        |       |       |       |       |       |       |       |           |
| 1                 | 11651           | RH  | 1.2 | 106.0  | 124.0 | 145.0 | 161.0 | 165.0 | 167.0 | 168.0 | 169.0 | 0.0       |
| 2                 | 11652           | RL  | 4.0 | -      | 79.0  | 100.0 | 116.0 | 120.0 | 122.0 | 123.0 | 124.0 | 45.0      |
| 3                 | 11653           | HL  | 4.0 | -      | -     | 75.0  | 91.0  | 95.0  | 97.0  | 98.0  | 99.0  | 25.0      |
| 4                 | 11654           | LC  | 5.5 | -      | -     | -     | 81.0  | 85.0  | 87.0  | 88.0  | 89.0  | 10.0      |
| 5                 | 11655           | LC  | 5.5 | -      | -     | -     | -     | 81.0  | 83.0  | 84.0  | 85.0  | 4.0       |
| 6                 | 11656           | DFS | 5.0 | -      | -     | -     | -     | -     | 80.0  | 81.0  | 82.0  | 3.0       |
| 7                 | 11657           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | 80.0  | 81.0  | 1.0       |
| 8                 | 11658           | DFS | 4.0 | -      | -     | -     | -     | -     | -     | -     | 80.0  | 1.0       |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0  | 11.0  | 3.5   | 2.0   | 1.8   | 1.5   | 1.2   |           |
|                   |                 |     | Ra  | 2.50   | 2.00  | 1.50  | 0.48  | 0.28  | 0.20  | 0.18  | 0.15  |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | STEEL         | 5mm                | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 11611                 | 11612                 | 11613                 | 11614                    | 11615                 | 11616 | 11617 |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | HL                    | LC                       | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 6                     | 6                     | 12                       | 8                     | 10    | 8     |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 2.5                      | 1.0                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 6                     |                          |                       |       |       |       |
| Off Time           | OFF | 4                     | 4                     | 14                    | 10                    | 1                        | 1                     | 9     | 7     |       |
| Stabilizer A       | SA  | 2                     | 1                     | 3                     | 1                     | 1                        | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 14                    | 12                    | 14                    | 10                    | 1                        | 1                     | 7     | 7     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     | 1     | 1     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 68.0<br>(65.0 ~ 71.0) | 48.0<br>(46.0 ~ 50.0) | 70.0<br>(68.0 ~ 72.0) | 165.0<br>(163.0 ~ 167.0) | 90.0<br>(88.0 ~ 92.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                       | 12                    | 12    | 12    |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                        | 7                     | 7     | 7     |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                       | 12                    | 12    | 12    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                        | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 1.0                   | 3.2                   | 9.0                   | 9.0                   | 7.0                      | 7.0                   | 6.0   | 6.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 101.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 119.0 | 79.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 145.0 | 105.0 | 75.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 162.0 | 122.0 | 92.0  | 82.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 166.0 | 126.0 | 96.0  | 86.0  | 80.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 167.0 | 127.0 | 97.0  | 87.0  | 81.0  | 76.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 170.0 | 130.0 | 100.0 | 90.0  | 84.0  | 79.0  | 76.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 30.0  | 10.0  | 6.0   | 5.0   | 3.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 5.4 ~ 7.5   | 14.1 ~ 18.0 | 7.1 ~ 9.3   | 6.7 ~ 7.6   | 6.7 ~ 7.5   | 5.7 ~ 6.3   | 6.0 ~ 6.0   |
| Average Voltage Gap  | V   |  | 56 ~ 73     | 41 ~ 56     | 62 ~ 79     | 170 ~ 181   | 92 ~ 106    |             |             |
| Avg. Linear Feedrate | ALF |  | 387.0       | 276.1       | 176.8       | 125.2       | 96.8        | 76.3        | 62.9        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | STEEL         | 10mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 11621                 | 11622                 | 11623                 | 11624                    | 11625                 | 11626 | 11627 |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | HL                    | LC                       | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 6                     | 6                     | 10                       | 8                     | 12    | 8     |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                      | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 6                     |                          |                       |       |       |       |
| Off Time           | OFF | 4                     | 4                     | 12                    | 8                     | 1                        | 1                     | 9     | 7     |       |
| Stabilizer A       | SA  | 2                     | 2                     | 3                     | 1                     | 1                        | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 14                    | 11                    | 12                    | 8                     | 1                        | 1                     | 7     | 7     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     | 1     | 1     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 58.0<br>(55.0 ~ 61.0) | 38.0<br>(36.0 ~ 40.0) | 70.0<br>(68.0 ~ 72.0) | 140.0<br>(138.0 ~ 142.0) | 95.0<br>(93.0 ~ 97.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                       | 12                    | 12    | 12    |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                        | 7                     | 7     | 7     |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                       | 12                    | 12    | 12    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                        | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 1.0                   | 4.0                   | 7.0                   | 7.0                   | 6.5                      | 6.5                   | 6.0   | 5.5   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 102.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 120.0 | 80.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 141.0 | 101.0 | 76.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 157.0 | 117.0 | 92.0  | 82.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 161.0 | 121.0 | 96.0  | 86.0  | 84.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 161.0 | 121.0 | 96.0  | 86.0  | 84.0  | 79.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 162.5 | 122.5 | 97.5  | 87.5  | 85.5  | 80.5  | 78.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 25.0  | 10.0  | 2.0   | 5.0   | 2.5   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 3.4 ~ 5.2   | 9.8 ~ 13.0  | 6.4 ~ 8.3   | 6.3 ~ 7.0   | 6.4 ~ 7.1   | 5.7 ~ 6.3   | 5.5 ~ 5.5   |
| Average Voltage Gap  | V   |  | 48 ~ 68     | 27 ~ 51     | 62 ~ 78     | 151 ~ 164   | 117 ~ 129   |             |             |
| Avg. Linear Feedrate | ALF |  | 258.0       | 187.3       | 131.5       | 98.9        | 79.5        | 65.1        | 54.4        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | STEEL         | 20mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                   | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 11631                 | 11632                 | 11633                 | 11634                   | 11635                 | 11636 | 11637 |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | HL                    | LC                      | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                      | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 6                     | 6                     | 10                      | 9                     | 16    | 9     |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                     | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 6                     |                         |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 10                    | 6                     | 1                       | 1                     | 9     | 7     |       |
| Stabilizer A       | SA  | 2                     | 2                     | 3                     | 1                     | 1                       | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 14                    | 7                     | 10                    | 6                     | 1                       | 1                     | 7     | 7     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                       | 4                     | 1     | 1     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                       | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 52.0<br>(49.0 ~ 55.0) | 34.0<br>(32.0 ~ 36.0) | 58.0<br>(56.0 ~ 60.0) | 100.0<br>(98.0 ~ 102.0) | 75.0<br>(73.0 ~ 77.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                      | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                     | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                      | 12                    | 12    | 12    |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                       | 7                     | 7     | 7     |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                      | 12                    | 12    | 12    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                      | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                       | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                      | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                       | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 1.0                   | 2.5                   | 6.0                   | 6.0                   | 6.0                     | 6.0                   | 5.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 120.0 | 80.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 142.0 | 102.0 | 77.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 158.0 | 118.0 | 93.0  | 81.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 160.0 | 120.0 | 95.0  | 83.0  | 80.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 162.0 | 122.0 | 97.0  | 85.0  | 82.0  | 77.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 165.0 | 125.0 | 100.0 | 88.0  | 85.0  | 80.0  | 78.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 25.0  | 12.0  | 3.0   | 5.0   | 2.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 2.5 ~ 3.7   | 11.1 ~ 14.1 | 5.0 ~ 6.5   | 5.9 ~ 6.6   | 5.8 ~ 6.5   | 4.8 ~ 5.3   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 48 ~ 61     | 31 ~ 47     | 52 ~ 63     | 116 ~ 128   | 79 ~ 91     |             |             |
| Avg. Linear Feedrate | ALF |  | 186.0       | 149.3       | 104.2       | 81.5        | 66.8        | 54.7        | 44.6        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | STEEL         | 30mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 972                   | 11641                 | 11642                 | 11643                 | 11644                 | 11645                 | 11646 | 11647 |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | HL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 7                     | 6                     | 10                    | 9                     | 15    | 9     |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 7                     |                       |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 10                    | 6                     | 1                     | 1                     | 9     | 7     |       |
| Stabilizer A       | SA  | 2                     | 2                     | 3                     | 1                     | 1                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 13                    | 7                     | 10                    | 5                     | 1                     | 1                     | 7     | 7     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     | 1     | 1     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 49.0<br>(46.0 ~ 52.0) | 32.0<br>(30.0 ~ 34.0) | 54.0<br>(52.0 ~ 56.0) | 85.0<br>(83.0 ~ 87.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12    | 12    |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                     | 7                     | 7     | 7     |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                    | 12                    | 12    | 12    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 0.6                   | 1.8                   | 5.0                   | 5.0                   | 5.7                   | 5.7                   | 5.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 122.0 | 80.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 143.0 | 101.0 | 76.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 160.0 | 118.0 | 93.0  | 81.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 162.0 | 120.0 | 95.0  | 83.0  | 80.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 165.0 | 123.0 | 98.0  | 86.0  | 83.0  | 79.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 167.0 | 125.0 | 100.0 | 88.0  | 85.0  | 81.0  | 79.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 42.0  | 25.0  | 12.0  | 3.0   | 4.0   | 2.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.8 ~ 2.9   | 9.4 ~ 12.1  | 4.5 ~ 5.5   | 5.7 ~ 6.4   | 5.5 ~ 6.2   | 4.8 ~ 5.3   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 42 ~ 56     | 31 ~ 49     | 46 ~ 59     | 104 ~ 115   | 66 ~ 79     |             |             |
| Avg. Linear Feedrate | ALF |  | 141.0       | 115.7       | 83.5        | 67.9        | 56.9        | 47.9        | 39.9        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | STEEL         | 40mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 972                   | 11651                 | 11652                 | 11653                 | 11654                 | 11655                 | 11656 | 11657 | 11658 |
| Power Supply       | PS  | RH                    | RH                    | RL                    | HL                    | LC                    | LC                    | DFS   | DFS   | DFS   |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    | NM    |
| Voltage Open       | Vo  | 7                     | 7                     | 8                     | 7                     | 10                    | 7                     | 14    | 10    | 8     |
| Power Setting      | IP  | 5.0                   | 7.0                   | 6.0                   | 6.0                   | 3.0                   | 1.5                   | 1.0   | 1.0   | 1.0   |
| IP adjust          | ΔIP | 10                    | 16                    | 8                     | 8                     |                       |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 9                     | 5                     | 1                     | 1                     | 9     | 9     | 9     |
| Stabilizer A       | SA  | 2                     | 2                     | 3                     | 2                     | 1                     | 1                     | 5     | 5     | 5     |
| Stabilizer B       | SB  | 13                    | 6                     | 9                     | 5                     | 1                     | 1                     | 7     | 7     | 7     |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     | 1     | 1     | 1     |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     | 1     |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 46.0<br>(43.0 ~ 49.0) | 30.0<br>(28.0 ~ 32.0) | 47.0<br>(45.0 ~ 49.0) | 70.0<br>(68.0 ~ 72.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   | OFF   |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF   | OFF   | OFF   |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12    | 12    | 12    |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                     | 7                     | 7     | 7     | 7     |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                    | 12                    | 12    | 12    | 12    |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    | NM    |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     | 4     |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    | 10    |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     | 0     |
| Feedrate Address   | FA  | 0.6                   | 1.2                   | 4.0                   | 4.0                   | 5.5                   | 5.5                   | 5.0   | 4.0   | 4.0   |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   | 1.0   |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 124.0 | 79.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 145.0 | 100.0 | 75.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 161.0 | 116.0 | 91.0  | 81.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 165.0 | 120.0 | 95.0  | 85.0  | 81.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 167.0 | 122.0 | 97.0  | 87.0  | 83.0  | 80.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 168.0 | 123.0 | 98.0  | 88.0  | 84.0  | 81.0  | 80.0  | ----- |
| Rough & 7 Skims    | ----- | 169.0 | 124.0 | 99.0  | 89.0  | 85.0  | 82.0  | 81.0  | 80.0  |
| Stepping Increment | ----- | ----- | 45.0  | 25.0  | 10.0  | 4.0   | 3.0   | 1.0   | 1.0   |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.1 ~ 2.2   | 7.8 ~ 10.4  | 3.4 ~ 4.5   | 5.4 ~ 6.1   | 5.2 ~ 5.9   | 4.8 ~ 5.3   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 37 ~ 51     | 30 ~ 51     | 41 ~ 54     | 91 ~ 103    | 53 ~ 66     |             |             |
| Avg. Linear Feedrate | ALF |  | 99.0        | 83.8        | 61.9        | 52.5        | 45.3        | 39.4        | 33.9        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.4 ~ 1.6   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.16 ~ 0.27 |
|                      |     |  |             |             |             |             |             | 0.14 ~ 0.23 |             |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.15BS            | WC-Co         | DFS   |

