



## **WIRE-CUT EDM SYSTEMS**

**MV2400S**

**MACHINING CHARACTERISTICS DATA BOOK**

BQN-W-70765—G

**(Version 9.0)**

## **Mitsubishi Electric Wire-cut EDM Systems MV2400S 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.

### **Copyright**

Copying or reproducing this Instructional Manual, in whole or in part, without the permission of Mitsubishi Electric Corporation, is strictly prohibited.

©2012(2013-2014) MITSUBISHI ELECTRIC CORPORATION  
ALL RIGHTS RESERVED

Edited by: Mitsubishi Electric Corporation, Nagoya Works, EDM Systems  
Dept., EDM Application Technology Section

Version 9.0  
Prepared/Revised: 2014-3

BQN-W-70765—G

# Contents

## 1. Configuration of Machining Conditions Table

1-1	Configuration of Machining Conditions Table	.....	A1
1-2	Machining Conditions	.....	A2

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

2-1	How to Read the Machining Characteristics Data Table (Machining Condition Digest)	.....	A3
2-2	How to Read the Machining Characteristics Data Table (Machining Conditions Table)	.....	A4
2-3	Names of Machining Conditions Setting Notches	.....	A5
2-4	Notch Settings	.....	A6
2-5	Setting the Nozzle and Dielectric Fluid Flow Rate	.....	A8

## 3. Adaptive Control

3-1	Machining with PM Control	.....	A9
3-2	Machining with CM control	.....	A13
3-3	Machining with RM Control	.....	A17
3-4	Machining with EM Control	.....	A18
3-5	Machining with OM control	.....	A19
3-6	Machining with BM control	.....	A20

## 4. Optimizing Machining Conditions

4-1	1st Cut Machining Section	.....	A22
4-2	Finish Machining Section	.....	A23
4-3	Nozzle Separated Machining Section	.....	A24
4-4	Correcting the Upper/lower Dimension Difference	.....	A25

## 5. Machining Characteristics Data

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

Wire dia. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions 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. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions 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. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions 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. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions 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. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions 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. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions Material thickness (mm)		
$\phi 0.20$	STEEL	Land(LND)	36	1	to	5
	Tungsten Carbide(WC-Co)		37	1	to	5
$\phi 0.25$	STEEL		38	1	to	5
	Tungsten Carbide(WC-Co)		39	1	to	5

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

Wire dia. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions Material thickness (mm)		
$\phi 0.20$	PCD	Standard(STD)	40	2	to	2
	CBN		41	2	to	2
$\phi 0.25$	PCD	Standard(STD)	42	2	to	2
	CBN		43	2	to	2

\* 2  
\* 3  
\* 2  
\* 3

#### 5-8 SL Machining characteristics data

Wire dia. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions Material thickness (mm)		
$\phi 0.20$	STEEL	SL Machining(SL)	44	5	to	100
$\phi 0.25$	STEEL		45	5	to	100

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

\*4

Wire dia. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions Material thickness (mm)		
$\phi 0.20$	STEEL	Standard(STD)	46	20	to	40
$\phi 0.25$	STEEL		47	20	to	40

#### 5-10 $\phi 0.20$ wire Machining characteristics data

Wire dia. (mm)	Workpiece material	Applicable mode	Classification No.	Machining conditions Material thickness (mm)		
$\phi 0.20$	STEEL	Minimum Step Punch(MSPP)	48	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  $\mu\text{m}$ ) only.  
For other particle diameter conditions, see the machining conditions table.
- \*3: For CBN, machining conditions are searched for type 1 (particle diameter 10  $\mu\text{m}$ ) 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 100	5 to 100	-
	Standard Die(STDD1)	-	-	-	-	5 to 100	5 to 100	-
	Standard(STD)	-	-	5 to 40	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 (STDPO1)	-	-	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	-
Tungsten Carbide	Standard (STD)	-	-	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 (STDPO1)	-	-	5 to 10	5 to 10	-	-	-
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.....STDPO1
- 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

\*1 Angle Taper is an option.

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

## **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

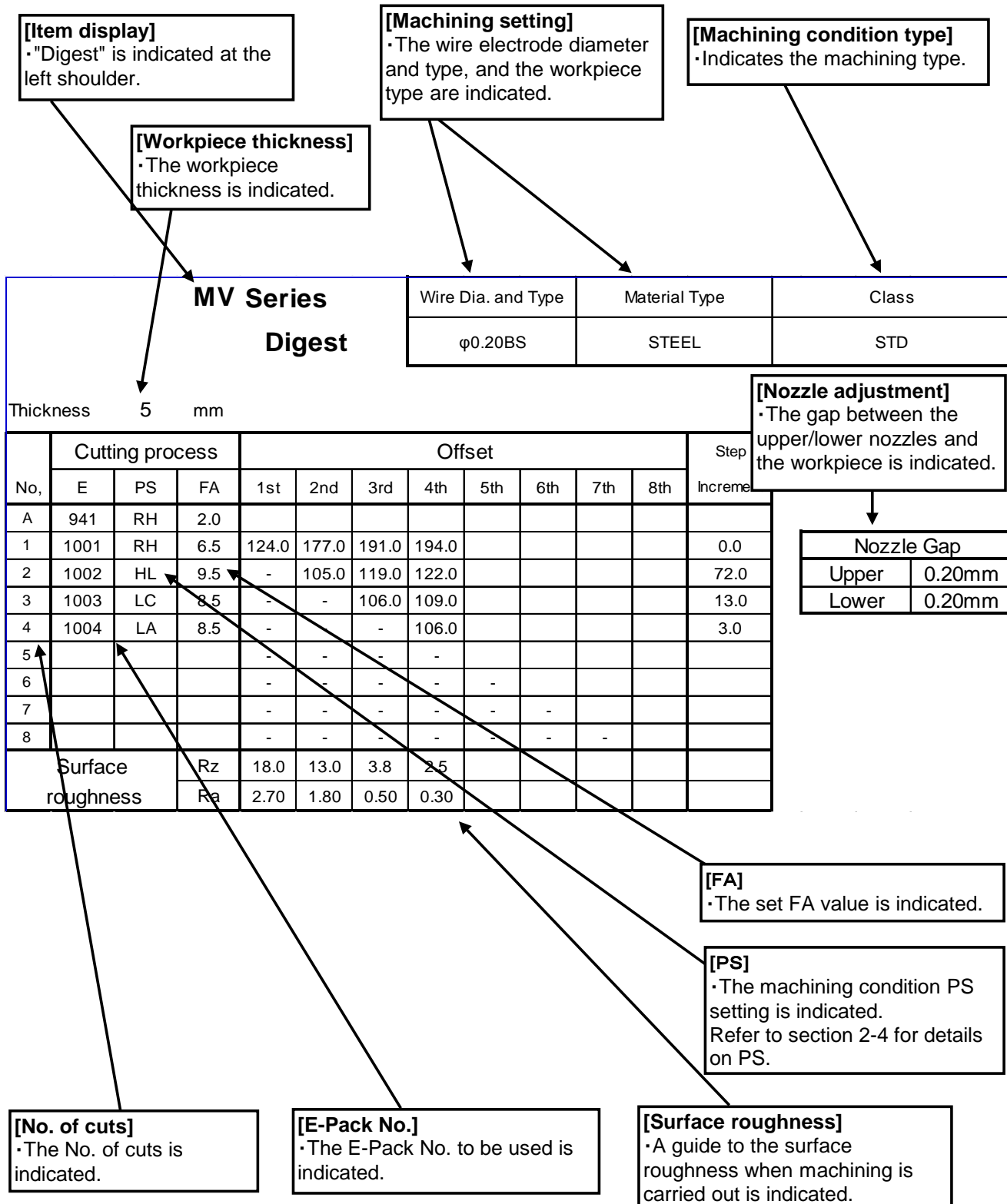
## 2. How to Read the Machining Characteristics Data Table

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 (58.0 ~ 62.0)	50.0 (47.0 ~ 53.0)	60.0 (58.0 ~ 62.0)	150.0 (148.0 ~ 152.0)	115.0 (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 (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

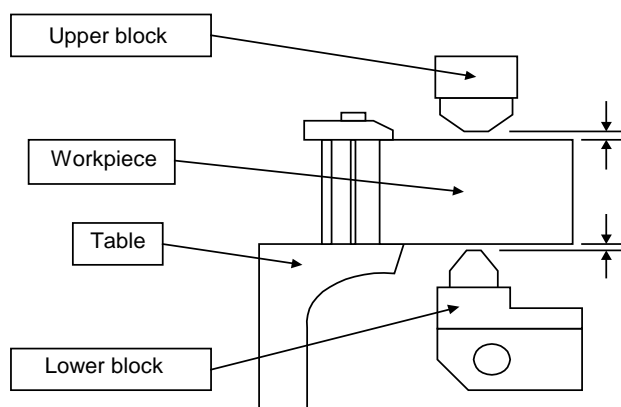
## 2-4 Notch Settings

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. 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. 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. 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. Please use WT1~2 only on fine wire specification machine. 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. 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. 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. 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. Use ▲ or ▼ to increase or decrease notch level.

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

### 2-5-1 Installing the workpiece

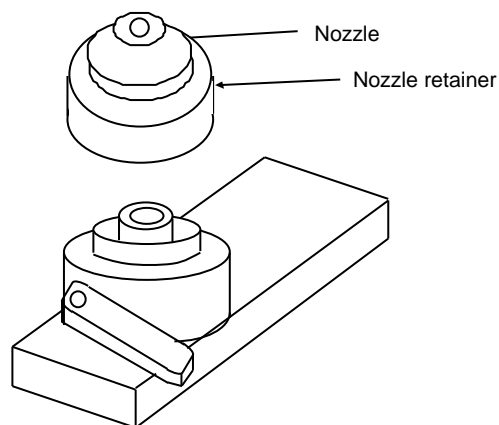


#### Upper clearance setting

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° (Up to 100 mm)	0 to 15° (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° (Up to 100 mm)	0 to 15° (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**

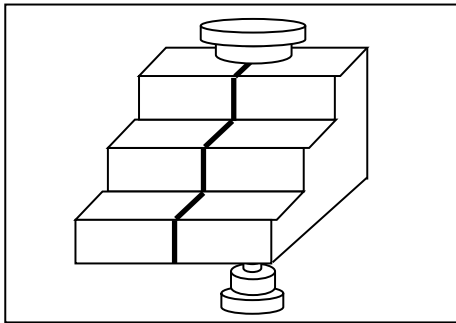
- (1) The application range above may be expanded in the future. When expanded, the application range will be listed in the "Supplement" for the system software, so please refer to that document.
- (2) The above applicable ranges are for submerged machining. When carrying out non-submerged machining 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

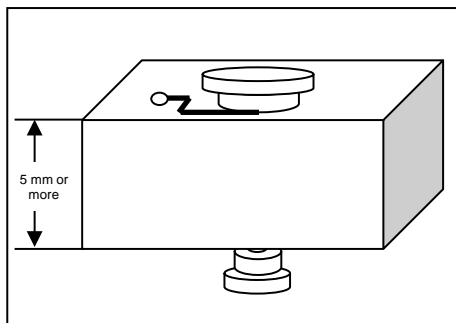


This mode is used when machining workpieces that have changes in the plate thickness (minimum plate thickness is 5 mm or more \*1), such as hollow shapes like pipes or stepped workpieces. This mode is effective when the state of the dielectric fluid is poor such as when biting from the workpiece edges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

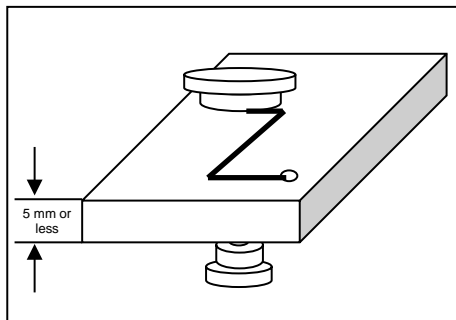
In the nozzle contact mode, contact the dielectric fluid nozzle against the workpiece. (\*2)

\*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

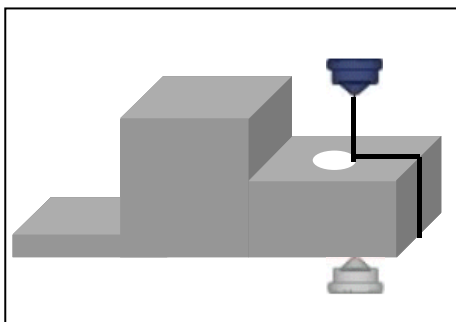


This mode is used when machining thin workpieces that have changes in the plate thickness of 5mm or less (\*1), or when the state of the dielectric fluid is poor such as when the dielectric fluid nozzle cannot be contacted against the workpiece.

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

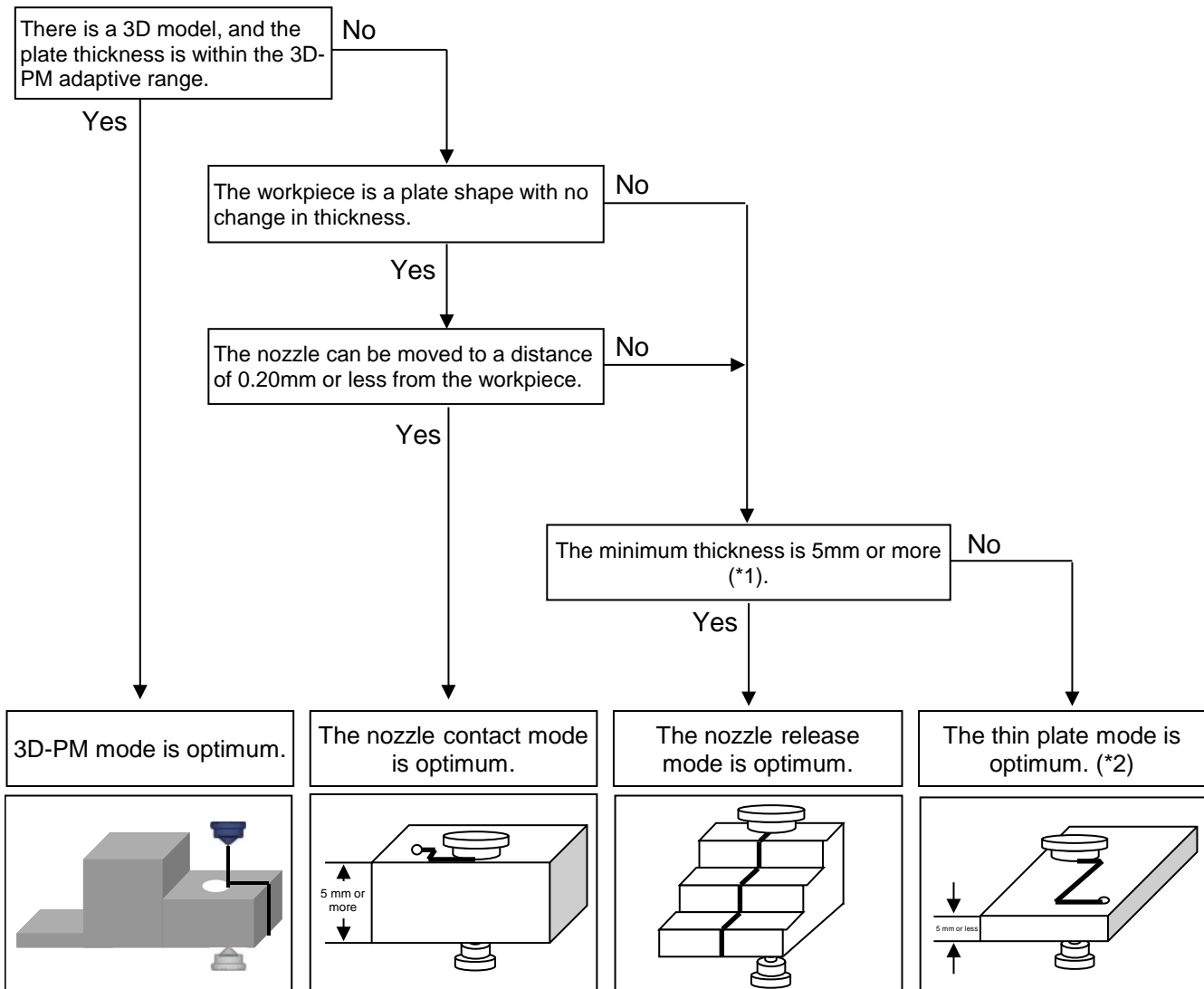
\*1: The thin plate mode cannot be used when using a  $\phi 0.30$  wire.

##### 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.

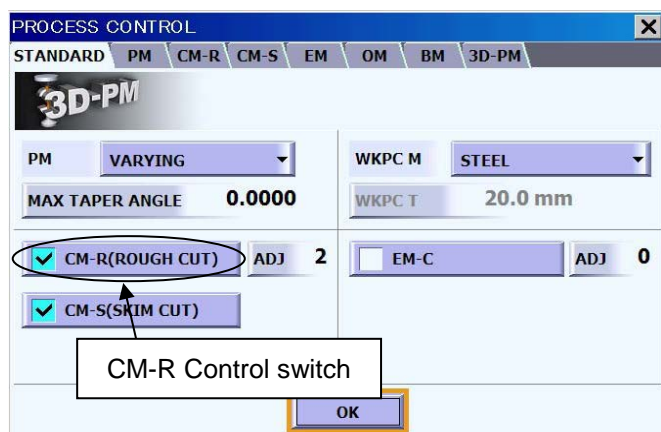
"CM-R" is a function that prevents corner drooping during the 1st cut. This control can be used only in the following cases.

- 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.

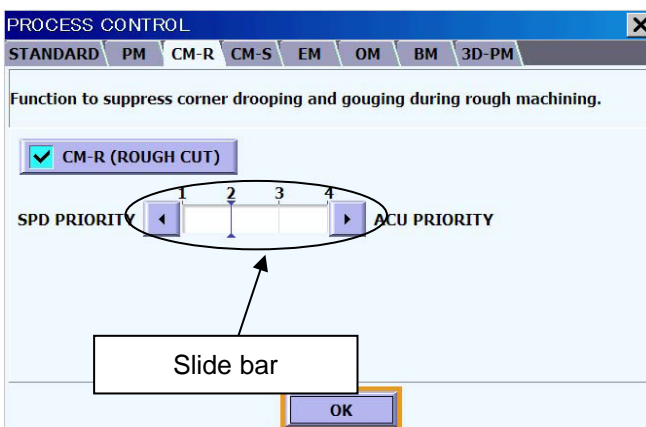
### [Usage Methods]

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)

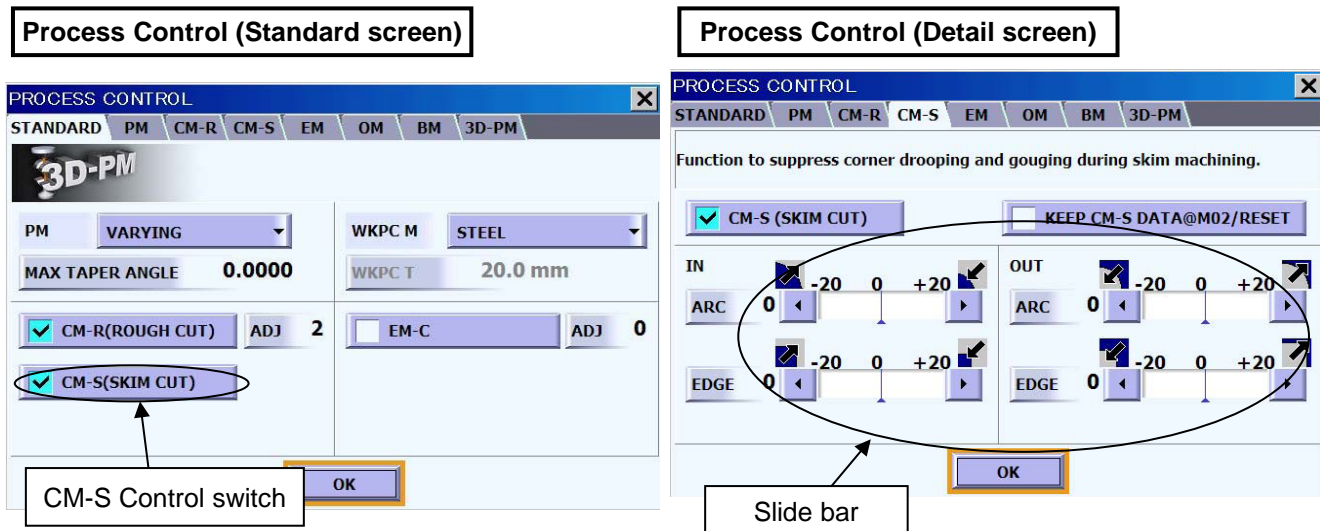


## (2)Setting CM-S

"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"

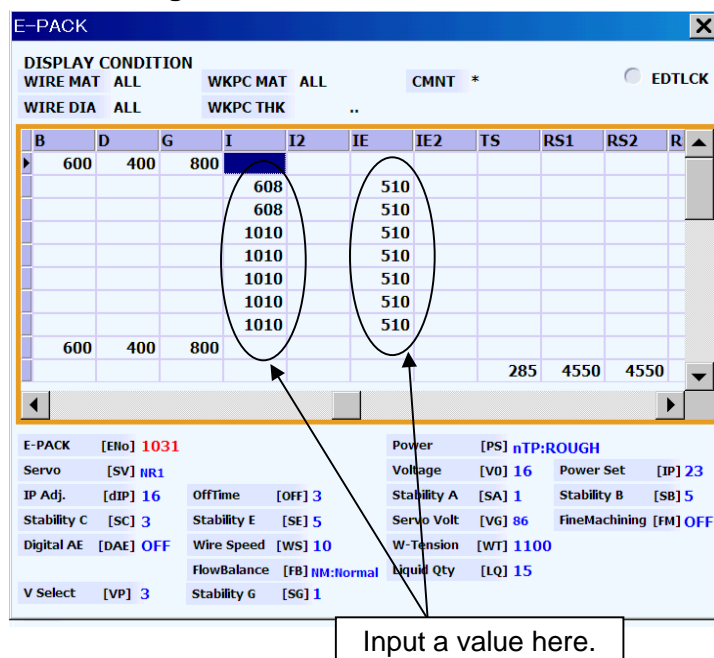
## [Usage methods (Applied) CM-S2]

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. At the top, there are tabs for DISPLAY CONDITION, WIRE MAT, WKPC MAT, and CMNT. Below these are various parameter settings including IE2, TS, RS1, RS2, RS3, RS4, RS5, RS6, ES1, ES2, and ES3. A table of values is displayed, showing settings for different corner radii (RS1 to RS6) and edge corner settings (ES1 to ES6). The values range from 0.0001mm to 1mm for corner radii and 90° to 165° for edge corner settings. A callout box points to the RS1 parameter, indicating that a value should be input here.

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.

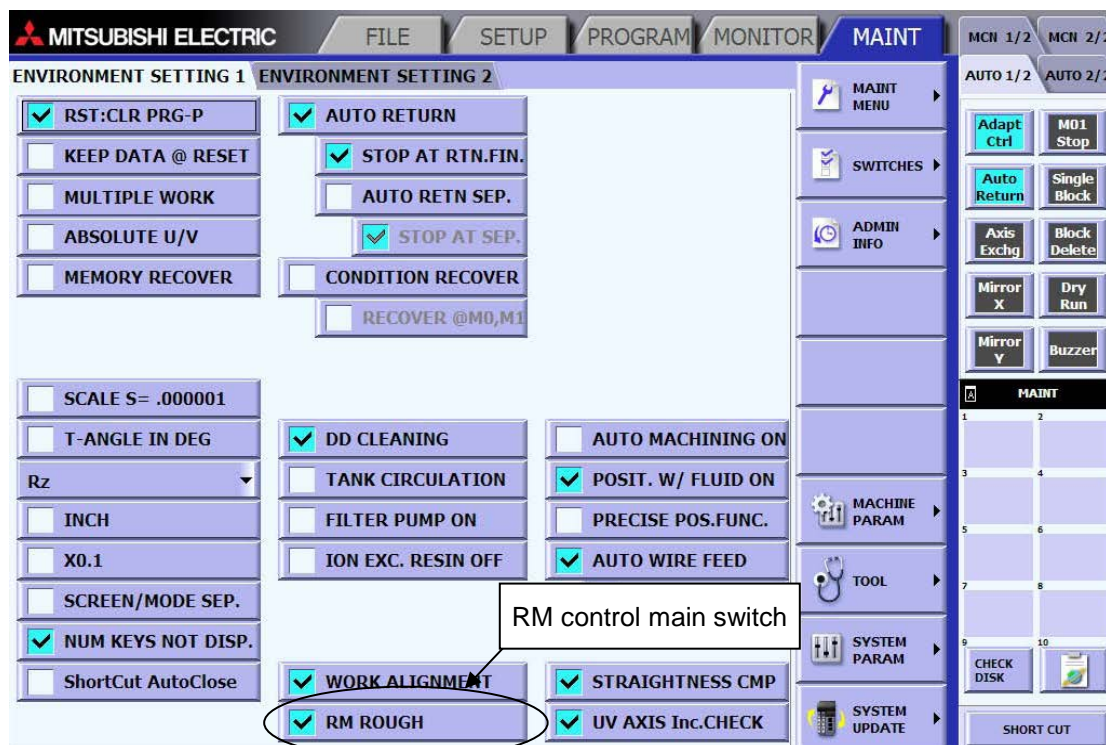
### 3-3 Machining with RM control

"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]

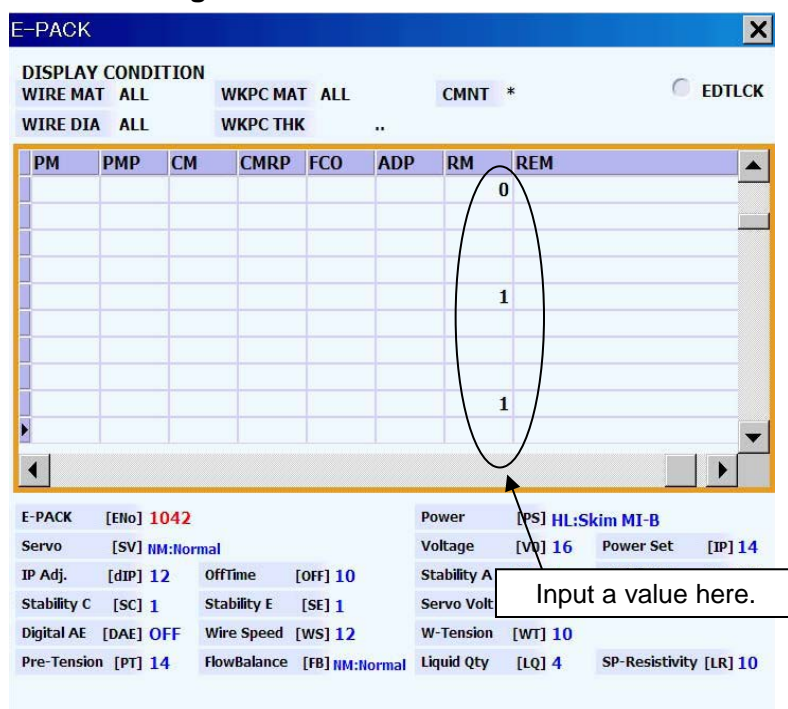
#### Maintenance Screen



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.