Thickness 5 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 971             | RH  | 1.0 |        |       |       |       |       |       |       |     |           |
| 1                 | 11711           | RH  | 2.0 | 99.0   | 121.0 | 133.0 | 143.0 | 145.0 | 146.0 | 147.0 |     | 0.0       |
| 2                 | 11712           | RL  | 6.0 | -      | 81.0  | 93.0  | 103.0 | 105.0 | 106.0 | 107.0 |     | 40.0      |
| 3                 | 11713           | RL  | 6.0 | -      | -     | 81.0  | 91.0  | 93.0  | 94.0  | 95.0  |     | 12.0      |
| 4                 | 11714           | LC  | 8.0 | -      | -     | -     | 78.0  | 80.0  | 81.0  | 82.0  |     | 13.0      |
| 5                 | 11715           | LC  | 8.0 | -      | -     | -     | -     | 78.0  | 79.0  | 80.0  |     | 2.0       |
| 6                 | 11716           | DFS | 7.0 | -      | -     | -     | -     | -     | 77.0  | 78.0  |     | 2.0       |
| 7                 | 11717           | DFS | 7.0 | -      | -     | -     | -     | -     | -     | 77.0  |     | 1.0       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 13.0  | 11.0  | 2.5   | 2.0   | 1.5   | 0.9   |     |           |
|                   |                 |     | Ra  | 2.50   | 1.80  | 1.50  | 0.30  | 0.28  | 0.18  | 0.13  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 971             | RH  | 1.0 |        |       |       |       |       |       |       |     |           |
| 1                 | 11721           | RH  | 1.8 | 100.0  | 121.0 | 134.0 | 143.0 | 145.0 | 146.0 | 147.0 |     | 0.0       |
| 2                 | 11722           | RL  | 6.0 | -      | 81.0  | 94.0  | 103.0 | 105.0 | 106.0 | 107.0 |     | 40.0      |
| 3                 | 11723           | RL  | 6.0 | -      | -     | 82.0  | 91.0  | 93.0  | 94.0  | 95.0  |     | 12.0      |
| 4                 | 11724           | LC  | 7.0 | -      | -     | -     | 78.0  | 80.0  | 81.0  | 82.0  |     | 13.0      |
| 5                 | 11725           | LC  | 7.0 | -      | -     | -     | -     | 78.0  | 79.0  | 80.0  |     | 2.0       |
| 6                 | 11726           | DFS | 7.0 | -      | -     | -     | -     | -     | 77.0  | 78.0  |     | 2.0       |
| 7                 | 11727           | DFS | 7.0 | -      | -     | -     | -     | -     | -     | 77.0  |     | 1.0       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 13.0  | 11.0  | 2.5   | 2.0   | 1.5   | 0.9   |     |           |
|                   |                 |     | Ra  | 2.50   | 1.80  | 1.50  | 0.30  | 0.28  | 0.18  | 0.13  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 971             | RH  | 1.0 |        |       |       |       |       |       |       |     |           |
| 1                 | 11731           | RH  | 0.8 | 101.0  | 123.0 | 145.0 | 155.0 | 157.0 | 158.0 | 159.0 |     | 0.0       |
| 2                 | 11732           | RL  | 5.0 | -      | 78.0  | 100.0 | 110.0 | 112.0 | 113.0 | 114.0 |     | 45.0      |
| 3                 | 11733           | RL  | 2.0 | -      | -     | 82.0  | 92.0  | 94.0  | 95.0  | 96.0  |     | 18.0      |
| 4                 | 11734           | LC  | 6.0 | -      | -     | -     | 79.0  | 81.0  | 82.0  | 83.0  |     | 13.0      |
| 5                 | 11735           | LC  | 6.0 | -      | -     | -     | -     | 78.0  | 79.0  | 80.0  |     | 3.0       |
| 6                 | 11736           | DFS | 6.5 | -      | -     | -     | -     | -     | 77.0  | 78.0  |     | 2.0       |
| 7                 | 11737           | DFS | 6.5 | -      | -     | -     | -     | -     | -     | 77.0  |     | 1.0       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 13.0  | 11.0  | 2.5   | 2.0   | 1.5   | 0.9   |     |           |
|                   |                 |     | Ra  | 2.50   | 1.80  | 1.50  | 0.30  | 0.28  | 0.18  | 0.13  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.15BS            | WC-Co         | DFS   |

Thickness 30 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 972             | RH  | 0.6 |        |       |       |       |       |       |       |     |           |
| 1                 | 11741           | RH  | 0.7 | 106.0  | 123.0 | 146.0 | 156.0 | 158.0 | 159.0 | 159.0 |     | 0.0       |
| 2                 | 11742           | RL  | 5.0 | -      | 78.0  | 101.0 | 111.0 | 113.0 | 114.0 | 114.0 |     | 45.0      |
| 3                 | 11743           | RL  | 1.5 | -      | -     | 83.0  | 93.0  | 95.0  | 96.0  | 96.0  |     | 18.0      |
| 4                 | 11744           | LC  | 6.0 | -      | -     | -     | 80.0  | 82.0  | 83.0  | 83.0  |     | 13.0      |
| 5                 | 11745           | LC  | 6.0 | -      | -     | -     | -     | 79.0  | 80.0  | 80.0  |     | 3.0       |
| 6                 | 11746           | DFS | 6.5 | -      | -     | -     | -     | -     | 78.0  | 78.0  |     | 2.0       |
| 7                 | 11747           | DFS | 6.5 | -      | -     | -     | -     | -     | -     | 77.0  |     | 1.0       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 13.0  | 11.0  | 2.5   | 2.0   | 1.5   | 0.9   |     |           |
|                   |                 |     | Ra  | 2.50   | 1.80  | 1.50  | 0.30  | 0.28  | 0.18  | 0.13  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 40 mm

| No.               | Cutting process |     |     | Offset |       |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|-------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd   | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 972             | RH  | 0.6 |        |       |       |       |       |       |       |     |           |
| 1                 | 11751           | RH  | 0.5 | 111.0  | 124.0 | 149.0 | 160.0 | 161.0 | 162.0 | 163.0 |     | 0.0       |
| 2                 | 11752           | RL  | 5.0 | -      | 79.0  | 104.0 | 115.0 | 116.0 | 117.0 | 118.0 |     | 45.0      |
| 3                 | 11753           | RL  | 1.0 | -      | -     | 84.0  | 95.0  | 96.0  | 97.0  | 98.0  |     | 20.0      |
| 4                 | 11754           | LC  | 6.0 | -      | -     | -     | 82.0  | 83.0  | 84.0  | 85.0  |     | 13.0      |
| 5                 | 11755           | LC  | 6.0 | -      | -     | -     | -     | 80.0  | 81.0  | 82.0  |     | 3.0       |
| 6                 | 11756           | DFS | 6.5 | -      | -     | -     | -     | -     | 79.0  | 80.0  |     | 2.0       |
| 7                 | 11757           | DFS | 6.5 | -      | -     | -     | -     | -     | -     | 78.0  |     | 2.0       |
| 8                 |                 |     |     | -      | -     | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 13.0  | 11.0  | 2.5   | 2.0   | 1.5   | 0.9   |     |           |
|                   |                 |     | Ra  | 2.50   | 1.80  | 1.50  | 0.30  | 0.28  | 0.18  | 0.13  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | WC-Co         | 5mm                | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                    | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|--------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 11711                 | 11712                 | 11713                 | 11714                    | 11715                 | 11716 | 11717 |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | RL                    | LC                       | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                       | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 8                     | 8                        | 8                     | 13    | 9     |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                      | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 5                     | 6                     |                          |                       |       |       |       |
| Off Time           | OFF | 4                     | 4                     | 14                    | 16                    | 1                        | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 2                     | 2                     | 2                     | 2                     | 1                        | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 14                    | 14                    | 14                    | 16                    | 1                        | 1                     | 7     | 7     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                        | 4                     | 1     | 1     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                        | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 72.0<br>(69.0 ~ 75.0) | 40.0<br>(38.0 ~ 42.0) | 45.0<br>(43.0 ~ 47.0) | 120.0<br>(118.0 ~ 122.0) | 80.0<br>(78.0 ~ 82.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                       | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                      | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 8                     | 10                    | 10                    | 10                       | 10                    | 10    | 10    |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                        | 7                     | 7     | 7     |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                       | 12                    | 12    | 12    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                       | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                        | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                       | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                        | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 1.0                   | 2.0                   | 6.0                   | 6.0                   | 8.0                      | 8.0                   | 7.0   | 7.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                      | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 99.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 121.0 | 81.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 133.0 | 93.0  | 81.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 143.0 | 103.0 | 91.0  | 78.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 145.0 | 105.0 | 93.0  | 80.0  | 78.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 146.0 | 106.0 | 94.0  | 81.0  | 79.0  | 77.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 147.0 | 107.0 | 95.0  | 82.0  | 80.0  | 78.0  | 77.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 12.0  | 13.0  | 2.0   | 2.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 2.2 ~ 3.5   | 8.6 ~ 12.0  | 5.3 ~ 7.8   | 7.7 ~ 8.6   | 7.8 ~ 8.7   | 7.0 ~ 7.0   | 7.0 ~ 7.0   |
| Average Voltage Gap  | V   |  | 59 ~ 83     | 29 ~ 51     | 37 ~ 59     | 129 ~ 143   | 98 ~ 114    |             |             |
| Avg. Linear Feedrate | ALF |  | 171.0       | 133.9       | 99.9        | 82.9        | 71.0        | 60.8        | 53.1        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | WC-Co         | 10mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                   | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 11721                 | 11722                 | 11723                 | 11724                   | 11725                 | 11726 | 11727 |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | RL                    | LC                      | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                      | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 10                    | 8                       | 8                     | 14    | 10    |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                     | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 6                     | 7                     |                         |                       |       |       |       |
| Off Time           | OFF | 4                     | 4                     | 12                    | 15                    | 1                       | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 2                     | 2                     | 2                     | 2                     | 1                       | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 14                    | 12                    | 12                    | 15                    | 1                       | 1                     | 7     | 7     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                       | 4                     | 1     | 1     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                       | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 64.0<br>(61.0 ~ 67.0) | 40.0<br>(38.0 ~ 42.0) | 40.0<br>(38.0 ~ 42.0) | 100.0<br>(98.0 ~ 102.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                      | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                     | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 8                     | 10                    | 10                    | 10                      | 10                    | 10    | 10    |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                       | 7                     | 7     | 7     |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                      | 12                    | 12    | 12    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                      | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                       | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                      | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                       | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 1.0                   | 1.8                   | 6.0                   | 6.0                   | 7.0                     | 7.0                   | 7.0   | 7.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                     | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 100.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 121.0 | 81.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 134.0 | 94.0  | 82.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 143.0 | 103.0 | 91.0  | 78.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 145.0 | 105.0 | 93.0  | 80.0  | 78.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 146.0 | 106.0 | 94.0  | 81.0  | 79.0  | 77.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 147.0 | 107.0 | 95.0  | 82.0  | 80.0  | 78.0  | 77.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 12.0  | 13.0  | 2.0   | 2.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.4 ~ 2.5   | 6.2 ~ 9.6   | 4.5 ~ 6.4   | 6.8 ~ 7.6   | 6.9 ~ 7.7   | 7.0 ~ 7.0   | 7.0 ~ 7.0   |
| Average Voltage Gap  | V   |  | 53 ~ 73     | 29 ~ 52     | 28 ~ 53     | 114 ~ 127   | 81 ~ 95     |             |             |
| Avg. Linear Feedrate | ALF |  | 117.0       | 93.8        | 72.9        | 62.4        | 54.6        | 48.3        | 43.3        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | WC-Co         | 20mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 971                   | 11731                 | 11732                 | 11733                 | 11734                 | 11735                 | 11736 | 11737 |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | RL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 10                    | 8                     | 8                     | 14    | 10    |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 8                     |                       |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 9                     | 13                    | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 2                     | 2                     | 2                     | 2                     | 1                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 14                    | 9                     | 9                     | 13                    | 1                     | 1                     | 7     | 7     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     | 1     | 1     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 55.0<br>(52.0 ~ 58.0) | 36.0<br>(34.0 ~ 38.0) | 34.0<br>(32.0 ~ 36.0) | 70.0<br>(68.0 ~ 72.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12    | 12    |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                     | 7                     | 7     | 7     |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                    | 12                    | 12    | 12    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 1.0                   | 0.8                   | 5.0                   | 2.0                   | 6.0                   | 6.0                   | 6.5   | 6.5   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 101.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 123.0 | 78.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 145.0 | 100.0 | 82.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 155.0 | 110.0 | 92.0  | 79.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 157.0 | 112.0 | 94.0  | 81.0  | 78.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 158.0 | 113.0 | 95.0  | 82.0  | 79.0  | 77.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 159.0 | 114.0 | 96.0  | 83.0  | 80.0  | 78.0  | 77.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 45.0  | 18.0  | 13.0  | 3.0   | 2.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.9 ~ 2.2   | 3.7 ~ 5.2   | 1.4 ~ 2.9   | 5.8 ~ 6.5   | 5.8 ~ 6.5   | 6.5 ~ 6.5   | 6.5 ~ 6.5   |
| Average Voltage Gap  | V   |  | 47 ~ 67     | 23 ~ 47     | 27 ~ 48     | 85 ~ 98     | 58 ~ 71     |             |             |
| Avg. Linear Feedrate | ALF |  | 93.0        | 69.0        | 44.9        | 40.1        | 36.1        | 33.1        | 30.5        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | WC-Co         | 30mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 972                   | 11741                 | 11742                 | 11743                 | 11744                 | 11745                 | 11746 | 11747 |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | RL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 10                    | 9                     | 8                     | 14    | 10    |       |
| Power Setting      | IP  | 5.0                   | 6.0                   | 6.0                   | 5.0                   | 3.0                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 8                     |                       |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 9                     | 13                    | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 2                     | 2                     | 2                     | 2                     | 1                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 13                    | 9                     | 9                     | 13                    | 1                     | 1                     | 7     | 7     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     | 1     | 1     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 62.0<br>(59.0 ~ 65.0) | 43.0<br>(41.0 ~ 45.0) | 32.0<br>(30.0 ~ 34.0) | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12    | 12    |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                     | 7                     | 7     | 7     |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                    | 12                    | 12    | 12    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 0.6                   | 0.7                   | 5.0                   | 1.5                   | 6.0                   | 6.0                   | 6.5   | 6.5   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 123.0 | 78.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 146.0 | 101.0 | 83.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 156.0 | 111.0 | 93.0  | 80.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 158.0 | 113.0 | 95.0  | 82.0  | 79.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 159.0 | 114.0 | 96.0  | 83.0  | 80.0  | 78.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 159.0 | 114.0 | 96.0  | 83.0  | 80.0  | 78.0  | 77.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 45.0  | 18.0  | 13.0  | 3.0   | 2.0   | 1.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.6 ~ 1.7   | 4.7 ~ 6.2   | 1.0 ~ 2.3   | 5.8 ~ 6.6   | 5.8 ~ 6.6   | 6.5 ~ 6.5   | 6.5 ~ 6.5   |
| Average Voltage Gap  | V   |  | 52 ~ 69     | 34 ~ 54     | 26 ~ 45     | 82 ~ 95     | 52 ~ 60     |             |             |
| Avg. Linear Feedrate | ALF |  | 69.0        | 57.0        | 36.2        | 33.0        | 30.3        | 28.1        | 26.2        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.15BS           | WC-Co         | 40mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 972                   | 11751                 | 11752                 | 11753                 | 11754                 | 11755                 | 11756 | 11757 |       |
| Power Supply       | PS  | RH                    | RH                    | RL                    | RL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 10                    | 10                    | 10                    | 9                     | 15    | 10    |       |
| Power Setting      | IP  | 5.0                   | 7.0                   | 6.0                   | 5.0                   | 3.0                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 10                    | 16                    | 7                     | 8                     |                       |                       |       |       |       |
| Off Time           | OFF | 4                     | 3                     | 5                     | 12                    | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 2                     | 2                     | 2                     | 2                     | 1                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 13                    | 8                     | 5                     | 12                    | 1                     | 1                     | 7     | 7     |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 1                     | 4                     | 4                     | 1     | 1     |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 70.0<br>(68.0 ~ 72.0) | 70.0<br>(67.0 ~ 73.0) | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(28.0 ~ 32.0) | 50.0<br>(48.0 ~ 52.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | ON                    | ON                    | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 12                    | 12                    | 12                    | 12    | 12    |       |
| Wire Tension       | WT  | 6                     | 6                     | 7                     | 7                     | 7                     | 7                     | 7     | 7     |       |
| Pre-Tension        | PT  | 10                    | 12                    | 12                    | 12                    | 12                    | 12                    | 12    | 12    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 10                    | 14                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 0.6                   | 0.5                   | 5.0                   | 1.0                   | 6.0                   | 6.0                   | 6.5   | 6.5   |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 111.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 124.0 | 79.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 149.0 | 104.0 | 84.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 160.0 | 115.0 | 95.0  | 82.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 161.0 | 116.0 | 96.0  | 83.0  | 80.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 162.0 | 117.0 | 97.0  | 84.0  | 81.0  | 79.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 163.0 | 118.0 | 98.0  | 85.0  | 82.0  | 80.0  | 78.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 45.0  | 20.0  | 13.0  | 3.0   | 2.0   | 2.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.4 ~ 1.1   | 8.8 ~ 11.6  | 0.7 ~ 1.7   | 6.0 ~ 6.7   | 5.9 ~ 6.6   | 6.5 ~ 6.5   | 6.5 ~ 6.5   |
| Average Voltage Gap  | V   |  | 57 ~ 79     | 45 ~ 61     | 24 ~ 41     | 81 ~ 93     | 47 ~ 59     |             |             |
| Avg. Linear Feedrate | ALF |  | 45.0        | 41.9        | 26.5        | 24.8        | 23.2        | 21.9        | 20.8        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 11.7 ~ 14.3 | 9.9 ~ 12.1  | 2.2 ~ 2.8   | 1.8 ~ 2.2   | 1.4 ~ 1.6   | 0.8 ~ 1.0   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.62 ~ 2.70 | 1.35 ~ 2.25 | 0.27 ~ 0.45 | 0.25 ~ 0.42 | 0.16 ~ 0.27 | 0.12 ~ 0.19 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.07SP            | STEEL         | DFS   |