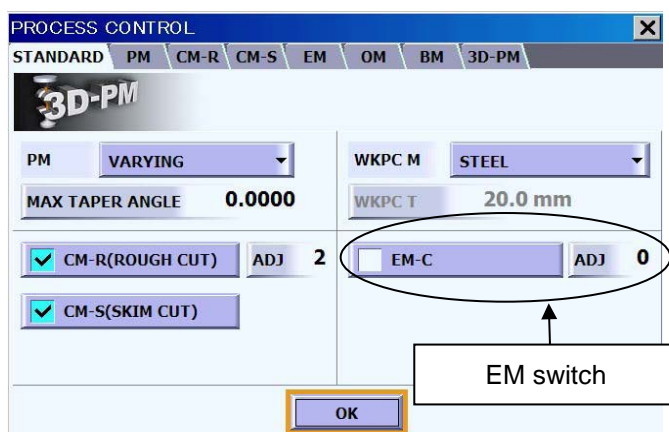
##### 1) To use EM-condition control

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.

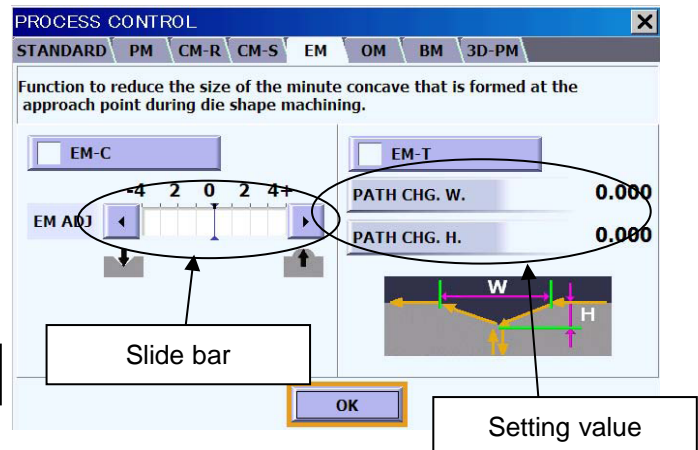
##### 2) To use EM-path control

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

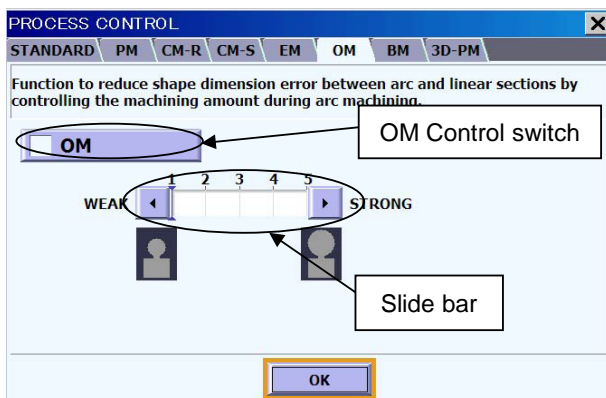
Open the "Process Control" screen from the "Automatic 2nd cut" screen or "MONITOR" screen, and turn the OM switch ON.

#### (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 ø0.2 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 2) Increase VG by 3 to 5 notches 3) Increase SB by 1 to 3 notches
2) Short-circuits occur during 1st cut	1) Increase VG by 2 to 8 notches 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.

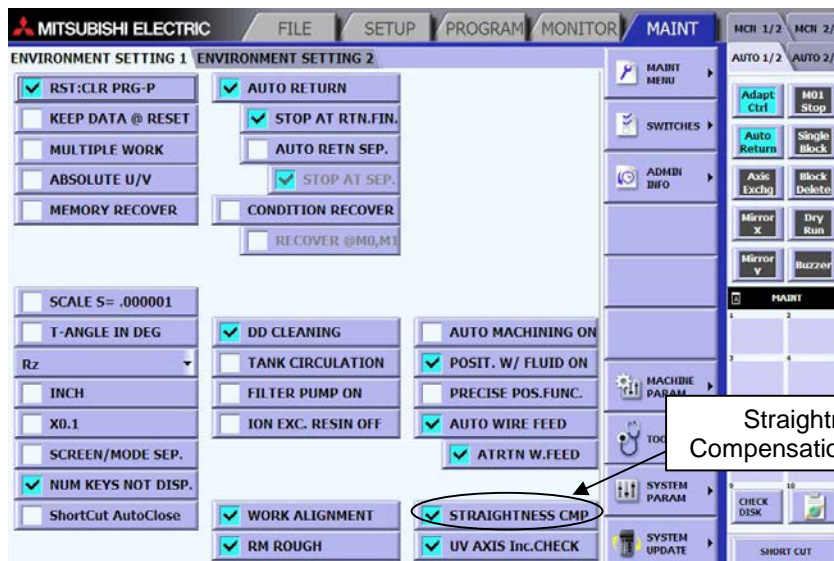
The straightness compensation function automatically carries out a small amount of taper machining using simple settings.

\* **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

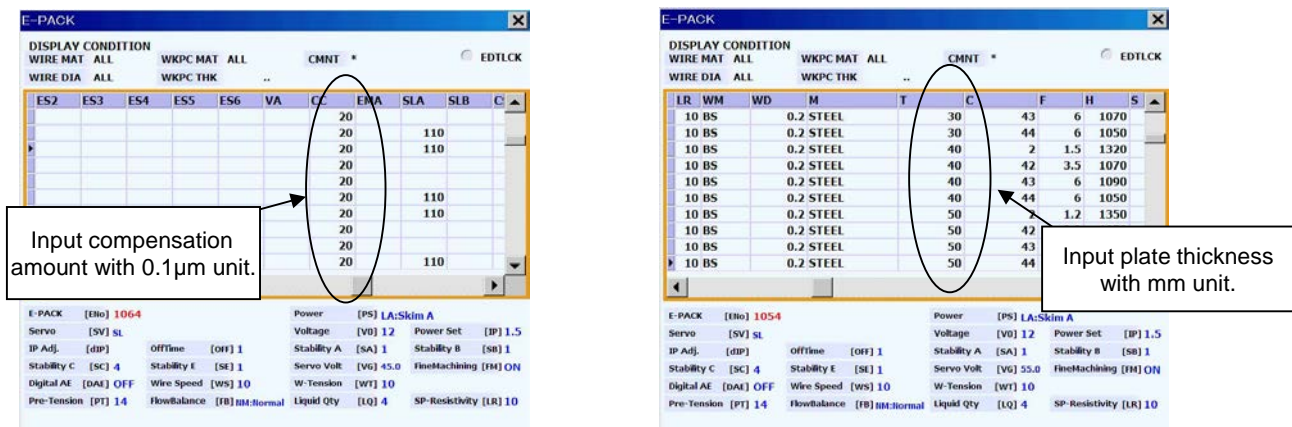
The following settings must be made to correctly use the straightness compensation function.

- 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

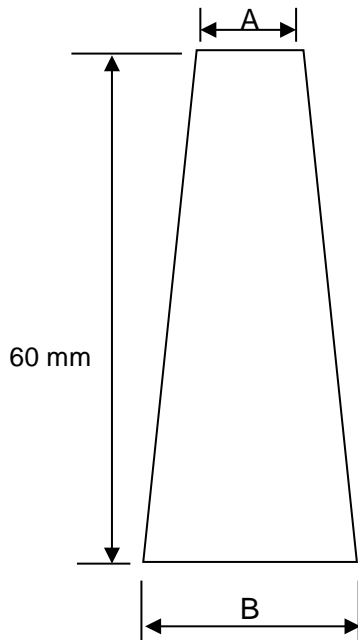
Infometer "T" : Input the workpiece thickness.

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)

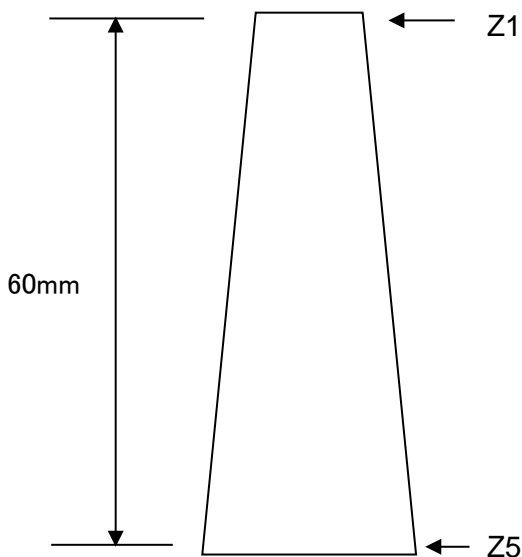
A=9.998mm

B=10.000mm

- 1) ...  $10.000 - 9.998 = 0.002$  mm  
The upper/lower dimension difference (both sides) is 2  $\mu$ m.
- 2) ...  $2 \div 2 = 1$   
The upper/lower dimension difference (one-side) is 1  $\mu$ 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**

**MV2400S****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



**MV2400S****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

**MV2400S****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

**MV2400S****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	

# MV2400S 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 (58.0 ~ 62.0)	50.0 (47.0 ~ 53.0)	60.0 (58.0 ~ 62.0)	150.0 (148.0 ~ 152.0)	115.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	46.0 (43.0 ~ 49.0)	65.0 (63.0 ~ 67.0)	155.0 (153.0 ~ 157.0)	110.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	42.0 (39.0 ~ 45.0)	65.0 (63.0 ~ 67.0)	120.0 (118.0 ~ 122.0)	75.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	46.0 (43.0 ~ 49.0)	68.0 (66.0 ~ 70.0)	116.0 (114.0 ~ 118.0)	70.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	50.0 (47.0 ~ 53.0)	70.0 (68.0 ~ 72.0)	112.0 (110.0 ~ 114.0)	65.0 (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.)



# MV2400S 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 (48.0 ~ 52.0)	44.0 (41.0 ~ 47.0)	68.0 (66.0 ~ 70.0)	98.0 (96.0 ~ 100.0)	55.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	38.0 (35.0 ~ 41.0)	60.0 (58.0 ~ 62.0)	85.0 (83.0 ~ 87.0)	45.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	55.0 (53.0 ~ 57.0)	65.0 (63.0 ~ 67.0)	40.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	42.0 (39.0 ~ 45.0)	47.0 (45.0 ~ 49.0)	65.0 (63.0 ~ 67.0)	40.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	44.0 (41.0 ~ 47.0)	42.0 (40.0 ~ 44.0)	60.0 (58.0 ~ 62.0)	35.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	46.0 (43.0 ~ 49.0)	37.0 (35.0 ~ 39.0)	50.0 (48.0 ~ 52.0)	30.0 (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.)

**MV2400S****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

**MV2400S****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



**MV2400S****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

# MV2400S

## 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	

# MV2400S 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 (58.0 ~ 62.0)	50.0 (47.0 ~ 53.0)	65.0 (63.0 ~ 67.0)	150.0 (148.0 ~ 152.0)	115.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	46.0 (43.0 ~ 49.0)	70.0 (68.0 ~ 72.0)	155.0 (153.0 ~ 157.0)	110.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	42.0 (39.0 ~ 45.0)	70.0 (68.0 ~ 72.0)	120.0 (118.0 ~ 122.0)	75.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	46.0 (43.0 ~ 49.0)	73.0 (71.0 ~ 75.0)	116.0 (114.0 ~ 118.0)	70.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	50.0 (47.0 ~ 53.0)	75.0 (73.0 ~ 77.0)	102.0 (100.0 ~ 104.0)	65.0 (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	11	11				
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.)

# MV2400S 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 (48.0 ~ 52.0)	44.0 (41.0 ~ 47.0)	65.0 (63.0 ~ 67.0)	88.0 (86.0 ~ 90.0)	55.0 (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	11	11				
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.)



# MV2400S 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 (48.0 ~ 52.0)	38.0 (35.0 ~ 41.0)	55.0 (53.0 ~ 57.0)	75.0 (73.0 ~ 77.0)	45.0 (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	11	11				
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.)

# MV2400S 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 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	48.0 (46.0 ~ 50.0)	70.0 (68.0 ~ 72.0)	45.0 (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	11	11				
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.)

# MV2400S 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 (48.0 ~ 52.0)	42.0 (39.0 ~ 45.0)	42.0 (40.0 ~ 44.0)	65.0 (63.0 ~ 67.0)	45.0 (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	11	11				
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.)

# MV2400S 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 (48.0 ~ 52.0)	44.0 (41.0 ~ 47.0)	42.0 (40.0 ~ 44.0)	60.0 (58.0 ~ 62.0)	40.0 (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	11	11				
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.)

# MV2400S 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 (48.0 ~ 52.0)	46.0 (43.0 ~ 49.0)	42.0 (40.0 ~ 44.0)	55.0 (53.0 ~ 57.0)	35.0 (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	11	11				
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.)

**MV2400S****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

**MV2400S****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

**MV2400S**

**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	



# MV2400S 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 (58.0 ~ 62.0)	68.0 (65.0 ~ 71.0)	83.0 (81.0 ~ 85.0)	105.0 (103.0 ~ 107.0)	95.0 (93.0 ~ 97.0)	84.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	50.0 (47.0 ~ 53.0)	60.0 (58.0 ~ 62.0)	95.0 (93.0 ~ 97.0)	80.0 (78.0 ~ 82.0)	67.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	40.0 (37.0 ~ 43.0)	57.0 (55.0 ~ 59.0)	85.0 (83.0 ~ 87.0)	55.0 (53.0 ~ 57.0)	45.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	43.0 (40.0 ~ 46.0)	59.0 (57.0 ~ 61.0)	50.0 (48.0 ~ 52.0)	70.0 (68.0 ~ 72.0)	50.0 (48.0 ~ 52.0)	43.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	45.0 (42.0 ~ 48.0)	62.0 (60.0 ~ 64.0)	50.0 (48.0 ~ 52.0)	70.0 (68.0 ~ 72.0)	50.0 (48.0 ~ 52.0)	40.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	45.0 (42.0 ~ 48.0)	56.0 (54.0 ~ 58.0)	50.0 (48.0 ~ 52.0)	70.0 (68.0 ~ 72.0)	50.0 (48.0 ~ 52.0)	38.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	45.0 (42.0 ~ 48.0)	50.0 (48.0 ~ 52.0)	50.0 (48.0 ~ 52.0)	70.0 (68.0 ~ 72.0)	50.0 (48.0 ~ 52.0)	35.0 (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.)

**MV2400S****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	214.0	217.0				0.0
2	14002	RH	7.0	-	107.0	128.0	131.0	134.0				83.0
3	14003	LC	7.5	-	-	106.0	109.0	112.0				22.0
4	14004	LC	7.5	-	-	-	106.0	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	200.0	203.0				0.0
2	14012	RH	6.5	-	106.0	120.0	122.0	125.0				78.0
3	14013	LC	7.5	-	-	105.0	107.0	110.0				15.0
4	14014	LC	7.0	-	-	-	105.0	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	191.0	194.0				0.0
2	14022	RH	4.0	-	104.0	120.0	123.0	126.0				68.0
3	14023	LC	7.0	-	-	103.0	106.0	109.0				17.0
4	14024	LC	7.0	-	-	-	103.0	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



**MV2400S****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	200.0	203.0	205.0			0.0
2	14032	RH	3.3	-	105.0	122.0	136.0	139.0	141.0			64.0
3	14033	RH	2.8	-	-	104.0	118.0	121.0	123.0			18.0
4	14034	LC	6.5	-	-	-	104.0	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	194.0	197.0	198.0			0.0
2	14042	RH	2.6	-	106.0	123.0	134.0	137.0	138.0			60.0
3	14043	RH	2.8	-	-	105.0	116.0	119.0	120.0			18.0
4	14044	LC	6.0	-	-	-	105.0	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	194.0	197.0	198.0			0.0
2	14052	RH	2.7	-	106.0	123.0	134.0	137.0	138.0			60.0
3	14053	RH	2.9	-	-	105.0	116.0	119.0	120.0			18.0
4	14054	LC	5.5	-	-	-	105.0	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

**MV2400S**

**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	195.0	197.0	197.0			0.0
2	14062	RH	2.8	-	106.0	123.0	135.0	137.0	137.0			60.0
3	14063	RH	3.0	-	-	105.0	117.0	119.0	119.0			18.0
4	14064	LC	5.0	-	-	-	105.0	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	

# MV2400S 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 (58.0 ~ 62.0)	68.0 (65.0 ~ 71.0)	83.0 (81.0 ~ 85.0)	105.0 (103.0 ~ 107.0)	95.0 (93.0 ~ 97.0)	84.0 (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	-----	214.0	131.0	109.0	106.0	-----	-----	-----	-----
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.)

# MV2400S 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 (58.0 ~ 62.0)	50.0 (47.0 ~ 53.0)	60.0 (58.0 ~ 62.0)	95.0 (93.0 ~ 97.0)	80.0 (78.0 ~ 82.0)	67.0 (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	-----	200.0	122.0	107.0	105.0	-----	-----	-----	-----
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.)

# MV2400S 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 (58.0 ~ 62.0)	40.0 (37.0 ~ 43.0)	57.0 (55.0 ~ 59.0)	85.0 (83.0 ~ 87.0)	55.0 (53.0 ~ 57.0)	45.0 (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	-----	191.0	123.0	106.0	103.0	-----	-----	-----	-----
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.)

# MV2400S 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 (48.0 ~ 52.0)	43.0 (40.0 ~ 46.0)	59.0 (57.0 ~ 61.0)	50.0 (48.0 ~ 52.0)	70.0 (68.0 ~ 72.0)	50.0 (48.0 ~ 52.0)	43.0 (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	-----	200.0	136.0	118.0	104.0	-----	-----	-----	-----
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.)

# MV2400S 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 (48.0 ~ 52.0)	45.0 (42.0 ~ 48.0)	62.0 (60.0 ~ 64.0)	50.0 (48.0 ~ 52.0)	70.0 (68.0 ~ 72.0)	50.0 (48.0 ~ 52.0)	40.0 (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	-----	194.0	134.0	116.0	105.0	-----	-----	-----	-----
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.)

# MV2400S 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 (48.0 ~ 52.0)	45.0 (42.0 ~ 48.0)	56.0 (54.0 ~ 58.0)	50.0 (48.0 ~ 52.0)	70.0 (68.0 ~ 72.0)	50.0 (48.0 ~ 52.0)	38.0 (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	-----	194.0	134.0	116.0	105.0	-----	-----	-----	-----
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.)



# MV2400S 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 (48.0 ~ 52.0)	45.0 (42.0 ~ 48.0)	50.0 (48.0 ~ 52.0)	50.0 (48.0 ~ 52.0)	70.0 (68.0 ~ 72.0)	50.0 (48.0 ~ 52.0)	35.0 (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	-----	195.0	135.0	117.0	105.0	-----	-----	-----	-----
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.)

**MV2400S****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

**MV2400S****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

**MV2400S****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

**MV2400S****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	

# MV2400S 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 (58.0 ~ 62.0)	56.0 (53.0 ~ 59.0)	74.0 (72.0 ~ 76.0)	110.0 (108.0 ~ 112.0)	68.0 (66.0 ~ 70.0)	84.0 (82.0 ~ 86.0)	80.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	46.0 (43.0 ~ 49.0)	64.0 (62.0 ~ 66.0)	88.0 (86.0 ~ 90.0)	72.0 (70.0 ~ 74.0)	72.0 (70.0 ~ 74.0)	62.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	42.0 (39.0 ~ 45.0)	60.0 (58.0 ~ 62.0)	80.0 (78.0 ~ 82.0)	72.0 (70.0 ~ 74.0)	64.0 (62.0 ~ 66.0)	50.0 (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.)



# MV2400S 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 (48.0 ~ 52.0)	41.0 (38.0 ~ 44.0)	60.0 (58.0 ~ 62.0)	70.0 (68.0 ~ 72.0)	55.0 (53.0 ~ 57.0)	64.0 (62.0 ~ 66.0)	55.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	60.0 (58.0 ~ 62.0)	68.0 (66.0 ~ 70.0)	32.0 (30.0 ~ 34.0)	54.0 (52.0 ~ 56.0)	46.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	39.0 (36.0 ~ 42.0)	58.0 (56.0 ~ 60.0)	61.0 (59.0 ~ 63.0)	27.0 (25.0 ~ 29.0)	45.0 (43.0 ~ 47.0)	40.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	38.0 (35.0 ~ 41.0)	56.0 (54.0 ~ 58.0)	59.0 (57.0 ~ 61.0)	25.0 (23.0 ~ 27.0)	40.0 (38.0 ~ 42.0)	35.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	39.0 (36.0 ~ 42.0)	55.0 (53.0 ~ 57.0)	57.0 (55.0 ~ 59.0)	25.0 (23.0 ~ 27.0)	35.0 (33.0 ~ 37.0)	32.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	54.0 (52.0 ~ 56.0)	55.0 (53.0 ~ 57.0)	25.0 (23.0 ~ 27.0)	30.0 (28.0 ~ 32.0)	30.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	43.0 (40.0 ~ 46.0)	52.0 (50.0 ~ 54.0)	51.0 (49.0 ~ 53.0)	22.0 (20.0 ~ 24.0)	30.0 (28.0 ~ 32.0)	27.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	46.0 (43.0 ~ 49.0)	50.0 (48.0 ~ 52.0)	47.0 (45.0 ~ 49.0)	20.0 (18.0 ~ 22.0)	30.0 (28.0 ~ 32.0)	25.0 (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.)



**MV2400S****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

**MV2400S****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

**MV2400S****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

**MV2400S****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	

# MV2400S 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 (58.0 ~ 62.0)	56.0 (53.0 ~ 59.0)	74.0 (72.0 ~ 76.0)	110.0 (108.0 ~ 112.0)	68.0 (66.0 ~ 70.0)	84.0 (82.0 ~ 86.0)	80.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	46.0 (43.0 ~ 49.0)	64.0 (62.0 ~ 66.0)	88.0 (86.0 ~ 90.0)	72.0 (70.0 ~ 74.0)	72.0 (70.0 ~ 74.0)	62.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	42.0 (39.0 ~ 45.0)	60.0 (58.0 ~ 62.0)	80.0 (78.0 ~ 82.0)	72.0 (70.0 ~ 74.0)	64.0 (62.0 ~ 66.0)	50.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	41.0 (38.0 ~ 44.0)	60.0 (58.0 ~ 62.0)	70.0 (68.0 ~ 72.0)	55.0 (53.0 ~ 57.0)	64.0 (62.0 ~ 66.0)	55.0 (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.)



# MV2400S 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 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	60.0 (58.0 ~ 62.0)	68.0 (66.0 ~ 70.0)	46.0 (44.0 ~ 48.0)	64.0 (62.0 ~ 66.0)	62.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	39.0 (36.0 ~ 42.0)	58.0 (56.0 ~ 60.0)	61.0 (59.0 ~ 63.0)	41.0 (39.0 ~ 43.0)	58.0 (56.0 ~ 60.0)	55.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	38.0 (35.0 ~ 41.0)	56.0 (54.0 ~ 58.0)	59.0 (57.0 ~ 61.0)	36.0 (34.0 ~ 38.0)	52.0 (50.0 ~ 54.0)	48.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	39.0 (36.0 ~ 42.0)	55.0 (53.0 ~ 57.0)	57.0 (55.0 ~ 59.0)	36.0 (34.0 ~ 38.0)	49.0 (47.0 ~ 51.0)	46.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	54.0 (52.0 ~ 56.0)	55.0 (53.0 ~ 57.0)	36.0 (34.0 ~ 38.0)	46.0 (44.0 ~ 48.0)	44.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	43.0 (40.0 ~ 46.0)	52.0 (50.0 ~ 54.0)	51.0 (49.0 ~ 53.0)	36.0 (34.0 ~ 38.0)	44.0 (42.0 ~ 46.0)	43.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	46.0 (43.0 ~ 49.0)	50.0 (48.0 ~ 52.0)	47.0 (45.0 ~ 49.0)	36.0 (34.0 ~ 38.0)	43.0 (41.0 ~ 45.0)	42.0 (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.)