Thickness 5 mm

| No.               | Cutting process |     |     | Offset |      |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 921             | RL  | 0.5 |        |      |       |       |       |       |       |     |           |
| 1                 | 11211           | RL  | 1.7 | 40.0   | 87.0 | 108.0 | 114.0 | 124.0 | 125.0 | 126.0 |     | 0.0       |
| 2                 | 11212           | HL  | 4.5 | -      | 42.0 | 63.0  | 69.0  | 79.0  | 80.0  | 81.0  |     | 45.0      |
| 3                 | 11213           | HL  | 4.0 | -      | -    | 38.0  | 44.0  | 54.0  | 55.0  | 56.0  |     | 25.0      |
| 4                 | 11214           | LC  | 6.0 | -      | -    | -     | 38.0  | 48.0  | 49.0  | 50.0  |     | 6.0       |
| 5                 | 11215           | LC  | 6.0 | -      | -    | -     | -     | 44.0  | 45.0  | 46.0  |     | 4.0       |
| 6                 | 11216           | DFS | 5.0 | -      | -    | -     | -     | -     | 40.0  | 41.0  |     | 5.0       |
| 7                 | 11217           | DFS | 5.0 | -      | -    | -     | -     | -     | -     | 39.0  |     | 2.0       |
| 8                 |                 |     |     | -      | -    | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   | 1.8   | 1.2   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  | 0.20  | 0.15  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |     |     | Offset |      |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 921             | RL  | 0.5 |        |      |       |       |       |       |       |     |           |
| 1                 | 11221           | RL  | 1.5 | 42.0   | 82.0 | 103.0 | 114.0 | 117.0 | 119.0 | 121.0 |     | 0.0       |
| 2                 | 11222           | HL  | 4.0 | -      | 42.0 | 63.0  | 74.0  | 77.0  | 79.0  | 81.0  |     | 40.0      |
| 3                 | 11223           | HL  | 3.5 | -      | -    | 38.0  | 49.0  | 52.0  | 54.0  | 56.0  |     | 25.0      |
| 4                 | 11224           | LC  | 6.0 | -      | -    | -     | 43.0  | 46.0  | 48.0  | 50.0  |     | 6.0       |
| 5                 | 11225           | LC  | 6.0 | -      | -    | -     | -     | 42.0  | 44.0  | 46.0  |     | 4.0       |
| 6                 | 11226           | DFS | 5.0 | -      | -    | -     | -     | -     | 39.0  | 41.0  |     | 5.0       |
| 7                 | 11227           | DFS | 5.0 | -      | -    | -     | -     | -     | -     | 39.0  |     | 2.0       |
| 8                 |                 |     |     | -      | -    | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   | 1.8   | 1.2   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  | 0.20  | 0.15  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |     |     | Offset |      |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 921             | RL  | 0.5 |        |      |       |       |       |       |       |     |           |
| 1                 | 11231           | RL  | 1.2 | 45.0   | 85.0 | 103.0 | 116.0 | 118.0 | 121.0 | 122.0 |     | 0.0       |
| 2                 | 11232           | HL  | 3.5 | -      | 45.0 | 63.0  | 76.0  | 78.0  | 81.0  | 82.0  |     | 40.0      |
| 3                 | 11233           | HL  | 3.0 | -      | -    | 38.0  | 51.0  | 53.0  | 56.0  | 57.0  |     | 25.0      |
| 4                 | 11234           | LC  | 6.0 | -      | -    | -     | 45.0  | 47.0  | 50.0  | 51.0  |     | 6.0       |
| 5                 | 11235           | LC  | 6.0 | -      | -    | -     | -     | 43.0  | 46.0  | 47.0  |     | 4.0       |
| 6                 | 11236           | DFS | 5.0 | -      | -    | -     | -     | -     | 41.0  | 42.0  |     | 5.0       |
| 7                 | 11237           | DFS | 4.0 | -      | -    | -     | -     | -     | -     | 40.0  |     | 2.0       |
| 8                 |                 |     |     | -      | -    | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   | 1.8   | 1.2   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  | 0.20  | 0.15  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.07SP           | STEEL         | 5mm                | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 921                   | 11211                 | 11212                 | 11213                 | 11214                 | 11215                 | 11216 | 11217 |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 5                     | 5                     | 6                     | 6                     | 14    | 9     |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 5.0                   | 1.5                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 16                    | 16                    | 12                    | 12                    |                       |                       |       |       |       |
| Off Time           | OFF | 9                     | 9                     | 14                    | 15                    | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 10                    | 9                     | 14                    | 15                    | 10                    | 10                    | 9     | 9     |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     | 9     | 9     |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     | 2     | 2     |       |
| Pre-Tension        | PT  | 11                    | 11                    | 12                    | 12                    | 12                    | 12                    | 12    | 12    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 12                    | 13                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 0.5                   | 1.7                   | 4.5                   | 4.0                   | 6.0                   | 6.0                   | 5.0   | 5.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 87.0  | 42.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 108.0 | 63.0  | 38.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 114.0 | 69.0  | 44.0  | 38.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 124.0 | 79.0  | 54.0  | 48.0  | 44.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 125.0 | 80.0  | 55.0  | 49.0  | 45.0  | 40.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 126.0 | 81.0  | 56.0  | 50.0  | 46.0  | 41.0  | 39.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 45.0  | 25.0  | 6.0   | 4.0   | 5.0   | 2.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 1.6 ~ 2.0   | 2.6 ~ 3.2   | 7.4 ~ 9.0   | 6.0 ~ 6.7   | 6.0 ~ 6.7   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 39 ~ 63     | 63 ~ 80     | 34 ~ 48     | 120 ~ 132   | 118 ~ 129   |             |             |
| Avg. Linear Feedrate | ALF |  | 108.0       | 66.6        | 58.7        | 50.9        | 44.9        | 39.0        | 34.5        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.07SP           | STEEL         | 10mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 921                   | 11221                 | 11222                 | 11223                 | 11224                 | 11225                 | 11226 | 11227 |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 5                     | 5                     | 6                     | 6                     | 14    | 9     |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 5.0                   | 1.5                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 16                    | 16                    | 12                    | 12                    |                       |                       |       |       |       |
| Off Time           | OFF | 9                     | 8                     | 14                    | 15                    | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 10                    | 8                     | 14                    | 15                    | 10                    | 10                    | 9     | 9     |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     | 9     | 9     |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     | 2     | 2     |       |
| Pre-Tension        | PT  | 11                    | 11                    | 12                    | 12                    | 12                    | 12                    | 12    | 12    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 12                    | 13                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 0.5                   | 1.5                   | 4.0                   | 3.5                   | 6.0                   | 6.0                   | 5.0   | 5.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 42.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 82.0  | 42.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 103.0 | 63.0  | 38.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 114.0 | 74.0  | 49.0  | 43.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 117.0 | 77.0  | 52.0  | 46.0  | 42.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 119.0 | 79.0  | 54.0  | 48.0  | 44.0  | 39.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 121.0 | 81.0  | 56.0  | 50.0  | 46.0  | 41.0  | 39.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 25.0  | 6.0   | 4.0   | 5.0   | 2.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.0   | 1.4 ~ 1.7   | 4.7 ~ 5.8   | 6.0 ~ 6.7   | 6.0 ~ 6.7   | 5.0 ~ 5.0   | 5.0 ~ 5.0   |
| Average Voltage Gap  | V   |  | 30 ~ 52     | 61 ~ 80     | 29 ~ 43     | 84 ~ 96     | 75 ~ 86     |             |             |
| Avg. Linear Feedrate | ALF |  | 54.0        | 34.2        | 30.8        | 28.5        | 26.5        | 24.4        | 22.5        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.07SP           | STEEL         | 20mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 921                   | 11231                 | 11232                 | 11233                 | 11234                 | 11235                 | 11236 | 11237 |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 5                     | 5                     | 6                     | 6                     | 14    | 9     |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 5.0                   | 1.5                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 16                    | 16                    | 12                    | 12                    |                       |                       |       |       |       |
| Off Time           | OFF | 9                     | 8                     | 14                    | 15                    | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 10                    | 8                     | 14                    | 15                    | 10                    | 10                    | 9     | 9     |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 30.0<br>(28.0 ~ 32.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     | 9     | 9     |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     | 2     | 2     |       |
| Pre-Tension        | PT  | 11                    | 11                    | 12                    | 12                    | 12                    | 12                    | 12    | 12    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 12                    | 13                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 0.5                   | 1.2                   | 3.5                   | 3.0                   | 6.0                   | 6.0                   | 5.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 45.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 85.0  | 45.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 103.0 | 63.0  | 38.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 116.0 | 76.0  | 51.0  | 45.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 118.0 | 78.0  | 53.0  | 47.0  | 43.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 121.0 | 81.0  | 56.0  | 50.0  | 46.0  | 41.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 122.0 | 82.0  | 57.0  | 51.0  | 47.0  | 42.0  | 40.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 25.0  | 6.0   | 4.0   | 5.0   | 2.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.3 ~ 0.5   | 0.7 ~ 1.0   | 2.7 ~ 3.5   | 6.0 ~ 6.7   | 6.0 ~ 6.7   | 5.0 ~ 5.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 28 ~ 38     | 61 ~ 78     | 27 ~ 42     | 54 ~ 66     | 54 ~ 66     |             |             |
| Avg. Linear Feedrate | ALF |  | 24.0        | 16.3        | 15.0        | 14.4        | 13.9        | 13.3        | 12.6        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.07SP            | WC-Co         | DFS   |