**MV2400S****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	121.0	162.0	172.0	174.0					0.0
2	1142	MP	6.5	-	107.0	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	133.0	159.0	170.0	172.0					0.0
2	1152	MP	6.0	-	104.0	115.0	117.0					55.0
3	1153	LC	11.0	-	-	109.0	111.0					6.0
4	1154	LA	12.0	-	-	-	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	136.0	159.0	166.0	168.0					0.0
2	1162	MP	4.5	-	109.0	116.0	118.0					50.0
3	1163	LC	10.5	-	-	112.0	114.0					4.0
4	1164	LA	8.5	-	-	-	110.0					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



**MV2400S****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	136.0	160.0	168.0	169.0					0.0
2	1172	MP	4.0	-	108.0	116.0	117.0					52.0
3	1173	LC	9.5	-	-	110.0	111.0					6.0
4	1174	LA	8.2	-	-	-	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

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	165.0	172.0	173.0					0.0
2	1182	MP	3.4	-	110.0	117.0	118.0					55.0
3	1183	LC	9.0	-	-	107.0	108.0					10.0
4	1184	LA	8.0	-	-	-	106.0					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	1.2	135.0	169.0	177.0	179.0					0.0
2	1192	MP	3.5	-	113.0	121.0	123.0					56.0
3	1193	LC	7.0	-	-	111.0	113.0					10.0
4	1194	LA	5.0	-	-	-	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

**MV2400S****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	174.0	182.0	184.0					0.0
2	1202	MP	3.6	-	116.0	124.0	126.0					58.0
3	1203	LC	6.0	-	-	114.0	116.0					10.0
4	1204	LA	4.5	-	-	-	111.0					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	172.0	183.0	183.0					0.0
2	1212	MP	2.9	-	110.0	121.0	121.0					62.0
3	1213	LC	5.0	-	-	112.0	112.0					9.0
4	1214	LA	4.0	-	-	-	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	133.0	172.0	184.0	186.0					0.0
2	1222	MP	2.8	-	107.0	119.0	121.0					65.0
3	1223	LC	4.2	-	-	110.0	112.0					9.0
4	1224	LA	4.0	-	-	-	109.0					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

**MV2400S****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	137.0	176.0	187.0	187.0					0.0
2	1232	MP	2.5	-	109.0	120.0	120.0					67.0
3	1233	LC	4.2	-	-	112.0	112.0					8.0
4	1234	LA	4.0	-	-	-	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 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	140.0	179.0	192.0	190.0					0.0
2	1242	MP	2.2	-	109.0	122.0	120.0					70.0
3	1243	LC	4.2	-	-	114.0	112.0					8.0
4	1244	LA	4.0	-	-	-	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 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	

# MV2400S 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	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 (58.0 ~ 62.0)	52.0 (49.0 ~ 55.0)	84.0 (82.0 ~ 86.0)	140.0 (138.0 ~ 142.0)	150.0 (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	-----	121.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	162.0	107.0	-----	-----	-----	-----	-----	-----
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		7.7 ~ 8.7	14.4 ~ 17.7	9.2 ~ 11.2	12.9 ~ 15.7			
Average Voltage Gap	V		49 ~ 63	99 ~ 113	157 ~ 170	150 ~ 165			
Avg. Linear Feedrate	ALF		492.0	325.6	212.5	170.3			
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.)

# MV2400S 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	10	16	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	4	1	1	1				
Voltage Gap	VG	60.0 (58.0 ~ 62.0)	49.0 (46.0 ~ 52.0)	80.0 (78.0 ~ 82.0)	135.0 (133.0 ~ 137.0)	135.0 (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	11.0	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	-----	133.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	159.0	104.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	170.0	115.0	109.0	-----	-----	-----	-----	-----
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		5.1 ~ 5.6	13.3 ~ 16.2	9.8 ~ 10.9	10.8 ~ 12.0			
Average Voltage Gap	V		37 ~ 54	89 ~ 108	143 ~ 157	125 ~ 145			
Avg. Linear Feedrate	ALF		321.0	235.6	170.8	136.7			
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.)

# MV2400S 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	11	16	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	4	1	1	1				
Voltage Gap	VG	60.0 (58.0 ~ 62.0)	42.0 (39.0 ~ 45.0)	79.0 (77.0 ~ 81.0)	125.0 (123.0 ~ 127.0)	105.0 (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	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	14	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	-----	136.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	159.0	109.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	166.0	116.0	112.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	168.0	118.0	114.0	110.0	-----	-----	-----	-----
Rough & 4 Skims	-----					-----	-----	-----	-----
Rough & 5 Skims	-----						-----	-----	-----
Rough & 6 Skims	-----							-----	-----
Rough & 7 Skims	-----								-----
Stepping Increment	-----	-----	50.0	4.0	4.0				

RESULTS									
Feedrate Cutting	FC		2.7 ~ 3.2	10.0 ~ 11.2	9.3 ~ 10.3	8.0 ~ 8.8			
Average Voltage Gap	V		43 ~ 60	84 ~ 98	153 ~ 165	119 ~ 133			
Avg. Linear Feedrate	ALF		177.0	138.5	112.1	91.7			
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.)

# MV2400S 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	10	16	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	4	1	1	1				
Voltage Gap	VG	50.0 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	71.0 (69.0 ~ 73.0)	110.0 (108.0 ~ 112.0)	80.0 (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	14	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	9.5	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	-----	136.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	160.0	108.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	168.0	116.0	110.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	169.0	117.0	111.0	108.0	-----	-----	-----	-----
Rough & 4 Skims	-----					-----	-----	-----	-----
Rough & 5 Skims	-----						-----	-----	-----
Rough & 6 Skims	-----							-----	-----
Rough & 7 Skims	-----								-----
Stepping Increment	-----	-----	52.0	6.0	3.0				

RESULTS									
Feedrate Cutting	FC		2.0 ~ 2.5	7.0 ~ 10.0	9.0 ~ 10.0	7.7 ~ 8.6			
Average Voltage Gap	V		35 ~ 55	80 ~ 92	123 ~ 145	97 ~ 115			
Avg. Linear Feedrate	ALF		135.0	106.7	89.9	75.9			
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.)

# MV2400S 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	8	15	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	4	1	1	1				
Voltage Gap	VG	50.0 (48.0 ~ 52.0)	36.0 (33.0 ~ 39.0)	80.0 (78.0 ~ 82.0)	90.0 (88.0 ~ 92.0)	55.0 (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	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	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	-----	165.0	110.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	172.0	117.0	107.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	173.0	118.0	108.0	106.0	-----	-----	-----	-----
Rough & 4 Skims	-----					-----	-----	-----	-----
Rough & 5 Skims	-----						-----	-----	-----
Rough & 6 Skims	-----							-----	-----
Rough & 7 Skims	-----								-----
Stepping Increment	-----	-----	55.0	10.0	2.0				

RESULTS									
Feedrate Cutting	FC		1.7 ~ 2.4	5.0 ~ 6.1	8.5 ~ 9.5	7.5 ~ 8.5			
Average Voltage Gap	V		30 ~ 48	74 ~ 88	112 ~ 125	80 ~ 93			
Avg. Linear Feedrate	ALF		123.0	89.8	77.0	66.4			
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.)



# MV2400S 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	7	16	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	4	1	1	1				
Voltage Gap	VG	50.0 (48.0 ~ 52.0)	35.0 (32.0 ~ 38.0)	75.0 (73.0 ~ 77.0)	85.0 (83.0 ~ 87.0)	60.0 (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	14	6	4	4				
Liquid Resistivity	LR	10	10	10	10	10				
Straightness cmp.	CC	0	0	40	30	30				
Feedrate Address	FA	0.7	1.2	3.5	7.0	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	-----	169.0	113.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	177.0	121.0	111.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	179.0	123.0	113.0	109.0	-----	-----	-----	-----
Rough & 4 Skims	-----					-----	-----	-----	-----
Rough & 5 Skims	-----						-----	-----	-----
Rough & 6 Skims	-----							-----	-----
Rough & 7 Skims	-----								-----
Stepping Increment	-----	-----	56.0	10.0	4.0				

RESULTS									
Feedrate Cutting	FC		1.3 ~ 2.0	3.5 ~ 4.3	6.5 ~ 7.5	4.4 ~ 4.8			
Average Voltage Gap	V		26 ~ 44	69 ~ 83	100 ~ 115	70 ~ 80			
Avg. Linear Feedrate	ALF		99.0	69.6	59.7	49.1			
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.)

# MV2400S 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	7	16	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	4	1	1	1				
Voltage Gap	VG	50.0 (48.0 ~ 52.0)	32.0 (29.0 ~ 35.0)	72.0 (70.0 ~ 74.0)	80.0 (78.0 ~ 82.0)	65.0 (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	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	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	-----	174.0	116.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	182.0	124.0	114.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	184.0	126.0	116.0	111.0	-----	-----	-----	-----
Rough & 4 Skims	-----					-----	-----	-----	-----
Rough & 5 Skims	-----						-----	-----	-----
Rough & 6 Skims	-----							-----	-----
Rough & 7 Skims	-----								-----
Stepping Increment	-----	-----	58.0	10.0	5.0				

RESULTS									
Feedrate Cutting	FC		1.1 ~ 1.6	3.2 ~ 4.0	4.8 ~ 5.3	3.6 ~ 4.0			
Average Voltage Gap	V		20 ~ 37	64 ~ 78	95 ~ 108	65 ~ 77			
Avg. Linear Feedrate	ALF		81.0	58.9	49.3	40.5			
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.)

# MV2400S 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 (48.0 ~ 52.0)	34.0 (31.0 ~ 37.0)	52.0 (50.0 ~ 54.0)	72.0 (70.0 ~ 74.0)	55.0 (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	14	6	4	4				
Liquid Resistivity	LR	10	10	10	10	10				
Straightness cmp.	CC	0	0	50	40	30				
Feedrate Address	FA	0.6	0.8	2.9	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	-----	134.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	172.0	110.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	183.0	121.0	112.0	-----	-----	-----	-----	-----
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 ~ 1.4	3.0 ~ 3.6	4.2 ~ 4.7	3.6 ~ 4.0			
Average Voltage Gap	V		24 ~ 40	52 ~ 67	85 ~ 90	55 ~ 67			
Avg. Linear Feedrate	ALF		72.0	52.8	44.1	36.9			
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.)

# MV2400S 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 (48.0 ~ 52.0)	35.0 (32.0 ~ 38.0)	50.0 (48.0 ~ 52.0)	68.0 (66.0 ~ 70.0)	50.0 (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	14	6	4	4				
Liquid Resistivity	LR	10	10	10	10	10				
Straightness cmp.	CC	0	0	50	40	30				
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	-----	133.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	172.0	107.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	184.0	119.0	110.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	186.0	121.0	112.0	109.0	-----	-----	-----	-----
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 ~ 1.4	2.7 ~ 3.2	3.6 ~ 4.0	3.6 ~ 4.0			
Average Voltage Gap	V		28 ~ 46	42 ~ 57	73 ~ 88	50 ~ 63			
Avg. Linear Feedrate	ALF		63.0	46.5	38.6	33.0			
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.)

# MV2400S 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	6	16	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	4	1	1	1				
Voltage Gap	VG	50.0 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	46.0 (44.0 ~ 48.0)	64.0 (62.0 ~ 66.0)	42.0 (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	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	14	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	-----	137.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	176.0	109.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	187.0	120.0	112.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	187.0	120.0	112.0	108.0	-----	-----	-----	-----
Rough & 4 Skims	-----					-----	-----	-----	-----
Rough & 5 Skims	-----						-----	-----	-----
Rough & 6 Skims	-----							-----	-----
Rough & 7 Skims	-----								-----
Stepping Increment	-----	-----	67.0	8.0	4.0				

RESULTS									
Feedrate Cutting	FC		0.6 ~ 0.9	2.7 ~ 3.2	3.7 ~ 4.1	3.6 ~ 4.0			
Average Voltage Gap	V		30 ~ 48	40 ~ 55	70 ~ 84	48 ~ 60			
Avg. Linear Feedrate	ALF		45.0	35.9	31.1	27.4			
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.)

# MV2400S 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	6	16	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	5	1	1	1				
Voltage Gap	VG	50.0 (48.0 ~ 52.0)	42.0 (39.0 ~ 45.0)	42.0 (40.0 ~ 44.0)	60.0 (58.0 ~ 62.0)	35.0 (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	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	14	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	-----	140.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	179.0	109.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	192.0	122.0	114.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	190.0	120.0	112.0	107.0	-----	-----	-----	-----
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 ~ 0.7	2.7 ~ 3.3	3.8 ~ 4.2	3.6 ~ 4.0			
Average Voltage Gap	V		36 ~ 51	37 ~ 52	68 ~ 82	39 ~ 53			
Avg. Linear Feedrate	ALF		36.0	30.0	26.7	23.9			
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.)

**MV2400S****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

**MV2400S****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



**MV2400S****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

**MV2400S****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	

# MV2400S 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 (58.0 ~ 62.0)	54.0 (51.0 ~ 57.0)	85.0 (83.0 ~ 87.0)	70.0 (68.0 ~ 72.0)	80.0 (78.0 ~ 82.0)	65.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	60.0 (57.0 ~ 63.0)	98.0 (96.0 ~ 100.0)	85.0 (83.0 ~ 87.0)	69.0 (67.0 ~ 71.0)	50.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	40.0 (37.0 ~ 43.0)	90.0 (88.0 ~ 92.0)	90.0 (88.0 ~ 92.0)	70.0 (68.0 ~ 72.0)	50.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	37.0 (34.0 ~ 40.0)	85.0 (83.0 ~ 87.0)	45.0 (43.0 ~ 47.0)	58.0 (56.0 ~ 60.0)	40.0 (38.0 ~ 42.0)	32.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	33.0 (30.0 ~ 36.0)	80.0 (78.0 ~ 82.0)	45.0 (43.0 ~ 47.0)	58.0 (56.0 ~ 60.0)	40.0 (38.0 ~ 42.0)	32.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	34.0 (31.0 ~ 37.0)	76.0 (74.0 ~ 78.0)	45.0 (43.0 ~ 47.0)	56.0 (54.0 ~ 58.0)	45.0 (43.0 ~ 47.0)	31.0 (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.)



# MV2400S 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 (48.0 ~ 52.0)	35.0 (32.0 ~ 38.0)	73.0 (71.0 ~ 75.0)	45.0 (43.0 ~ 47.0)	55.0 (53.0 ~ 57.0)	50.0 (48.0 ~ 52.0)	30.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	35.0 (32.0 ~ 38.0)	73.0 (71.0 ~ 75.0)	42.0 (40.0 ~ 44.0)	51.0 (49.0 ~ 53.0)	45.0 (43.0 ~ 47.0)	30.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	35.0 (32.0 ~ 38.0)	73.0 (71.0 ~ 75.0)	40.0 (38.0 ~ 42.0)	48.0 (46.0 ~ 50.0)	45.0 (43.0 ~ 47.0)	30.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	37.0 (34.0 ~ 40.0)	70.0 (68.0 ~ 72.0)	38.0 (36.0 ~ 40.0)	47.0 (45.0 ~ 49.0)	42.0 (40.0 ~ 44.0)	30.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	68.0 (66.0 ~ 70.0)	37.0 (35.0 ~ 39.0)	47.0 (45.0 ~ 49.0)	39.0 (37.0 ~ 41.0)	30.0 (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.)

**MV2400S****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

**MV2400S****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

# MV2400S 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 (58.0 ~ 62.0)	45.0 (42.0 ~ 48.0)	55.0 (53.0 ~ 57.0)	115.0 (113.0 ~ 117.0)	100.0 (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.)



# MV2400S 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 (58.0 ~ 62.0)	45.0 (42.0 ~ 48.0)	60.0 (58.0 ~ 62.0)	100.0 (98.0 ~ 102.0)	60.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	50.0 (47.0 ~ 53.0)	60.0 (58.0 ~ 62.0)	95.0 (93.0 ~ 97.0)	55.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	50.0 (47.0 ~ 53.0)	60.0 (58.0 ~ 62.0)	85.0 (83.0 ~ 87.0)	40.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	35.0 (32.0 ~ 38.0)	57.0 (55.0 ~ 59.0)	80.0 (78.0 ~ 82.0)	40.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	35.0 (32.0 ~ 38.0)	57.0 (55.0 ~ 59.0)	75.0 (73.0 ~ 77.0)	35.0 (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.)

**MV2400S****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

# MV2400S 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 (58.0 ~ 62.0)	45.0 (42.0 ~ 48.0)	65.0 (63.0 ~ 67.0)	115.0 (113.0 ~ 117.0)	100.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	45.0 (42.0 ~ 48.0)	65.0 (63.0 ~ 67.0)	100.0 (98.0 ~ 102.0)	60.0 (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.)



# MV2400S 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 (48.0 ~ 52.0)	50.0 (47.0 ~ 53.0)	70.0 (68.0 ~ 72.0)	95.0 (93.0 ~ 97.0)	60.0 (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.)

**MV2400S****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

**MV2400S****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

**MV2400S****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

**MV2400S****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	

# MV2400S 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 (58.0 ~ 62.0)	85.0 (82.0 ~ 88.0)	85.0 (83.0 ~ 87.0)	110.0 (108.0 ~ 112.0)	100.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	85.0 (82.0 ~ 88.0)	95.0 (93.0 ~ 97.0)	115.0 (113.0 ~ 117.0)	90.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	80.0 (77.0 ~ 83.0)	80.0 (78.0 ~ 82.0)	100.0 (98.0 ~ 102.0)	110.0 (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.)



# MV2400S 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 (48.0 ~ 52.0)	78.0 (75.0 ~ 81.0)	87.0 (85.0 ~ 89.0)	90.0 (88.0 ~ 92.0)	87.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	75.0 (72.0 ~ 78.0)	95.0 (93.0 ~ 97.0)	80.0 (78.0 ~ 82.0)	65.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	65.0 (62.0 ~ 68.0)	92.0 (90.0 ~ 94.0)	82.0 (80.0 ~ 84.0)	72.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	60.0 (57.0 ~ 63.0)	90.0 (88.0 ~ 92.0)	84.0 (82.0 ~ 86.0)	70.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	58.0 (55.0 ~ 61.0)	87.0 (85.0 ~ 89.0)	72.0 (70.0 ~ 74.0)	60.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	55.0 (52.0 ~ 58.0)	85.0 (83.0 ~ 87.0)	60.0 (58.0 ~ 62.0)	50.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	62.0 (59.0 ~ 65.0)	82.0 (80.0 ~ 84.0)	54.0 (52.0 ~ 56.0)	42.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	68.0 (65.0 ~ 71.0)	80.0 (78.0 ~ 82.0)	48.0 (46.0 ~ 50.0)	35.0 (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.)



**MV2400S****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

**MV2400S****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

**MV2400S****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

# MV2400S

## 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	

# MV2400S 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 (58.0 ~ 62.0)	70.0 (67.0 ~ 73.0)	125.0 (123.0 ~ 127.0)	100.0 (98.0 ~ 102.0)	95.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	56.0 (53.0 ~ 59.0)	120.0 (118.0 ~ 122.0)	90.0 (88.0 ~ 92.0)	90.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	56.0 (53.0 ~ 59.0)	116.0 (114.0 ~ 118.0)	80.0 (78.0 ~ 82.0)	75.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	56.0 (53.0 ~ 59.0)	113.0 (111.0 ~ 115.0)	72.0 (70.0 ~ 74.0)	70.0 (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.)



# MV2400S 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 (48.0 ~ 52.0)	56.0 (53.0 ~ 59.0)	110.0 (108.0 ~ 112.0)	65.0 (63.0 ~ 67.0)	65.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	55.0 (52.0 ~ 58.0)	108.0 (106.0 ~ 110.0)	60.0 (58.0 ~ 62.0)	62.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	54.0 (51.0 ~ 57.0)	106.0 (104.0 ~ 108.0)	55.0 (53.0 ~ 57.0)	60.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	62.0 (59.0 ~ 65.0)	107.0 (105.0 ~ 109.0)	52.0 (50.0 ~ 54.0)	60.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	70.0 (67.0 ~ 73.0)	108.0 (106.0 ~ 110.0)	50.0 (48.0 ~ 52.0)	60.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	70.0 (67.0 ~ 73.0)	107.0 (105.0 ~ 109.0)	50.0 (48.0 ~ 52.0)	55.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	70.0 (67.0 ~ 73.0)	106.0 (104.0 ~ 108.0)	50.0 (48.0 ~ 52.0)	50.0 (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.)

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.20BS	Graphite	Class1

Thickness 10 mm

No.	Cutting process			Offset										Step 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 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 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



# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.20BS	Graphite	Class1

Thickness 40 mm

No.	Cutting process			Offset										Step 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 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 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

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.20BS	Graphite	Class1

Thickness 70 mm

No.	Cutting process			Offset										Step 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 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 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

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.20BS	Graphite	Class1

Thickness 100 mm

No.	Cutting process			Offset										Step 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 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 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	

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.20BS	Graphite	Class2

Thickness 10 mm

No.	Cutting process			Offset										Step 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 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 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

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.20BS	Graphite	Class2

Thickness 40 mm

No.	Cutting process			Offset										Step 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 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 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

**MV2400S****Digest**

Wire Dia. and Type	Material Type	Class
0.20BS	Graphite	Class2

Thickness 70 mm

No.	Cutting process			Offset										Step 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 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 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

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.20BS	Graphite	Class2

Thickness 100 mm

No.	Cutting process			Offset										Step 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 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 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	

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.20BS	Graphite	Class3

Thickness 10 mm

No.	Cutting process			Offset										Step 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 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 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



# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.20BS	Graphite	Class3

Thickness 40 mm

No.	Cutting process			Offset										Step 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 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 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

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.20BS	Graphite	Class3

Thickness 70 mm

No.	Cutting process			Offset										Step 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 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 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

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.20BS	Graphite	Class3

Thickness 100 mm

No.	Cutting process			Offset										Step 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 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 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	

## MV2400S 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 (58 ~ 62)	60.0 (57 ~ 63)		80.0 (77 ~ 83)		55.0 (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.)

## MV2400S 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 (58 ~ 62)	50.0 (47 ~ 53)		60.0 (57 ~ 63)		55.0 (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.)

## MV2400S 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 (48 ~ 52)	55.0 (52 ~ 58)		55.0 (52 ~ 58)		55.0 (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.)

## MV2400S 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 (48 ~ 52)	60.0 (57 ~ 63)		50.0 (47 ~ 53)		60.0 (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.)

## MV2400S 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 (48 ~ 52)	50.0 (47 ~ 53)		50.0 (47 ~ 53)		55.0 (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.)



## MV2400S 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 (48 ~ 52)	40.0 (37 ~ 43)		50.0 (47 ~ 53)		50.0 (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.)

## MV2400S 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 (48 ~ 52)	45.0 (42 ~ 48)		50.0 (47 ~ 53)		50.0 (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.)

## MV2400S 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 (48 ~ 52)	50.0 (47 ~ 53)		50.0 (47 ~ 53)		50.0 (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.)

## MV2400S 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 (48 ~ 52)	50.0 (47 ~ 53)		50.0 (47 ~ 53)		50.0 (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.)

## MV2400S 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 (48 ~ 52)	50.0 (47 ~ 53)		50.0 (47 ~ 53)		50.0 (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**

**MV2400S****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

**MV2400S****Digest**

Wire Dia. and Type	Material Type	Class
φ0.25BS	STEEL	STD P1

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



**MV2400S****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

**MV2400S****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	

# MV2400S 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 (58.0 ~ 62.0)	60.0 (57.0 ~ 63.0)	80.0 (78.0 ~ 82.0)	140.0 (138.0 ~ 142.0)	100.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	52.0 (49.0 ~ 55.0)	76.0 (74.0 ~ 78.0)	120.0 (118.0 ~ 122.0)	80.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	46.0 (43.0 ~ 49.0)	71.0 (69.0 ~ 73.0)	110.0 (108.0 ~ 112.0)	70.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	45.0 (42.0 ~ 48.0)	65.0 (63.0 ~ 67.0)	100.0 (98.0 ~ 102.0)	65.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	44.0 (41.0 ~ 47.0)	59.0 (57.0 ~ 61.0)	90.0 (88.0 ~ 92.0)	60.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	43.0 (40.0 ~ 46.0)	53.0 (51.0 ~ 55.0)	80.0 (78.0 ~ 82.0)	55.0 (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.)



# MV2400S 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 (48.0 ~ 52.0)	42.0 (39.0 ~ 45.0)	47.0 (45.0 ~ 49.0)	70.0 (68.0 ~ 72.0)	50.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	43.0 (40.0 ~ 46.0)	42.0 (40.0 ~ 44.0)	65.0 (63.0 ~ 67.0)	45.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	44.0 (41.0 ~ 47.0)	38.0 (36.0 ~ 40.0)	60.0 (58.0 ~ 62.0)	40.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	45.0 (42.0 ~ 48.0)	36.0 (34.0 ~ 38.0)	55.0 (53.0 ~ 57.0)	35.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	46.0 (43.0 ~ 49.0)	35.0 (33.0 ~ 37.0)	50.0 (48.0 ~ 52.0)	30.0 (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.)

**MV2400S****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

**MV2400S****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

**MV2400S****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



**MV2400S****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	

# MV2400S 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 (58.0 ~ 62.0)	60.0 (57.0 ~ 63.0)	75.0 (73.0 ~ 77.0)	135.0 (133.0 ~ 137.0)	95.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	52.0 (49.0 ~ 55.0)	71.0 (69.0 ~ 73.0)	115.0 (113.0 ~ 117.0)	75.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	46.0 (43.0 ~ 49.0)	66.0 (64.0 ~ 68.0)	105.0 (103.0 ~ 107.0)	65.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	45.0 (42.0 ~ 48.0)	60.0 (58.0 ~ 62.0)	95.0 (93.0 ~ 97.0)	60.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	44.0 (41.0 ~ 47.0)	54.0 (52.0 ~ 56.0)	85.0 (83.0 ~ 87.0)	55.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	43.0 (40.0 ~ 46.0)	47.0 (45.0 ~ 49.0)	75.0 (73.0 ~ 77.0)	50.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	42.0 (39.0 ~ 45.0)	42.0 (40.0 ~ 44.0)	65.0 (63.0 ~ 67.0)	45.0 (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.)



# MV2400S 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 (48.0 ~ 52.0)	43.0 (40.0 ~ 46.0)	37.0 (35.0 ~ 39.0)	60.0 (58.0 ~ 62.0)	42.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	44.0 (41.0 ~ 47.0)	33.0 (31.0 ~ 35.0)	55.0 (53.0 ~ 57.0)	40.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	45.0 (42.0 ~ 48.0)	31.0 (29.0 ~ 33.0)	50.0 (48.0 ~ 52.0)	35.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	46.0 (43.0 ~ 49.0)	30.0 (28.0 ~ 32.0)	45.0 (43.0 ~ 47.0)	30.0 (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.)