Thickness 5 mm

| No.               | Cutting process |     |     | Offset |      |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 921             | RL  | 0.5 |        |      |       |       |       |       |       |     |           |
| 1                 | 11311           | RL  | 0.8 | 40.0   | 85.0 | 108.0 | 117.0 | 120.0 | 123.0 | 125.0 |     | 0.0       |
| 2                 | 11312           | HL  | 1.5 | -      | 40.0 | 63.0  | 72.0  | 75.0  | 78.0  | 80.0  |     | 45.0      |
| 3                 | 11313           | HL  | 2.5 | -      | -    | 38.0  | 47.0  | 50.0  | 53.0  | 55.0  |     | 25.0      |
| 4                 | 11314           | LC  | 5.0 | -      | -    | -     | 41.0  | 44.0  | 47.0  | 49.0  |     | 6.0       |
| 5                 | 11315           | LC  | 5.0 | -      | -    | -     | -     | 40.0  | 43.0  | 45.0  |     | 4.0       |
| 6                 | 11316           | DFS | 5.0 | -      | -    | -     | -     | -     | 38.0  | 40.0  |     | 5.0       |
| 7                 | 11317           | DFS | 4.0 | -      | -    | -     | -     | -     | -     | 38.0  |     | 2.0       |
| 8                 |                 |     |     | -      | -    | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   | 1.8   | 1.2   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  | 0.20  | 0.15  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |     |     | Offset |      |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 921             | RL  | 0.5 |        |      |       |       |       |       |       |     |           |
| 1                 | 11321           | RL  | 0.5 | 40.0   | 80.0 | 103.0 | 112.0 | 115.0 | 118.0 | 120.0 |     | 0.0       |
| 2                 | 11322           | HL  | 1.0 | -      | 40.0 | 63.0  | 72.0  | 75.0  | 78.0  | 80.0  |     | 40.0      |
| 3                 | 11323           | HL  | 2.0 | -      | -    | 38.0  | 47.0  | 50.0  | 53.0  | 55.0  |     | 25.0      |
| 4                 | 11324           | LC  | 5.0 | -      | -    | -     | 41.0  | 44.0  | 47.0  | 49.0  |     | 6.0       |
| 5                 | 11325           | LC  | 5.0 | -      | -    | -     | -     | 40.0  | 43.0  | 45.0  |     | 4.0       |
| 6                 | 11326           | DFS | 5.0 | -      | -    | -     | -     | -     | 38.0  | 40.0  |     | 5.0       |
| 7                 | 11327           | DFS | 4.0 | -      | -    | -     | -     | -     | -     | 38.0  |     | 2.0       |
| 8                 |                 |     |     | -      | -    | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   | 1.8   | 1.2   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  | 0.20  | 0.15  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |     |     | Offset |      |       |       |       |       |       |     | Step      |
|-------------------|-----------------|-----|-----|--------|------|-------|-------|-------|-------|-------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd  | 3rd   | 4th   | 5th   | 6th   | 7th   | 8th | Increment |
| A                 | 921             | RL  | 0.5 |        |      |       |       |       |       |       |     |           |
| 1                 | 11331           | RL  | 0.3 | 40.0   | 80.0 | 104.0 | 114.0 | 116.0 | 118.0 | 120.0 |     | 0.0       |
| 2                 | 11332           | HL  | 1.0 | -      | 40.0 | 64.0  | 74.0  | 76.0  | 78.0  | 80.0  |     | 40.0      |
| 3                 | 11333           | HL  | 2.0 | -      | -    | 39.0  | 49.0  | 51.0  | 53.0  | 55.0  |     | 25.0      |
| 4                 | 11334           | LC  | 5.0 | -      | -    | -     | 43.0  | 45.0  | 47.0  | 49.0  |     | 6.0       |
| 5                 | 11335           | LC  | 5.0 | -      | -    | -     | -     | 41.0  | 43.0  | 45.0  |     | 4.0       |
| 6                 | 11336           | DFS | 5.0 | -      | -    | -     | -     | -     | 38.0  | 40.0  |     | 5.0       |
| 7                 | 11337           | DFS | 4.0 | -      | -    | -     | -     | -     | -     | 38.0  |     | 2.0       |
| 8                 |                 |     |     | -      | -    | -     | -     | -     | -     | -     |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0 | 11.0  | 3.5   | 2.0   | 1.8   | 1.2   |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00 | 1.50  | 0.48  | 0.28  | 0.20  | 0.15  |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.07SP           | WC-Co         | 5mm                | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 921                   | 11311                 | 11312                 | 11313                 | 11314                 | 11315                 | 11316 | 11317 |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 5                     | 5                     | 6                     | 6                     | 13    | 8     |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 5.0                   | 1.5                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 16                    | 16                    | 12                    | 12                    |                       |                       |       |       |       |
| Off Time           | OFF | 9                     | 12                    | 13                    | 14                    | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 10                    | 12                    | 13                    | 14                    | 10                    | 10                    | 9     | 9     |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 65.0<br>(62.0 ~ 68.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     | 9     | 9     |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     | 2     | 2     |       |
| Pre-Tension        | PT  | 11                    | 11                    | 12                    | 12                    | 12                    | 12                    | 12    | 12    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 12                    | 13                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 0.5                   | 0.8                   | 1.5                   | 2.5                   | 5.0                   | 5.0                   | 5.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 85.0  | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 108.0 | 63.0  | 38.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 117.0 | 72.0  | 47.0  | 41.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 120.0 | 75.0  | 50.0  | 44.0  | 40.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 123.0 | 78.0  | 53.0  | 47.0  | 43.0  | 38.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 125.0 | 80.0  | 55.0  | 49.0  | 45.0  | 40.0  | 38.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 45.0  | 25.0  | 6.0   | 4.0   | 5.0   | 2.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.5 ~ 0.9   | 1.5 ~ 1.8   | 4.4 ~ 5.3   | 5.0 ~ 5.7   | 5.0 ~ 5.7   | 5.0 ~ 5.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 51 ~ 79     | 62 ~ 82     | 28 ~ 43     | 82 ~ 95     | 75 ~ 87     |             |             |
| Avg. Linear Feedrate | ALF |  | 42.0        | 29.5        | 26.8        | 24.7        | 22.9        | 21.3        | 19.6        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.07SP           | WC-Co         | 10mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 921                   | 11321                 | 11322                 | 11323                 | 11324                 | 11325                 | 11326 | 11327 |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 5                     | 5                     | 6                     | 6                     | 13    | 8     |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 5.0                   | 1.5                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 16                    | 16                    | 12                    | 12                    |                       |                       |       |       |       |
| Off Time           | OFF | 9                     | 12                    | 14                    | 15                    | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 10                    | 12                    | 14                    | 15                    | 10                    | 10                    | 9     | 9     |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(57.0 ~ 63.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     | 9     | 9     |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     | 2     | 2     |       |
| Pre-Tension        | PT  | 11                    | 11                    | 12                    | 12                    | 12                    | 12                    | 12    | 12    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 12                    | 13                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 0.5                   | 0.5                   | 1.0                   | 2.0                   | 5.0                   | 5.0                   | 5.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 80.0  | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 103.0 | 63.0  | 38.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 112.0 | 72.0  | 47.0  | 41.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 115.0 | 75.0  | 50.0  | 44.0  | 40.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 118.0 | 78.0  | 53.0  | 47.0  | 43.0  | 38.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 120.0 | 80.0  | 55.0  | 49.0  | 45.0  | 40.0  | 38.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 25.0  | 6.0   | 4.0   | 5.0   | 2.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.2 ~ 0.4   | 0.7 ~ 1.0   | 1.8 ~ 2.5   | 5.0 ~ 5.7   | 5.0 ~ 5.7   | 5.0 ~ 5.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 53 ~ 67     | 63 ~ 77     | 28 ~ 42     | 66 ~ 82     | 60 ~ 72     |             |             |
| Avg. Linear Feedrate | ALF |  | 18.0        | 13.3        | 12.1        | 11.6        | 11.2        | 10.8        | 10.3        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.07SP           | WC-Co         | 20mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 921                   | 11331                 | 11332                 | 11333                 | 11334                 | 11335                 | 11336 | 11337 |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 7                     | 7                     | 5                     | 5                     | 6                     | 6                     | 13    | 8     |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 5.0                   | 5.0                   | 1.5                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 16                    | 16                    | 12                    | 12                    |                       |                       |       |       |       |
| Off Time           | OFF | 9                     | 12                    | 14                    | 15                    | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 10                    | 12                    | 14                    | 15                    | 10                    | 10                    | 9     | 9     |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(57.0 ~ 63.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 35.0<br>(33.0 ~ 37.0) | 35.0<br>(33.0 ~ 37.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     | 9     | 9     |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     | 2     | 2     |       |
| Pre-Tension        | PT  | 11                    | 11                    | 12                    | 12                    | 12                    | 12                    | 12    | 12    |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 12                    | 13                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 0.5                   | 0.3                   | 1.0                   | 2.0                   | 5.0                   | 5.0                   | 5.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 80.0  | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 104.0 | 64.0  | 39.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 114.0 | 74.0  | 49.0  | 43.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 116.0 | 76.0  | 51.0  | 45.0  | 41.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 118.0 | 78.0  | 53.0  | 47.0  | 43.0  | 38.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 120.0 | 80.0  | 55.0  | 49.0  | 45.0  | 40.0  | 38.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 40.0  | 25.0  | 6.0   | 4.0   | 5.0   | 2.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.1 ~ 0.2   | 0.5 ~ 0.8   | 1.0 ~ 1.5   | 5.0 ~ 5.7   | 5.0 ~ 5.7   | 5.0 ~ 5.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 52 ~ 70     | 65 ~ 76     | 28 ~ 44     | 45 ~ 57     | 42 ~ 54     |             |             |
| Avg. Linear Feedrate | ALF |  | 9.0         | 7.3         | 6.7         | 6.5         | 6.4         | 6.3         | 6.1         |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.05SP            | STEEL         | DFS   |