**MV2400S****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

**MV2400S****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

**MV2400S****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

**MV2400S****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



**MV2400S****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	

# MV2400S 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 (58.0 ~ 62.0)	68.0 (65.0 ~ 71.0)	90.0 (88.0 ~ 92.0)	90.0 (88.0 ~ 92.0)	80.0 (78.0 ~ 82.0)	100.0 (98.0 ~ 102.0)	90.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	50.0 (47.0 ~ 53.0)	100.0 (98.0 ~ 102.0)	90.0 (88.0 ~ 92.0)	90.0 (88.0 ~ 92.0)	85.0 (83.0 ~ 87.0)	80.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	50.0 (47.0 ~ 53.0)	78.0 (76.0 ~ 80.0)	64.0 (62.0 ~ 66.0)	90.0 (88.0 ~ 92.0)	75.0 (73.0 ~ 77.0)	65.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	50.0 (47.0 ~ 53.0)	78.0 (76.0 ~ 80.0)	62.0 (60.0 ~ 64.0)	88.0 (86.0 ~ 90.0)	65.0 (63.0 ~ 67.0)	60.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	50.0 (47.0 ~ 53.0)	78.0 (76.0 ~ 80.0)	60.0 (58.0 ~ 62.0)	85.0 (83.0 ~ 87.0)	54.0 (52.0 ~ 56.0)	55.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	50.0 (47.0 ~ 53.0)	73.0 (71.0 ~ 75.0)	57.0 (55.0 ~ 59.0)	79.0 (77.0 ~ 81.0)	51.0 (49.0 ~ 53.0)	50.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	50.0 (47.0 ~ 53.0)	68.0 (66.0 ~ 70.0)	54.0 (52.0 ~ 56.0)	72.0 (70.0 ~ 74.0)	48.0 (46.0 ~ 50.0)	45.0 (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.)



# MV2400S 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 (48.0 ~ 52.0)	50.0 (47.0 ~ 53.0)	63.0 (61.0 ~ 65.0)	51.0 (49.0 ~ 53.0)	73.0 (71.0 ~ 75.0)	49.0 (47.0 ~ 51.0)	44.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	50.0 (47.0 ~ 53.0)	58.0 (56.0 ~ 60.0)	48.0 (46.0 ~ 50.0)	74.0 (72.0 ~ 76.0)	50.0 (48.0 ~ 52.0)	42.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	50.0 (47.0 ~ 53.0)	59.0 (57.0 ~ 61.0)	47.0 (45.0 ~ 49.0)	75.0 (73.0 ~ 77.0)	53.0 (51.0 ~ 55.0)	38.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	50.0 (47.0 ~ 53.0)	60.0 (58.0 ~ 62.0)	45.0 (43.0 ~ 47.0)	76.0 (74.0 ~ 78.0)	56.0 (54.0 ~ 58.0)	34.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	51.0 (48.0 ~ 54.0)	57.0 (55.0 ~ 59.0)	49.0 (47.0 ~ 51.0)	71.0 (69.0 ~ 73.0)	49.0 (47.0 ~ 51.0)	37.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	52.0 (49.0 ~ 55.0)	54.0 (52.0 ~ 56.0)	52.0 (50.0 ~ 54.0)	66.0 (64.0 ~ 68.0)	42.0 (40.0 ~ 44.0)	34.0 (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.)

**MV2400S****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	242.0	256.0	260.0	262.0			0.0
2	2222	KH	9.0	-	129.0	176.0	190.0	194.0	196.0			66.0
3	2223	KL	7.0	-	-	130.0	144.0	148.0	150.0			46.0
4	2224	LC	14.0	-	-	-	130.0	134.0	136.0			14.0
5	2225	LC	12.0	-	-	-	-	132.0	134.0			2.0
6	2226	LC	12.0	-	-	-	-	-	132.0			2.0
7				-	-	-	-	-	-			
8				-	-	-	-	-	-	-		
Surface roughness			Rz	18.0	11.0	6.0	6.0	2.8	2.5			
			Ra	2.70	1.50	0.80	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	951	RH	2.0									
1	2231	RH	6.0	155.0	191.0	228.0	238.0	241.0	242.0			0.0
2	2232	KH	9.0	-	130.0	167.0	177.0	180.0	181.0			61.0
3	2233	KL	7.0	-	-	131.0	141.0	144.0	145.0			36.0
4	2234	LC	14.0	-	-	-	130.0	133.0	134.0			11.0
5	2235	LC	12.0	-	-	-	-	131.0	132.0			2.0
6	2236	LC	12.0	-	-	-	-	-	131.0			1.0
7				-	-	-	-	-	-			
8				-	-	-	-	-	-	-		
Surface roughness			Rz	18.0	11.0	6.0	6.0	2.8	2.5			
			Ra	2.70	1.50	0.80	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	951	RH	2.0									
1	2241	RH	3.7	153.0	194.0	219.0	233.0	235.0	237.0			0.0
2	2242	RH	9.0	-	129.0	154.0	168.0	170.0	172.0			65.0
3	2243	HL	6.5	-	-	129.0	143.0	145.0	147.0			25.0
4	2244	LC	7.0	-	-	-	133.0	135.0	137.0			10.0
5	2245	LC	7.0	-	-	-	-	132.0	134.0			3.0
6	2246	LC	6.0	-	-	-	-	-	132.0			2.0
7				-	-	-	-	-	-			
8				-	-	-	-	-	-	-		
Surface roughness			Rz	18.0	11.0	6.0	6.0	2.8	2.5			
			Ra	2.70	1.50	0.80	0.80	0.34	0.30			

Nozzle Gap	
Upper	0.20mm
Lower	0.20mm

**MV2400S****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	193.0	219.0	233.0	235.0	237.0			0.0
2	2252	RH	8.0	-	128.0	154.0	168.0	170.0	172.0			65.0
3	2253	HL	6.0	-	-	129.0	143.0	145.0	147.0			25.0
4	2254	LC	7.0	-	-	-	133.0	135.0	137.0			10.0
5	2255	LC	7.0	-	-	-	-	132.0	134.0			3.0
6	2256	LC	5.7	-	-	-	-	-	132.0			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	952	RH	1.0									
1	2261	RH	2.3	159.0	193.0	219.0	233.0	235.0	237.0			0.0
2	2262	RH	7.0	-	128.0	154.0	168.0	170.0	172.0			65.0
3	2263	HL	5.5	-	-	129.0	143.0	145.0	147.0			25.0
4	2264	LC	7.0	-	-	-	133.0	135.0	137.0			10.0
5	2265	LC	7.0	-	-	-	-	132.0	134.0			3.0
6	2266	LC	5.5	-	-	-	-	-	132.0			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	953	RH	0.7									
1	2271	RH	2.0	164.0	193.0	219.0	232.0	234.0	237.0			0.0
2	2272	RH	6.0	-	128.0	154.0	167.0	169.0	172.0			65.0
3	2273	HL	5.0	-	-	129.0	142.0	144.0	147.0			25.0
4	2274	LC	7.0	-	-	-	132.0	134.0	137.0			10.0
5	2275	LC	7.0	-	-	-	-	131.0	134.0			3.0
6	2276	LC	5.2	-	-	-	-	-	132.0			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



**MV2400S****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	193.0	219.0	232.0	234.0	236.0			0.0
2	2282	RH	5.0	-	128.0	154.0	167.0	169.0	171.0			65.0
3	2283	HL	4.5	-	-	129.0	142.0	144.0	146.0			25.0
4	2284	LC	7.0	-	-	-	132.0	134.0	136.0			10.0
5	2285	LC	7.0	-	-	-	-	131.0	133.0			3.0
6	2286	LC	5.0	-	-	-	-	-	131.0			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	954	RH	0.6									
1	2291	RH	1.5	169.0	194.0	222.0	235.0	237.0	239.0			0.0
2	2292	RH	4.9	-	127.0	155.0	168.0	170.0	172.0			67.0
3	2293	HL	4.0	-	-	130.0	143.0	145.0	147.0			25.0
4	2294	LC	7.0	-	-	-	133.0	135.0	137.0			10.0
5	2295	LC	7.0	-	-	-	-	132.0	134.0			3.0
6	2296	LC	5.0	-	-	-	-	-	132.0			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	954	RH	0.6									
1	2301	RH	1.3	169.0	197.0	225.0	238.0	241.0	242.0			0.0
2	2302	RH	4.8	-	127.0	155.0	168.0	171.0	172.0			70.0
3	2303	HL	3.5	-	-	130.0	143.0	146.0	147.0			25.0
4	2304	LC	7.0	-	-	-	133.0	136.0	137.0			10.0
5	2305	LC	7.0	-	-	-	-	133.0	134.0			3.0
6	2306	LC	5.0	-	-	-	-	-	132.0			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

**MV2400S****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	199.0	228.0	241.0	244.0	246.0			0.0
2	2312	RH	4.5	-	127.0	156.0	169.0	172.0	174.0			72.0
3	2313	HL	3.4	-	-	129.0	142.0	145.0	147.0			27.0
4	2314	LC	6.7	-	-	-	132.0	135.0	137.0			10.0
5	2315	LC	6.5	-	-	-	-	132.0	134.0			3.0
6	2316	LC	5.0	-	-	-	-	-	132.0			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	955	RH	0.5									
1	2321	RH	1.0	171.0	202.0	233.0	247.0	250.0	252.0			0.0
2	2322	RH	4.2	-	127.0	158.0	172.0	175.0	177.0			75.0
3	2323	HL	3.3	-	-	128.0	142.0	145.0	147.0			30.0
4	2324	LC	6.5	-	-	-	132.0	135.0	137.0			10.0
5	2325	LC	6.0	-	-	-	-	132.0	134.0			3.0
6	2326	LC	5.0	-	-	-	-	-	132.0			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 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	0.8	177.0	214.0	249.0	266.0	270.0	274.0			0.0
2	2332	RH	3.8	-	129.0	164.0	181.0	185.0	189.0			85.0
3	2333	RH	3.2	-	-	132.0	149.0	153.0	157.0			32.0
4	2334	LC	5.5	-	-	-	134.0	138.0	142.0			15.0
5	2335	LC	5.5	-	-	-	-	133.0	137.0			5.0
6	2336	LC	5.0	-	-	-	-	-	134.0			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

**MV2400S****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	0.6	183.0	216.0	251.0	268.0	274.0	278.0			0.0
2	2342	RH	3.5	-	131.0	166.0	183.0	189.0	193.0			85.0
3	2343	RH	3.0	-	-	134.0	151.0	157.0	161.0			32.0
4	2344	LC	5.0	-	-	-	134.0	140.0	144.0			17.0
5	2345	LC	5.0	-	-	-	-	134.0	138.0			6.0
6	2346	LC	5.0	-	-	-	-	-	135.0			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 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	2351	RH	0.4	169.0	214.0	244.0	260.0	267.0				0.0
2	2352	RH	3.5	-	129.0	159.0	175.0	182.0				85.0
3	2353	RH	3.0	-	-	134.0	150.0	157.0				25.0
4	2354	LC	5.0	-	-	-	133.0	140.0				17.0
5	2355	LC	4.0	-	-	-	-	130.0				10.0
6				-	-	-	-	-				
7				-	-	-	-	-	-			
8				-	-	-	-	-	-	-		
Surface roughness			Rz	18.0	15.0	13.0	8.0	6.0				
			Ra	2.70	2.50	1.80	0.90	0.80				

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	955	RH	0.5									
1	2361	RH	0.3	189.0	233.0	274.0						0.0
2	2362	RH	2.5	-	128.0	169.0						105.0
3	2363	RH	2.0	-	-	139.0						30.0
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

**MV2400S**

**Digest**

Wire Dia. and Type	Material Type	Class
φ0.25BS	STEEL	ACU

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	2371	RH	0.2	189.0	256.0	303.0						0.0
2	2372	RH	2.0	-	131.0	178.0						125.0
3	2373	RH	1.5	-	-	133.0						45.0
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 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	

# MV2400S 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	6	8	9		
Power Setting	IP	7.0	9.0	5.0	5.0	2.5	2.0	1.0		
IP adjust	ΔIP	11	11	10	8					
Off Time	OFF	6	3	1	1	8	2	2		
Stabilizer A	SA	3	6	2	2	2	1	1		
Stabilizer B	SB	8	11	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 (58.0 ~ 62.0)	50.0 (47.0 ~ 53.0)	90.0 (88.0 ~ 92.0)	85.0 (83.0 ~ 87.0)	80.0 (78.0 ~ 82.0)	100.0 (98.0 ~ 102.0)	90.0 (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	14.0	12.0	12.0		
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	-----	242.0	176.0	130.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	256.0	190.0	144.0	130.0	-----	-----	-----	-----
Rough & 4 Skims	-----	260.0	194.0	148.0	134.0	132.0	-----	-----	-----
Rough & 5 Skims	-----	262.0	196.0	150.0	136.0	134.0	132.0	-----	-----
Rough & 6 Skims	-----								-----
Rough & 7 Skims	-----								
Stepping Increment	-----	-----	66.0	46.0	14.0	2.0	2.0		

RESULTS									
Feedrate Cutting	FC		11.7 ~ 14.3	15.7 ~ 19.1	11.6 ~ 14.2	12.2 ~ 13.5	10.6 ~ 11.8	10.5 ~ 11.5	
Average Voltage Gap	V		38 ~ 60	99 ~ 112	82 ~ 92	87 ~ 104	115 ~ 133	98 ~ 116	
Avg. Linear Feedrate	ALF		780.0	446.4	283.1	207.1	158.3	127.7	
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	2.2 ~ 2.8	
	Ra		2.43 ~ 4.05	1.35 ~ 2.25	0.72 ~ 1.20	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.)