Thickness 5 mm

| No.               | Cutting process |     |     | Offset |      |      |      |      |      |      |     | Step      |
|-------------------|-----------------|-----|-----|--------|------|------|------|------|------|------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd  | 3rd  | 4th  | 5th  | 6th  | 7th  | 8th | Increment |
| A                 | 911             | RL  | 0.5 |        |      |      |      |      |      |      |     |           |
| 1                 | 11411           | RL  | 0.8 | 32.0   | 39.0 | 49.0 | 59.0 | 64.0 | 68.0 | 71.0 |     | 0.0       |
| 2                 | 11412           | HL  | 4.0 | -      | 32.0 | 42.0 | 52.0 | 57.0 | 61.0 | 64.0 |     | 7.0       |
| 3                 | 11413           | HL  | 4.0 | -      | -    | 28.0 | 38.0 | 43.0 | 47.0 | 50.0 |     | 14.0      |
| 4                 | 11414           | LC  | 6.0 | -      | -    | -    | 28.0 | 33.0 | 37.0 | 40.0 |     | 10.0      |
| 5                 | 11415           | LC  | 6.0 | -      | -    | -    | -    | 29.0 | 33.0 | 36.0 |     | 4.0       |
| 6                 | 11416           | DFS | 4.0 | -      | -    | -    | -    | -    | 28.0 | 31.0 |     | 5.0       |
| 7                 | 11417           | DFS | 4.0 | -      | -    | -    | -    | -    | -    | 28.0 |     | 3.0       |
| 8                 |                 |     |     | -      | -    | -    | -    | -    | -    | -    |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0 | 11.0 | 3.5  | 2.0  | 1.8  | 1.2  |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00 | 1.50 | 0.48 | 0.28 | 0.20 | 0.15 |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |     |     | Offset |      |      |      |      |      |      |     | Step      |
|-------------------|-----------------|-----|-----|--------|------|------|------|------|------|------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd  | 3rd  | 4th  | 5th  | 6th  | 7th  | 8th | Increment |
| A                 | 911             | RL  | 0.5 |        |      |      |      |      |      |      |     |           |
| 1                 | 11421           | RL  | 0.5 | 35.0   | 42.0 | 49.0 | 60.0 | 63.0 | 68.0 | 70.0 |     | 0.0       |
| 2                 | 11422           | HL  | 3.5 | -      | 35.0 | 42.0 | 53.0 | 56.0 | 61.0 | 63.0 |     | 7.0       |
| 3                 | 11423           | HL  | 3.5 | -      | -    | 28.0 | 39.0 | 42.0 | 47.0 | 49.0 |     | 14.0      |
| 4                 | 11424           | LC  | 6.0 | -      | -    | -    | 32.0 | 35.0 | 40.0 | 42.0 |     | 7.0       |
| 5                 | 11425           | LC  | 6.0 | -      | -    | -    | -    | 31.0 | 36.0 | 38.0 |     | 4.0       |
| 6                 | 11426           | DFS | 4.0 | -      | -    | -    | -    | -    | 31.0 | 33.0 |     | 5.0       |
| 7                 | 11427           | DFS | 4.0 | -      | -    | -    | -    | -    | -    | 30.0 |     | 3.0       |
| 8                 |                 |     |     | -      | -    | -    | -    | -    | -    | -    |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0 | 11.0 | 3.5  | 2.0  | 1.8  | 1.2  |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00 | 1.50 | 0.48 | 0.28 | 0.20 | 0.15 |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |     |     | Offset |      |      |      |      |      |      |     | Step      |
|-------------------|-----------------|-----|-----|--------|------|------|------|------|------|------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd  | 3rd  | 4th  | 5th  | 6th  | 7th  | 8th | Increment |
| A                 | 911             | RL  | 0.5 |        |      |      |      |      |      |      |     |           |
| 1                 | 11431           | RL  | 0.3 | 38.0   | 46.0 | 50.0 | 59.0 | 62.0 | 66.0 | 71.0 |     | 0.0       |
| 2                 | 11432           | HL  | 3.5 | -      | 39.0 | 43.0 | 52.0 | 55.0 | 59.0 | 64.0 |     | 7.0       |
| 3                 | 11433           | HL  | 3.5 | -      | -    | 29.0 | 38.0 | 41.0 | 45.0 | 50.0 |     | 14.0      |
| 4                 | 11434           | LC  | 6.0 | -      | -    | -    | 31.0 | 34.0 | 38.0 | 43.0 |     | 7.0       |
| 5                 | 11435           | LC  | 6.0 | -      | -    | -    | -    | 30.0 | 34.0 | 39.0 |     | 4.0       |
| 6                 | 11436           | DFS | 4.0 | -      | -    | -    | -    | -    | 30.0 | 35.0 |     | 4.0       |
| 7                 | 11437           | DFS | 4.0 | -      | -    | -    | -    | -    | -    | 28.0 |     | 7.0       |
| 8                 |                 |     |     | -      | -    | -    | -    | -    | -    | -    |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0 | 11.0 | 3.5  | 2.0  | 1.8  | 1.2  |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00 | 1.50 | 0.48 | 0.28 | 0.20 | 0.15 |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.05SP           | STEEL         | 5mm                | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 911                   | 11411                 | 11412                 | 11413                 | 11414                 | 11415                 | 11416 | 11417 |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 4                     | 4                     | 2                     | 2                     | 6                     | 6                     | 13    | 8     |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 1.5                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 16                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 12                    | 11                    | 14                    | 15                    | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 14                    | 11                    | 14                    | 15                    | 10                    | 10                    | 9     | 9     |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 45.0<br>(42.0 ~ 48.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 55.0<br>(53.0 ~ 57.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     | 9     | 9     |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     | 2     | 2     |       |
| Pre-Tension        | PT  | 7                     | 7                     | 8                     | 8                     | 8                     | 8                     | 8     | 8     |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 0.5                   | 0.8                   | 4.0                   | 4.0                   | 6.0                   | 6.0                   | 4.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 32.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 39.0  | 32.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 49.0  | 42.0  | 28.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 59.0  | 52.0  | 38.0  | 28.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 64.0  | 57.0  | 43.0  | 33.0  | 29.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 68.0  | 61.0  | 47.0  | 37.0  | 33.0  | 28.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 71.0  | 64.0  | 50.0  | 40.0  | 36.0  | 31.0  | 28.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 7.0   | 14.0  | 10.0  | 4.0   | 5.0   | 3.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.1   | 7.4 ~ 9.0   | 7.4 ~ 9.0   | 6.0 ~ 6.7   | 6.0 ~ 6.7   | 4.0 ~ 4.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 35 ~ 53     | 62 ~ 85     | 26 ~ 43     | 78 ~ 90     | 77 ~ 89     |             |             |
| Avg. Linear Feedrate | ALF |  | 57.0        | 51.1        | 46.3        | 41.3        | 37.2        | 32.2        | 28.4        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.05SP           | STEEL         | 10mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 911                   | 11421                 | 11422                 | 11423                 | 11424                 | 11425                 | 11426 | 11427 |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 4                     | 4                     | 2                     | 2                     | 6                     | 6                     | 14    | 9     |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 1.5                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 16                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 12                    | 12                    | 14                    | 15                    | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 14                    | 12                    | 14                    | 15                    | 10                    | 10                    | 9     | 9     |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 55.0<br>(53.0 ~ 57.0) | 55.0<br>(53.0 ~ 57.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     | 9     | 9     |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     | 2     | 2     |       |
| Pre-Tension        | PT  | 7                     | 7                     | 8                     | 8                     | 8                     | 8                     | 8     | 8     |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 0.5                   | 0.5                   | 3.5                   | 3.5                   | 6.0                   | 6.0                   | 4.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 35.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 42.0  | 35.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 49.0  | 42.0  | 28.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 60.0  | 53.0  | 39.0  | 32.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 63.0  | 56.0  | 42.0  | 35.0  | 31.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 68.0  | 61.0  | 47.0  | 40.0  | 36.0  | 31.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 70.0  | 63.0  | 49.0  | 42.0  | 38.0  | 33.0  | 30.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 7.0   | 14.0  | 7.0   | 4.0   | 5.0   | 3.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.4 ~ 0.6   | 4.9 ~ 6.0   | 4.5 ~ 5.5   | 6.0 ~ 6.7   | 6.0 ~ 6.7   | 4.0 ~ 4.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 27 ~ 50     | 62 ~ 78     | 28 ~ 42     | 67 ~ 80     | 68 ~ 81     |             |             |
| Avg. Linear Feedrate | ALF |  | 30.0        | 27.5        | 25.2        | 23.6        | 22.2        | 20.3        | 18.8        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.05SP           | STEEL         | 20mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 911                   | 11431                 | 11432                 | 11433                 | 11434                 | 11435                 | 11436 | 11437 |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 4                     | 4                     | 2                     | 2                     | 6                     | 6                     | 14    | 9     |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 1.5                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 16                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 12                    | 12                    | 14                    | 15                    | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 14                    | 12                    | 14                    | 15                    | 10                    | 10                    | 9     | 9     |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 70.0<br>(68.0 ~ 72.0) | 35.0<br>(33.0 ~ 37.0) | 30.0<br>(28.0 ~ 32.0) | 30.0<br>(28.0 ~ 32.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 7                     | 7                     | 8                     | 9                     | 9                     | 9                     | 9     | 9     |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     | 2     | 2     |       |
| Pre-Tension        | PT  | 7                     | 7                     | 8                     | 8                     | 8                     | 8                     | 8     | 8     |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 0.5                   | 0.3                   | 3.5                   | 3.5                   | 6.0                   | 6.0                   | 4.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 38.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 46.0  | 39.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 50.0  | 43.0  | 29.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 59.0  | 52.0  | 38.0  | 31.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 62.0  | 55.0  | 41.0  | 34.0  | 30.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 66.0  | 59.0  | 45.0  | 38.0  | 34.0  | 30.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 71.0  | 64.0  | 50.0  | 43.0  | 39.0  | 35.0  | 28.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 7.0   | 14.0  | 7.0   | 4.0   | 4.0   | 7.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.2 ~ 0.4   | 2.6 ~ 3.2   | 2.9 ~ 3.5   | 6.0 ~ 6.7   | 6.0 ~ 6.7   | 4.0 ~ 4.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 29 ~ 51     | 63 ~ 78     | 28 ~ 42     | 27 ~ 44     | 42 ~ 54     |             |             |
| Avg. Linear Feedrate | ALF |  | 18.0        | 16.3        | 15.0        | 14.5        | 13.9        | 13.2        | 12.5        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.05SP            | WC-Co         | DFS   |

Thickness 5 mm

| No.               | Cutting process |     |     | Offset |      |      |      |      |      |      |     | Step      |
|-------------------|-----------------|-----|-----|--------|------|------|------|------|------|------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd  | 3rd  | 4th  | 5th  | 6th  | 7th  | 8th | Increment |
| A                 | 911             | RL  | 0.5 |        |      |      |      |      |      |      |     |           |
| 1                 | 11511           | RL  | 0.5 | 32.0   | 42.0 | 52.0 | 60.0 | 64.0 | 66.0 | 69.0 |     | 0.0       |
| 2                 | 11512           | HL  | 1.5 | -      | 33.0 | 43.0 | 51.0 | 55.0 | 57.0 | 60.0 |     | 9.0       |
| 3                 | 11513           | HL  | 3.0 | -      | -    | 29.0 | 37.0 | 41.0 | 43.0 | 46.0 |     | 14.0      |
| 4                 | 11514           | LC  | 6.0 | -      | -    | -    | 30.0 | 34.0 | 36.0 | 39.0 |     | 7.0       |
| 5                 | 11515           | LC  | 6.0 | -      | -    | -    | -    | 30.0 | 32.0 | 35.0 |     | 4.0       |
| 6                 | 11516           | DFS | 4.0 | -      | -    | -    | -    | -    | 28.0 | 31.0 |     | 4.0       |
| 7                 | 11517           | DFS | 4.0 | -      | -    | -    | -    | -    | -    | 28.0 |     | 3.0       |
| 8                 |                 |     |     | -      | -    | -    | -    | -    | -    | -    |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0 | 11.0 | 3.5  | 2.0  | 1.8  | 1.2  |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00 | 1.50 | 0.48 | 0.28 | 0.20 | 0.15 |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 10 mm

| No.               | Cutting process |     |     | Offset |      |      |      |      |      |      |     | Step      |
|-------------------|-----------------|-----|-----|--------|------|------|------|------|------|------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd  | 3rd  | 4th  | 5th  | 6th  | 7th  | 8th | Increment |
| A                 | 911             | RL  | 0.5 |        |      |      |      |      |      |      |     |           |
| 1                 | 11521           | RL  | 0.4 | 32.0   | 45.0 | 50.0 | 55.0 | 60.0 | 62.0 | 65.0 |     | 0.0       |
| 2                 | 11522           | HL  | 1.5 | -      | 40.0 | 45.0 | 50.0 | 55.0 | 57.0 | 60.0 |     | 5.0       |
| 3                 | 11523           | HL  | 3.0 | -      | -    | 31.0 | 36.0 | 41.0 | 43.0 | 46.0 |     | 14.0      |
| 4                 | 11524           | LC  | 6.0 | -      | -    | -    | 29.0 | 34.0 | 36.0 | 39.0 |     | 7.0       |
| 5                 | 11525           | LC  | 6.0 | -      | -    | -    | -    | 30.0 | 32.0 | 35.0 |     | 4.0       |
| 6                 | 11526           | DFS | 4.0 | -      | -    | -    | -    | -    | 28.0 | 31.0 |     | 4.0       |
| 7                 | 11527           | DFS | 4.0 | -      | -    | -    | -    | -    | -    | 28.0 |     | 3.0       |
| 8                 |                 |     |     | -      | -    | -    | -    | -    | -    | -    |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0 | 11.0 | 3.5  | 2.0  | 1.8  | 1.2  |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00 | 1.50 | 0.48 | 0.28 | 0.20 | 0.15 |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |     |     | Offset |      |      |      |      |      |      |     | Step      |
|-------------------|-----------------|-----|-----|--------|------|------|------|------|------|------|-----|-----------|
|                   | E               | PS  | FA  | 1st    | 2nd  | 3rd  | 4th  | 5th  | 6th  | 7th  | 8th | Increment |
| A                 | 911             | RL  | 0.5 |        |      |      |      |      |      |      |     |           |
| 1                 | 11531           | RL  | 0.3 | 32.0   | 50.0 | 52.0 | 58.0 | 60.0 | 62.0 | 65.0 |     | 0.0       |
| 2                 | 11532           | HL  | 1.0 | -      | 45.0 | 47.0 | 53.0 | 55.0 | 57.0 | 60.0 |     | 5.0       |
| 3                 | 11533           | HL  | 2.5 | -      | -    | 33.0 | 39.0 | 41.0 | 43.0 | 46.0 |     | 14.0      |
| 4                 | 11534           | LC  | 6.0 | -      | -    | -    | 32.0 | 34.0 | 36.0 | 39.0 |     | 7.0       |
| 5                 | 11535           | LC  | 6.0 | -      | -    | -    | -    | 30.0 | 32.0 | 35.0 |     | 4.0       |
| 6                 | 11536           | DFS | 4.0 | -      | -    | -    | -    | -    | 28.0 | 31.0 |     | 4.0       |
| 7                 | 11537           | DFS | 4.0 | -      | -    | -    | -    | -    | -    | 28.0 |     | 3.0       |
| 8                 |                 |     |     | -      | -    | -    | -    | -    | -    | -    |     |           |
| Surface roughness |                 |     | Rz  | 15.0   | 14.0 | 11.0 | 3.5  | 2.0  | 1.8  | 1.2  |     |           |
|                   |                 |     | Ra  | 2.50   | 2.00 | 1.50 | 0.48 | 0.28 | 0.20 | 0.15 |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.05SP           | WC-Co         | 5mm                | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 911                   | 11511                 | 11512                 | 11513                 | 11514                 | 11515                 | 11516 | 11517 |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 4                     | 4                     | 2                     | 2                     | 6                     | 6                     | 14    | 9     |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 1.5                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 16                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 12                    | 12                    | 14                    | 15                    | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 14                    | 12                    | 14                    | 15                    | 10                    | 10                    | 9     | 9     |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 88.0<br>(86.0 ~ 90.0) | 50.0<br>(48.0 ~ 52.0) | 60.0<br>(58.0 ~ 62.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 7                     | 7                     | 7                     | 9                     | 9                     | 9                     | 9     | 9     |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     | 2     | 2     |       |
| Pre-Tension        | PT  | 7                     | 7                     | 8                     | 8                     | 8                     | 8                     | 8     | 8     |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 0.5                   | 0.5                   | 1.5                   | 3.0                   | 6.0                   | 6.0                   | 4.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 32.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 42.0  | 33.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 52.0  | 43.0  | 29.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 60.0  | 51.0  | 37.0  | 30.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 64.0  | 55.0  | 41.0  | 34.0  | 30.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 66.0  | 57.0  | 43.0  | 36.0  | 32.0  | 28.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 69.0  | 60.0  | 46.0  | 39.0  | 35.0  | 31.0  | 28.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 9.0   | 14.0  | 7.0   | 4.0   | 4.0   | 3.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.3 ~ 0.5   | 1.1 ~ 1.4   | 2.8 ~ 3.5   | 6.0 ~ 6.7   | 6.0 ~ 6.7   | 4.0 ~ 4.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 43 ~ 66     | 81 ~ 95     | 48 ~ 52     | 77 ~ 90     | 71 ~ 83     |             |             |
| Avg. Linear Feedrate | ALF |  | 24.0        | 18.2        | 16.6        | 15.9        | 15.3        | 14.3        | 13.5        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.05SP           | WC-Co         | 10mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 911                   | 11521                 | 11522                 | 11523                 | 11524                 | 11525                 | 11526 | 11527 |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 4                     | 4                     | 2                     | 2                     | 6                     | 6                     | 14    | 9     |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 1.5                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 16                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 12                    | 12                    | 14                    | 15                    | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 14                    | 12                    | 14                    | 15                    | 10                    | 10                    | 9     | 9     |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 40.0<br>(37.0 ~ 43.0) | 88.0<br>(86.0 ~ 90.0) | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(38.0 ~ 42.0) | 40.0<br>(38.0 ~ 42.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 7                     | 7                     | 7                     | 9                     | 9                     | 9                     | 9     | 9     |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     | 2     | 2     |       |
| Pre-Tension        | PT  | 7                     | 7                     | 8                     | 8                     | 8                     | 8                     | 8     | 8     |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 0.5                   | 0.4                   | 1.5                   | 3.0                   | 6.0                   | 6.0                   | 4.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 32.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 45.0  | 40.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 50.0  | 45.0  | 31.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 55.0  | 50.0  | 36.0  | 29.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 60.0  | 55.0  | 41.0  | 34.0  | 30.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 62.0  | 57.0  | 43.0  | 36.0  | 32.0  | 28.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 65.0  | 60.0  | 46.0  | 39.0  | 35.0  | 31.0  | 28.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 5.0   | 14.0  | 7.0   | 4.0   | 4.0   | 3.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.2 ~ 0.4   | 0.7 ~ 1.0   | 2.6 ~ 3.2   | 6.0 ~ 6.7   | 6.0 ~ 6.7   | 4.0 ~ 4.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 43 ~ 57     | 78 ~ 91     | 42 ~ 51     | 59 ~ 71     | 52 ~ 64     |             |             |
| Avg. Linear Feedrate | ALF |  | 18.0        | 13.3        | 12.4        | 12.0        | 11.6        | 11.1        | 10.6        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.05SP           | WC-Co         | 20mm               | DFS     | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3                 | Skim4                 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|
| E-pack Number      | Eno | 911                   | 11531                 | 11532                 | 11533                 | 11534                 | 11535                 | 11536 | 11537 |       |
| Power Supply       | PS  | RL                    | RL                    | HL                    | HL                    | LC                    | LC                    | DFS   | DFS   |       |
| Servo              | SV  | NM                    | NM                    | NM                    | NM                    | SL                    | SL                    | NM    | NM    |       |
| Voltage Open       | Vo  | 4                     | 4                     | 2                     | 2                     | 6                     | 6                     | 14    | 9     |       |
| Power Setting      | IP  | 4.0                   | 4.0                   | 4.0                   | 4.0                   | 1.5                   | 1.5                   | 1.0   | 1.0   |       |
| IP adjust          | ΔIP | 16                    | 16                    | 10                    | 10                    |                       |                       |       |       |       |
| Off Time           | OFF | 12                    | 12                    | 14                    | 15                    | 1                     | 1                     | 9     | 9     |       |
| Stabilizer A       | SA  | 1                     | 1                     | 1                     | 1                     | 2                     | 1                     | 5     | 5     |       |
| Stabilizer B       | SB  | 14                    | 12                    | 14                    | 15                    | 10                    | 10                    | 9     | 9     |       |
| Stabilizer C       | SC  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Stabilizer E       | SE  | 1                     | 1                     | 1                     | 1                     | 1                     | 1                     | 1     | 1     |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 50.0<br>(47.0 ~ 53.0) | 88.0<br>(86.0 ~ 90.0) | 50.0<br>(48.0 ~ 52.0) | 25.0<br>(23.0 ~ 27.0) | 25.0<br>(23.0 ~ 27.0) |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | OFF                   | ON                    | ON                    | OFF   | OFF   |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF                   | OFF   | OFF   |       |
| Wire Speed         | WS  | 7                     | 7                     | 7                     | 9                     | 9                     | 9                     | 9     | 9     |       |
| Wire Tension       | WT  | 2                     | 2                     | 2                     | 2                     | 2                     | 2                     | 2     | 2     |       |
| Pre-Tension        | PT  | 7                     | 7                     | 8                     | 8                     | 8                     | 8                     | 8     | 8     |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    | NM                    | NM                    | NM    | NM    |       |
| Liquid Quantity    | LQ  | 10                    | 12                    | 4                     | 4                     | 4                     | 4                     | 4     | 4     |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    | 10                    | 10                    | 10    | 10    |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                     | 0                     | 0                     | 0     | 0     |       |
| Feedrate Address   | FA  | 0.5                   | 0.3                   | 1.0                   | 2.5                   | 6.0                   | 6.0                   | 4.0   | 4.0   |       |
| Upper Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |
| Lower Flow Rate    |     | 6.0                   | 7.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0                   | 1.0   | 1.0   |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 32.0  | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 50.0  | 45.0  | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 52.0  | 47.0  | 33.0  | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- | 58.0  | 53.0  | 39.0  | 32.0  | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- | 60.0  | 55.0  | 41.0  | 34.0  | 30.0  | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- | 62.0  | 57.0  | 43.0  | 36.0  | 32.0  | 28.0  | ----- | ----- |
| Rough & 6 Skims    | ----- | 65.0  | 60.0  | 46.0  | 39.0  | 35.0  | 31.0  | 28.0  | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 5.0   | 14.0  | 7.0   | 4.0   | 4.0   | 3.0   |       |

| RESULTS              |     |  |             |             |             |             |             |             |             |
|----------------------|-----|--|-------------|-------------|-------------|-------------|-------------|-------------|-------------|
| Feedrate Cutting     | FC  |  | 0.2 ~ 0.4   | 2.6 ~ 3.2   | 2.9 ~ 3.5   | 6.0 ~ 6.7   | 6.0 ~ 6.7   | 4.0 ~ 4.0   | 4.0 ~ 4.0   |
| Average Voltage Gap  | V   |  | 33 ~ 51     | 76 ~ 92     | 44 ~ 57     | 32 ~ 40     | 33 ~ 40     |             |             |
| Avg. Linear Feedrate | ALF |  | 18.0        | 16.3        | 15.0        | 14.5        | 13.9        | 13.2        | 12.5        |
| Surface Finish(u m)  | Rz  |  | 13.5 ~ 16.5 | 12.6 ~ 15.4 | 9.9 ~ 12.1  | 3.2 ~ 3.8   | 1.8 ~ 2.2   | 1.6 ~ 2.0   | 1.1 ~ 1.3   |
|                      | Ra  |  | 2.25 ~ 3.75 | 1.80 ~ 3.00 | 1.35 ~ 2.25 | 0.43 ~ 0.72 | 0.25 ~ 0.42 | 0.18 ~ 0.30 | 0.14 ~ 0.23 |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

**5-13 ø0.20 Wire**  
**Machining Characteristics Data**

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | MSPP  |

Thickness 10 mm

| No.               | Cutting process |    |     | Offset |       |       |     |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |     |     |     |     |     |           |
| 1                 | 3811            | RH | 5.5 | 119.0  | 171.0 | 189.0 |     |     |     |     |     | 0.0       |
| 2                 | 3812            | HL | 2.5 | -      | 101.0 | 119.0 |     |     |     |     |     | 70.0      |
| 3                 | 3813            | LC | 8.0 | -      | -     | 106.0 |     |     |     |     |     | 13.0      |
| 4                 |                 |    |     | -      | -     | -     |     |     |     |     |     |           |
| 5                 |                 |    |     | -      | -     | -     | -   |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -   | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -   | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   |     |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  |     |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 20 mm

| No.               | Cutting process |    |     | Offset |       |       |     |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 | 941             | RH | 2.0 |        |       |       |     |     |     |     |     |           |
| 1                 | 3821            | RH | 3.0 | 124.0  | 166.0 | 186.0 |     |     |     |     |     | 0.0       |
| 2                 | 3822            | HL | 2.5 | -      | 101.0 | 121.0 |     |     |     |     |     | 65.0      |
| 3                 | 3823            | LC | 6.0 | -      | -     | 108.0 |     |     |     |     |     | 13.0      |
| 4                 |                 |    |     | -      | -     | -     |     |     |     |     |     |           |
| 5                 |                 |    |     | -      | -     | -     | -   |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -   | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -   | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   |     |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  |     |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 30 mm

| No.               | Cutting process |    |     | Offset |       |       |     |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |     |     |     |     |     |           |
| 1                 | 3831            | RH | 2.2 | 130.0  | 168.0 | 186.0 |     |     |     |     |     | 0.0       |
| 2                 | 3832            | HL | 2.5 | -      | 103.0 | 121.0 |     |     |     |     |     | 65.0      |
| 3                 | 3833            | LC | 6.0 | -      | -     | 108.0 |     |     |     |     |     | 13.0      |
| 4                 |                 |    |     | -      | -     | -     |     |     |     |     |     |           |
| 5                 |                 |    |     | -      | -     | -     | -   |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -   | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -   | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   |     |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  |     |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |



**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | MSPP  |

Thickness 40 mm

| No.               | Cutting process |    |     | Offset |       |       |     |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 | 942             | RH | 1.0 |        |       |       |     |     |     |     |     |           |
| 1                 | 3841            | RH | 1.5 | 136.0  | 171.0 | 187.0 |     |     |     |     |     | 0.0       |
| 2                 | 3842            | HL | 2.5 | -      | 106.0 | 122.0 |     |     |     |     |     | 65.0      |
| 3                 | 3843            | LC | 6.0 | -      | -     | 109.0 |     |     |     |     |     | 13.0      |
| 4                 |                 |    |     | -      | -     | -     |     |     |     |     |     |           |
| 5                 |                 |    |     | -      | -     | -     | -   |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -   | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -   | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   |     |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  |     |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 50 mm

| No.               | Cutting process |    |     | Offset |       |       |     |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |     |     |     |     |     |           |
| 1                 | 3851            | RH | 1.2 | 138.0  | 171.0 | 187.0 |     |     |     |     |     | 0.0       |
| 2                 | 3852            | HL | 2.5 | -      | 106.0 | 122.0 |     |     |     |     |     | 65.0      |
| 3                 | 3853            | LC | 5.0 | -      | -     | 109.0 |     |     |     |     |     | 13.0      |
| 4                 |                 |    |     | -      | -     | -     |     |     |     |     |     |           |
| 5                 |                 |    |     | -      | -     | -     | -   |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -   | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -   | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   |     |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  |     |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 60 mm

| No.               | Cutting process |    |     | Offset |       |       |     |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 | 943             | RH | 0.7 |        |       |       |     |     |     |     |     |           |
| 1                 | 3861            | RH | 1.0 | 141.0  | 171.0 | 188.0 |     |     |     |     |     | 0.0       |
| 2                 | 3862            | HL | 2.5 | -      | 106.0 | 123.0 |     |     |     |     |     | 65.0      |
| 3                 | 3863            | LC | 4.5 | -      | -     | 109.0 |     |     |     |     |     | 14.0      |
| 4                 |                 |    |     | -      | -     | -     |     |     |     |     |     |           |
| 5                 |                 |    |     | -      | -     | -     | -   |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -   | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -   | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   |     |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  |     |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

| Wire Dia. and Type | Material Type | Class |
|--------------------|---------------|-------|
| φ0.20BS            | STEEL         | MSPP  |

Thickness 70 mm

| No.               | Cutting process |    |     | Offset |       |       |     |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |     |     |     |     |     |           |
| 1                 | 3871            | RH | 0.9 | 142.0  | 170.0 | 188.0 |     |     |     |     |     | 0.0       |
| 2                 | 3872            | HL | 2.5 | -      | 105.0 | 123.0 |     |     |     |     |     | 65.0      |
| 3                 | 3873            | LC | 4.5 | -      | -     | 110.0 |     |     |     |     |     | 13.0      |
| 4                 |                 |    |     | -      | -     | -     |     |     |     |     |     |           |
| 5                 |                 |    |     | -      | -     | -     | -   |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -   | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -   | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   |     |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  |     |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 80 mm

| No.               | Cutting process |    |     | Offset |       |       |     |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 | 944             | RH | 0.6 |        |       |       |     |     |     |     |     |           |
| 1                 | 3881            | RH | 0.8 | 143.0  | 170.0 | 187.0 |     |     |     |     |     | 0.0       |
| 2                 | 3882            | HL | 2.5 | -      | 105.0 | 122.0 |     |     |     |     |     | 65.0      |
| 3                 | 3883            | LC | 4.5 | -      | -     | 110.0 |     |     |     |     |     | 12.0      |
| 4                 |                 |    |     | -      | -     | -     |     |     |     |     |     |           |
| 5                 |                 |    |     | -      | -     | -     | -   |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -   | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -   | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   |     |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  |     |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness 90 mm

| No.               | Cutting process |    |     | Offset |       |       |     |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |     |     |     |     |     |           |
| 1                 | 3891            | RH | 0.7 | 142.0  | 170.0 | 187.0 |     |     |     |     |     | 0.0       |
| 2                 | 3892            | HL | 2.5 | -      | 105.0 | 122.0 |     |     |     |     |     | 65.0      |
| 3                 | 3893            | LC | 4.5 | -      | -     | 110.0 |     |     |     |     |     | 12.0      |
| 4                 |                 |    |     | -      | -     | -     |     |     |     |     |     |           |
| 5                 |                 |    |     | -      | -     | -     | -   |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -   | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -   | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   |     |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  |     |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

**MV2400R****Digest**

|                    |               |       |
|--------------------|---------------|-------|
| Wire Dia. and Type | Material Type | Class |
| φ0.20BS            | STEEL         | MSPP  |

Thickness 100 mm

| No.               | Cutting process |    |     | Offset |       |       |     |     |     |     |     | Step      |
|-------------------|-----------------|----|-----|--------|-------|-------|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA  | 1st    | 2nd   | 3rd   | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 | 945             | RH | 0.5 |        |       |       |     |     |     |     |     |           |
| 1                 | 3901            | RH | 0.7 | 141.0  | 170.0 | 187.0 |     |     |     |     |     | 0.0       |
| 2                 | 3902            | HL | 2.5 | -      | 105.0 | 122.0 |     |     |     |     |     | 65.0      |
| 3                 | 3903            | LC | 4.5 | -      | -     | 110.0 |     |     |     |     |     | 12.0      |
| 4                 |                 |    |     | -      | -     | -     |     |     |     |     |     |           |
| 5                 |                 |    |     | -      | -     | -     | -   |     |     |     |     |           |
| 6                 |                 |    |     | -      | -     | -     | -   | -   |     |     |     |           |
| 7                 |                 |    |     | -      | -     | -     | -   | -   | -   |     |     |           |
| 8                 |                 |    |     | -      | -     | -     | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz  | 18.0   | 13.0  | 3.8   |     |     |     |     |     |           |
|                   |                 |    | Ra  | 2.70   | 1.80  | 0.50  |     |     |     |     |     |           |

| Nozzle Gap |        |
|------------|--------|
| Upper      | 0.20mm |
| Lower      | 0.20mm |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

Thickness mm

| No.               | Cutting process |    |    | Offset |     |     |     |     |     |     |     | Step      |
|-------------------|-----------------|----|----|--------|-----|-----|-----|-----|-----|-----|-----|-----------|
|                   | E               | PS | FA | 1st    | 2nd | 3rd | 4th | 5th | 6th | 7th | 8th | Increment |
| A                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 1                 |                 |    |    |        |     |     |     |     |     |     |     |           |
| 2                 |                 |    |    | -      |     |     |     |     |     |     |     |           |
| 3                 |                 |    |    | -      | -   |     |     |     |     |     |     |           |
| 4                 |                 |    |    | -      | -   | -   |     |     |     |     |     |           |
| 5                 |                 |    |    | -      | -   | -   | -   |     |     |     |     |           |
| 6                 |                 |    |    | -      | -   | -   | -   | -   |     |     |     |           |
| 7                 |                 |    |    | -      | -   | -   | -   | -   | -   |     |     |           |
| 8                 |                 |    |    | -      | -   | -   | -   | -   | -   | -   |     |           |
| Surface roughness |                 |    | Rz |        |     |     |     |     |     |     |     |           |
|                   |                 |    | Ra |        |     |     |     |     |     |     |     |           |

| Nozzle Gap |  |
|------------|--|
| Upper      |  |
| Lower      |  |

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 10mm               | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 3811                  | 3812                  | 3813                     |       |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       |       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | SL                    | SL                       |       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                       |       |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 7.0                   | 14.0                  | 3.0                      |       |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 1                        |       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        |       |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 5                     | 8                     | 1                        |       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        |       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        |       |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 46.0<br>(43.0 ~ 49.0) | 30.0<br>(28.0 ~ 32.0) | 155.0<br>(153.0 ~ 157.0) |       |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       |       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      |       |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       |       |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       |       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       |       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       |       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        |       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       |       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 0                     | 0                     | 0                        |       |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 5.5                   | 2.5                   | 8.0                      |       |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      |       |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      |       |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 119.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 171.0 | 101.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 189.0 | 119.0 | 106.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- |       |       |       | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 70.0  | 13.0  |       |       |       |       |       |

| RESULTS              |     |  |             |             |             |  |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 6.1 ~ 7.4   | 14.0 ~ 17.2 | 7.3 ~ 8.2   |  |  |  |  |
| Average Voltage Gap  | V   |  | 37 ~ 49     | 62 ~ 72     | 159 ~ 169   |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 405.0       | 282.7       | 175.8       |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   |  |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 20mm               | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-------|-------|-------|-------|-------|
| E-pack Number      | Eno | 941                   | 3821                  | 3822                  | 3823                     |       |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       |       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | SL                    | SL                       |       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                       |       |       |       |       |       |
| Power Setting      | IP  | 6.0                   | 8.0                   | 14.0                  | 3.0                      |       |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 8                     | 1                        |       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        |       |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 8                     | 1                        |       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        |       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        |       |       |       |       |       |
| Voltage Gap        | VG  | 60.0<br>(58.0 ~ 62.0) | 42.0<br>(39.0 ~ 45.0) | 30.0<br>(28.0 ~ 32.0) | 120.0<br>(118.0 ~ 122.0) |       |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       |       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      |       |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       |       |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       |       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       |       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       |       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        |       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       |       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 15                    | 15                    | 15                       |       |       |       |       |       |
| Feedrate Address   | FA  | 2.0                   | 3.0                   | 2.5                   | 6.0                      |       |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      |       |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      |       |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 124.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 166.0 | 101.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 186.0 | 121.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  |       |       |       |       |       |

| RESULTS              |     |  |             |             |             |  |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 4.4 ~ 5.4   | 9.6 ~ 11.8  | 5.5 ~ 6.1   |  |  |  |  |
| Average Voltage Gap  | V   |  | 37 ~ 49     | 57 ~ 67     | 124 ~ 136   |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 294.0       | 201.7       | 127.7       |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   |  |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 30mm               | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 3831                  | 3832                  | 3833                     |       |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       |       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | SL                    | SL                       |       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                       |       |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                      |       |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 9                     | 1                        |       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        |       |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 9                     | 1                        |       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        |       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        |       |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 46.0<br>(43.0 ~ 49.0) | 30.0<br>(28.0 ~ 32.0) | 116.0<br>(114.0 ~ 118.0) |       |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       |       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      |       |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       |       |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       |       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       |       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       |       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        |       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       |       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                       |       |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 2.2                   | 2.5                   | 6.0                      |       |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      |       |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      |       |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 130.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 168.0 | 103.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 186.0 | 121.0 | 108.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  |       |       |       |       |       |

| RESULTS              |     |  |             |             |             |  |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 3.1 ~ 3.7   | 6.7 ~ 8.3   | 5.5 ~ 6.0   |  |  |  |  |
| Average Voltage Gap  | V   |  | 37 ~ 49     | 60 ~ 70     | 118 ~ 130   |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 204.0       | 140.4       | 99.8        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   |  |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 40mm               | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                    | Skim3 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|--------------------------|-------|-------|-------|-------|-------|
| E-pack Number      | Eno | 942                   | 3841                  | 3842                  | 3843                     |       |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                       |       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | SL                    | SL                       |       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                       |       |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                      |       |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                          |       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                        |       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                        |       |       |       |       |       |
| Stabilizer B       | SB  | 8                     | 4                     | 10                    | 1                        |       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                        |       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                        |       |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 50.0<br>(47.0 ~ 53.0) | 30.0<br>(28.0 ~ 32.0) | 112.0<br>(110.0 ~ 114.0) |       |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                       |       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                      |       |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                       |       |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                       |       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                       |       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                       |       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                        |       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                       |       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                       |       |       |       |       |       |
| Feedrate Address   | FA  | 1.0                   | 1.5                   | 2.5                   | 6.0                      |       |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      |       |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                      |       |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 136.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 171.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 187.0 | 122.0 | 109.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  |       |       |       |       |       |

| RESULTS              |     |  |             |             |             |  |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 1.7 ~ 2.1   | 3.9 ~ 4.8   | 5.4 ~ 6.0   |  |  |  |  |
| Average Voltage Gap  | V   |  | 37 ~ 49     | 62 ~ 72     | 112 ~ 124   |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 114.0       | 79.3        | 64.4        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   |  |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 50mm               | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                  | Skim3 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|------------------------|-------|-------|-------|-------|-------|
| E-pack Number      | Eno | 943                   | 3851                  | 3852                  | 3853                   |       |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                     |       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | SL                    | SL                     |       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                     |       |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                    |       |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 10                    | 12                    |                        |       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                      |       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                      |       |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                    | 1                      |       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                      |       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                      |       |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 44.0<br>(41.0 ~ 47.0) | 30.0<br>(28.0 ~ 32.0) | 98.0<br>(96.0 ~ 100.0) |       |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                     |       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                    |       |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                     |       |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                     |       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                     |       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                     |       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                      |       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                     |       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                     |       |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.2                   | 2.5                   | 5.0                    |       |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                    |       |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                    |       |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 138.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 171.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 187.0 | 122.0 | 109.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  |       |       |       |       |       |

| RESULTS              |     |  |             |             |             |  |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 1.6 ~ 2.0   | 3.3 ~ 4.1   | 5.0 ~ 5.6   |  |  |  |  |
| Average Voltage Gap  | V   |  | 36 ~ 47     | 60 ~ 70     | 100 ~ 112   |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 108.0       | 72.7        | 59.1        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   |  |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)



# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 60mm               | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|-------|
| E-pack Number      | Eno | 943                   | 3861                  | 3862                  | 3863                  |       |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    |       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | SL                    | SL                    |       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 12                    |       |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   |       |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     |       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     |       |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                    | 1                     |       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     |       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     |       |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 38.0<br>(35.0 ~ 41.0) | 30.0<br>(28.0 ~ 32.0) | 85.0<br>(83.0 ~ 87.0) |       |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    |       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    |       |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    |       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    |       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    |       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     |       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    |       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    |       |       |       |       |       |
| Feedrate Address   | FA  | 0.7                   | 1.0                   | 2.5                   | 4.5                   |       |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 141.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 171.0 | 106.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 188.0 | 123.0 | 109.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 14.0  |       |       |       |       |       |

| RESULTS              |     |  |             |             |             |  |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 1.5 ~ 1.9   | 2.8 ~ 3.5   | 4.7 ~ 5.2   |  |  |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 46     | 52 ~ 62     | 89 ~ 101    |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 102.0       | 66.2        | 54.2        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   |  |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 70mm               | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|-------|
| E-pack Number      | Eno | 944                   | 3871                  | 3872                  | 3873                  |       |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    |       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | SL                    | SL                    |       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 13                    |       |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   |       |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     |       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     |       |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                    | 1                     |       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     |       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     |       |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 40.0<br>(37.0 ~ 43.0) | 30.0<br>(28.0 ~ 32.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    |       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    |       |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    |       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    |       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    |       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     |       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    |       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    |       |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.9                   | 2.5                   | 4.5                   |       |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 142.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 170.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 188.0 | 123.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 13.0  |       |       |       |       |       |

| RESULTS              |     |  |             |             |             |  |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 1.2 ~ 1.7   | 2.6 ~ 3.3   | 4.8 ~ 5.3   |  |  |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 47     | 52 ~ 62     | 85 ~ 103    |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 87.0        | 58.3        | 48.9        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   |  |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 80mm               | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|-------|
| E-pack Number      | Eno | 944                   | 3881                  | 3882                  | 3883                  |       |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    |       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | SL                    | SL                    |       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 14                    |       |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   |       |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     |       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     |       |       |       |       |       |
| Stabilizer B       | SB  | 7                     | 4                     | 10                    | 1                     |       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     |       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     |       |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 42.0<br>(39.0 ~ 45.0) | 30.0<br>(28.0 ~ 32.0) | 65.0<br>(63.0 ~ 67.0) |       |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    |       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    |       |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    |       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    |       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    |       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     |       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    |       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    |       |       |       |       |       |
| Feedrate Address   | FA  | 0.6                   | 0.8                   | 2.5                   | 4.5                   |       |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 143.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 170.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 187.0 | 122.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- |       |       |       | ----- | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Stepping Increment | ----- | ----- | 65.0  | 12.0  |       |       |       |       |       |

| RESULTS              |     |  |             |             |             |  |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 1.0 ~ 1.2   | 2.5 ~ 3.1   | 5.0 ~ 5.5   |  |  |  |  |
| Average Voltage Gap  | V   |  | 35 ~ 48     | 44 ~ 54     | 81 ~ 93     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 66.0        | 47.4        | 41.2        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   |  |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 90mm               | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|-------|
| E-pack Number      | Eno | 945                   | 3891                  | 3892                  | 3893                  |       |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    |       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | SL                    | SL                    |       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 14                    |       |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   |       |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     |       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     |       |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 10                    | 1                     |       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     |       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     |       |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 44.0<br>(41.0 ~ 47.0) | 30.0<br>(28.0 ~ 32.0) | 60.0<br>(58.0 ~ 62.0) |       |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    |       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    |       |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    |       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    |       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    |       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     |       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    |       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    |       |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.7                   | 2.5                   | 4.5                   |       |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 142.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 170.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 187.0 | 122.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 12.0  |       |       |       |       |       |

| RESULTS              |     |  |             |             |             |  |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.8 ~ 1.0   | 2.5 ~ 3.1   | 4.5 ~ 5.0   |  |  |  |  |
| Average Voltage Gap  | V   |  | 38 ~ 49     | 39 ~ 49     | 71 ~ 83     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 54.0        | 40.9        | 35.7        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   |  |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)

# MV2400R Machning Data Sheet

| Wire Dia. and Type | Material Type | Material Thickness | Process | Nozzle Dia | Flush cup clearance |        |
|--------------------|---------------|--------------------|---------|------------|---------------------|--------|
|                    |               |                    |         |            | Upper               | Lower  |
| φ 0.20BS           | STEEL         | 100mm              | MSPP    | φ 4.0mm    | 0.20mm              | 0.20mm |

| Cutting Process    |     | Start Up              | Rough Cut             | Skim1                 | Skim2                 | Skim3 | Skim4 | Skim5 | Skim6 | Skim7 |
|--------------------|-----|-----------------------|-----------------------|-----------------------|-----------------------|-------|-------|-------|-------|-------|
| E-pack Number      | Eno | 945                   | 3901                  | 3902                  | 3903                  |       |       |       |       |       |
| Power Supply       | PS  | RH                    | RH                    | HL                    | LC                    |       |       |       |       |       |
| Servo              | SV  | NM                    | NM                    | SL                    | SL                    |       |       |       |       |       |
| Voltage Open       | Vo  | 7                     | 7                     | 16                    | 14                    |       |       |       |       |       |
| Power Setting      | IP  | 7.0                   | 9.0                   | 14.0                  | 3.0                   |       |       |       |       |       |
| IP adjust          | ΔIP | 11                    | 11                    | 12                    |                       |       |       |       |       |       |
| Off Time           | OFF | 6                     | 3                     | 10                    | 1                     |       |       |       |       |       |
| Stabilizer A       | SA  | 3                     | 5                     | 1                     | 1                     |       |       |       |       |       |
| Stabilizer B       | SB  | 6                     | 5                     | 10                    | 1                     |       |       |       |       |       |
| Stabilizer C       | SC  | 7                     | 7                     | 1                     | 4                     |       |       |       |       |       |
| Stabilizer E       | SE  | 4                     | 4                     | 1                     | 1                     |       |       |       |       |       |
| Voltage Gap        | VG  | 50.0<br>(48.0 ~ 52.0) | 46.0<br>(43.0 ~ 49.0) | 30.0<br>(28.0 ~ 32.0) | 50.0<br>(48.0 ~ 52.0) |       |       |       |       |       |
| Fine machining     | FM  | OFF                   | OFF                   | OFF                   | ON                    |       |       |       |       |       |
| Digital AE         | DAE | OFF                   | OFF                   | OFF                   | OFF                   |       |       |       |       |       |
| Wire Speed         | WS  | 8                     | 9                     | 12                    | 10                    |       |       |       |       |       |
| Wire Tension       | WT  | 6                     | 8                     | 10                    | 10                    |       |       |       |       |       |
| Pre-Tension        | PT  | 14                    | 14                    | 14                    | 14                    |       |       |       |       |       |
| Flow Balance       | FB  | NM                    | NM                    | NM                    | NM                    |       |       |       |       |       |
| Liquid Quantity    | LQ  | 11                    | 14                    | 4                     | 4                     |       |       |       |       |       |
| Liquid Resistivity | LR  | 10                    | 10                    | 10                    | 10                    |       |       |       |       |       |
| Straightness cmp.  | CC  | 0                     | 20                    | 20                    | 20                    |       |       |       |       |       |
| Feedrate Address   | FA  | 0.5                   | 0.7                   | 2.5                   | 4.5                   |       |       |       |       |       |
| Upper Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |
| Lower Flow Rate    |     | 6.0                   | 8.0                   | 1.0                   | 1.0                   |       |       |       |       |       |

| Offset Value(s)    |       |       |       |       |       |       |       |       |       |
|--------------------|-------|-------|-------|-------|-------|-------|-------|-------|-------|
| Rough Cut          | ----- | 141.0 | ----- | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 1 Skim     | ----- | 170.0 | 105.0 | ----- | ----- | ----- | ----- | ----- | ----- |
| Rough & 2 Skims    | ----- | 187.0 | 122.0 | 110.0 | ----- | ----- | ----- | ----- | ----- |
| Rough & 3 Skims    | ----- |       |       |       |       | ----- | ----- | ----- | ----- |
| Rough & 4 Skims    | ----- |       |       |       |       |       | ----- | ----- | ----- |
| Rough & 5 Skims    | ----- |       |       |       |       |       |       | ----- | ----- |
| Rough & 6 Skims    | ----- |       |       |       |       |       |       |       | ----- |
| Rough & 7 Skims    | ----- |       |       |       |       |       |       |       |       |
| Stepping Increment | ----- | ----- | 65.0  | 12.0  |       |       |       |       |       |

| RESULTS              |     |  |             |             |             |  |  |  |  |
|----------------------|-----|--|-------------|-------------|-------------|--|--|--|--|
| Feedrate Cutting     | FC  |  | 0.6 ~ 0.8   | 2.6 ~ 3.1   | 4.1 ~ 4.6   |  |  |  |  |
| Average Voltage Gap  | V   |  | 41 ~ 52     | 34 ~ 44     | 62 ~ 73     |  |  |  |  |
| Avg. Linear Feedrate | ALF |  | 42.0        | 33.7        | 29.9        |  |  |  |  |
| Surface Finish(u m)  | Rz  |  | 16.2 ~ 19.8 | 11.7 ~ 14.3 | 3.4 ~ 4.2   |  |  |  |  |
|                      | Ra  |  | 2.43 ~ 4.05 | 1.62 ~ 2.70 | 0.45 ~ 0.75 |  |  |  |  |

Note: Set flush cup clearance as shown as Top chart.

Note: Please use the straightness compensation function.

(If wire breakage occurs, set FA Adjust to -1 or -2 on monitor screen.)