# MV2400S 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	9		
Power Setting	IP	7.0	9.0	5.0	5.0	2.0	2.0	1.0		
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	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 (58.0 ~ 62.0)	42.0 (39.0 ~ 45.0)	100.0 (98.0 ~ 102.0)	85.0 (83.0 ~ 87.0)	80.0 (78.0 ~ 82.0)	80.0 (78.0 ~ 82.0)	70.0 (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	14.0	12.0	12.0		
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	-----	228.0	167.0	131.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	238.0	177.0	141.0	130.0	-----	-----	-----	-----
Rough & 4 Skims	-----	241.0	180.0	144.0	133.0	131.0	-----	-----	-----
Rough & 5 Skims	-----	242.0	181.0	145.0	134.0	132.0	131.0	-----	-----
Rough & 6 Skims	-----								-----
Rough & 7 Skims	-----								
Stepping Increment	-----	-----	61.0	36.0	11.0	2.0	1.0		

RESULTS									
Feedrate Cutting	FC		8.9 ~ 10.9	15.0 ~ 18.3	12.0 ~ 14.6	12.2 ~ 13.5	10.5 ~ 11.7	10.5 ~ 11.7	
Average Voltage Gap	V		30 ~ 52	100 ~ 114	82 ~ 92	86 ~ 104	89 ~ 107	83 ~ 98	
Avg. Linear Feedrate	ALF		594.0	372.5	254.0	191.0	148.5	121.4	
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	2.2 ~ 2.8	
	Ra		2.43 ~ 4.05	1.35 ~ 2.25	0.72 ~ 1.20	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.)

# MV2400S 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	14		
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 (58.0 ~ 62.0)	42.0 (39.0 ~ 45.0)	52.0 (50.0 ~ 54.0)	45.0 (43.0 ~ 47.0)	105.0 (103.0 ~ 107.0)	90.0 (88.0 ~ 92.0)	80.0 (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	-----	194.0	129.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	219.0	154.0	129.0	-----	-----	-----	-----	-----
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	-----	237.0	172.0	147.0	137.0	134.0	132.0	-----	-----
Rough & 6 Skims	-----								-----
Rough & 7 Skims	-----								
Stepping Increment	-----	-----	65.0	25.0	10.0	3.0	2.0		

RESULTS									
Feedrate Cutting	FC		6.4 ~ 7.8	8.0 ~ 9.8	6.8 ~ 8.4	6.5 ~ 7.1	5.8 ~ 6.4	5.1 ~ 5.6	
Average Voltage Gap	V		34 ~ 52	45 ~ 61	42 ~ 52	114 ~ 129	100 ~ 114	99 ~ 113	
Avg. Linear Feedrate	ALF		426.0	237.0	155.9	112.8	86.2	68.0	
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	2.2 ~ 2.8	
	Ra		2.43 ~ 4.05	1.35 ~ 2.25	0.72 ~ 1.20	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.)

# MV2400S 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	14		
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 (48.0 ~ 52.0)	40.0 (34.0 ~ 40.0)	50.0 (48.0 ~ 52.0)	43.0 (41.0 ~ 45.0)	90.0 (88.0 ~ 92.0)	80.0 (78.0 ~ 82.0)	70.0 (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	-----	193.0	128.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	219.0	154.0	129.0	-----	-----	-----	-----	-----
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	-----	237.0	172.0	147.0	137.0	134.0	132.0	-----	-----
Rough & 6 Skims	-----								-----
Rough & 7 Skims	-----								
Stepping Increment	-----	-----	65.0	25.0	10.0	3.0	2.0		

RESULTS									
Feedrate Cutting	FC		3.8 ~ 4.8	6.6 ~ 8.1	5.4 ~ 6.6	6.5 ~ 7.1	6.0 ~ 6.8	4.8 ~ 5.4	
Average Voltage Gap	V		36 ~ 46	42 ~ 59	40 ~ 50	100 ~ 115	89 ~ 103	82 ~ 96	
Avg. Linear Feedrate	ALF		327.0	187.8	123.4	94.7	76.0	60.9	
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.)



# MV2400S 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	14		
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 (48.0 ~ 52.0)	32.0 (29.0 ~ 35.0)	48.0 (46.0 ~ 50.0)	41.0 (39.0 ~ 43.0)	75.0 (73.0 ~ 77.0)	70.0 (68.0 ~ 72.0)	60.0 (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	-----	193.0	128.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	219.0	154.0	129.0	-----	-----	-----	-----	-----
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	-----	237.0	172.0	147.0	137.0	134.0	132.0	-----	-----
Rough & 6 Skims	-----								-----
Rough & 7 Skims	-----								
Stepping Increment	-----	-----	65.0	25.0	10.0	3.0	2.0		

RESULTS									
Feedrate Cutting	FC		3.4 ~ 4.2	5.1 ~ 6.3	4.0 ~ 4.8	6.5 ~ 7.1	6.4 ~ 7.0	4.6 ~ 5.0	
Average Voltage Gap	V		23 ~ 40	39 ~ 57	38 ~ 48	87 ~ 102	78 ~ 92	64 ~ 78	
Avg. Linear Feedrate	ALF		228.0	136.8	90.1	73.8	62.4	51.3	
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.)

# MV2400S 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		
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	14		
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	10	8	6	2		
Stabilizer A	SA	3	6	3	1	2	1	1		
Stabilizer B	SB	7	4	8	10	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 (48.0 ~ 52.0)	31.0 (28.0 ~ 34.0)	46.0 (44.0 ~ 48.0)	41.0 (39.0 ~ 43.0)	60.0 (58.0 ~ 62.0)	60.0 (58.0 ~ 62.0)	50.0 (48.0 ~ 52.0)		
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	0.7	2.0	6.0	5.0	7.0	7.0	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	-----	164.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	193.0	128.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	219.0	154.0	129.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	232.0	167.0	142.0	132.0	-----	-----	-----	-----
Rough & 4 Skims	-----	234.0	169.0	144.0	134.0	131.0	-----	-----	-----
Rough & 5 Skims	-----	237.0	172.0	147.0	137.0	134.0	132.0	-----	-----
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	4.5 ~ 5.5	4.0 ~ 4.8	6.5 ~ 7.1	6.2 ~ 6.8	4.4 ~ 4.8	
Average Voltage Gap	V		22 ~ 39	37 ~ 55	38 ~ 48	78 ~ 92	70 ~ 83	57 ~ 70	
Avg. Linear Feedrate	ALF		195.0	118.2	81.6	68.0	57.9	47.9	
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.)

# MV2400S 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		
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	14		
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	9	8	6	2		
Stabilizer A	SA	3	7	3	1	2	1	1		
Stabilizer B	SB	7	4	8	9	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 (48.0 ~ 52.0)	30.0 (27.0 ~ 33.0)	44.0 (42.0 ~ 46.0)	41.0 (39.0 ~ 43.0)	45.0 (43.0 ~ 47.0)	50.0 (48.0 ~ 52.0)	40.0 (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	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	1.7	5.0	4.5	7.0	7.0	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	-----	169.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	193.0	128.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	219.0	154.0	129.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	232.0	167.0	142.0	132.0	-----	-----	-----	-----
Rough & 4 Skims	-----	234.0	169.0	144.0	134.0	131.0	-----	-----	-----
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		2.4 ~ 3.0	4.0 ~ 4.8	4.0 ~ 4.8	6.6 ~ 7.2	6.0 ~ 6.6	4.2 ~ 4.6	
Average Voltage Gap	V		21 ~ 39	36 ~ 54	38 ~ 48	69 ~ 83	61 ~ 74	49 ~ 62	
Avg. Linear Feedrate	ALF		162.0	100.4	72.7	61.9	53.2	44.3	
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.)

# MV2400S 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		
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	10	15		
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	9	8	5	1		
Stabilizer A	SA	3	6	3	1	2	1	1		
Stabilizer B	SB	7	4	8	9	8	5	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 (48.0 ~ 52.0)	30.0 (27.0 ~ 33.0)	42.0 (40.0 ~ 44.0)	41.0 (39.0 ~ 43.0)	45.0 (43.0 ~ 47.0)	50.0 (48.0 ~ 52.0)	38.0 (36.0 ~ 40.0)		
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	0.6	1.5	4.9	4.0	7.0	7.0	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	-----	169.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	194.0	127.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	222.0	155.0	130.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	235.0	168.0	143.0	133.0	-----	-----	-----	-----
Rough & 4 Skims	-----	237.0	170.0	145.0	135.0	132.0	-----	-----	-----
Rough & 5 Skims	-----	239.0	172.0	147.0	137.0	134.0	132.0	-----	-----
Rough & 6 Skims	-----								-----
Rough & 7 Skims	-----								
Stepping Increment	-----	-----	67.0	25.0	10.0	3.0	2.0		

RESULTS									
Feedrate Cutting	FC		2.0 ~ 2.5	3.5 ~ 4.2	3.3 ~ 4.1	6.5 ~ 7.1	6.1 ~ 6.7	4.2 ~ 4.7	
Average Voltage Gap	V		20 ~ 41	34 ~ 52	38 ~ 48	63 ~ 77	60 ~ 73	45 ~ 58	
Avg. Linear Feedrate	ALF		135.0	85.2	61.6	53.5	47.0	39.9	
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.)

# MV2400S 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		
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	15		
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	9	8	4	1		
Stabilizer A	SA	3	6	3	1	2	1	1		
Stabilizer B	SB	7	4	8	9	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 (48.0 ~ 52.0)	30.0 (27.0 ~ 33.0)	40.0 (38.0 ~ 42.0)	41.0 (39.0 ~ 43.0)	45.0 (43.0 ~ 47.0)	50.0 (48.0 ~ 52.0)	36.0 (34.0 ~ 38.0)		
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	0.6	1.3	4.8	3.5	7.0	7.0	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	-----	169.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	197.0	127.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	225.0	155.0	130.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	238.0	168.0	143.0	133.0	-----	-----	-----	-----
Rough & 4 Skims	-----	241.0	171.0	146.0	136.0	133.0	-----	-----	-----
Rough & 5 Skims	-----	242.0	172.0	147.0	137.0	134.0	132.0	-----	-----
Rough & 6 Skims	-----								-----
Rough & 7 Skims	-----								
Stepping Increment	-----	-----	70.0	25.0	10.0	3.0	2.0		

RESULTS									
Feedrate Cutting	FC		1.6 ~ 2.0	3.0 ~ 3.6	2.7 ~ 3.3	6.5 ~ 7.1	6.2 ~ 6.8	4.3 ~ 4.7	
Average Voltage Gap	V		20 ~ 42	32 ~ 50	38 ~ 48	56 ~ 71	59 ~ 72	42 ~ 54	
Avg. Linear Feedrate	ALF		108.0	69.9	50.3	44.8	40.2	35.0	
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.)

# MV2400S 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		
Power Supply	PS	RH	RH	RH	HL	LC	LC	LC		
Servo	SV	NM	NM	NM	NM	SL	SL	SL		
Voltage Open	Vo	7	7	6	12	14	12	12		
Power Setting	IP	8.0	11.0	6.0	14.0	2.5	2.5	2.0		
IP adjust	ΔIP	11	12	10	12					
Off Time	OFF	6	4	7	8	7	3	1		
Stabilizer A	SA	3	6	3	1	2	1	1		
Stabilizer B	SB	6	5	7	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 (48.0 ~ 52.0)	30.0 (27.0 ~ 33.0)	45.0 (43.0 ~ 47.0)	42.0 (40.0 ~ 44.0)	45.0 (43.0 ~ 47.0)	49.0 (47.0 ~ 51.0)	42.0 (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	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	1.1	4.5	3.4	6.7	6.5	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	-----	170.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	199.0	127.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	228.0	156.0	129.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	241.0	169.0	142.0	132.0	-----	-----	-----	-----
Rough & 4 Skims	-----	244.0	172.0	145.0	135.0	132.0	-----	-----	-----
Rough & 5 Skims	-----	246.0	174.0	147.0	137.0	134.0	132.0	-----	-----
Rough & 6 Skims	-----								-----
Rough & 7 Skims	-----								
Stepping Increment	-----	-----	72.0	27.0	10.0	3.0	2.0		

RESULTS									
Feedrate Cutting	FC		1.3 ~ 1.6	2.9 ~ 3.5	2.5 ~ 3.2	6.2 ~ 6.8	6.1 ~ 6.6	4.4 ~ 4.8	
Average Voltage Gap	V		20 ~ 42	36 ~ 55	39 ~ 49	54 ~ 67	57 ~ 69	42 ~ 54	
Avg. Linear Feedrate	ALF		87.0	59.9	44.3	39.8	36.0	31.9	
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.)

# MV2400S 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		
Power Supply	PS	RH	RH	RH	HL	LC	LC	LC		
Servo	SV	NM	NM	NM	NM	SL	SL	SL		
Voltage Open	Vo	7	7	8	12	14	13	12		
Power Setting	IP	8.0	11.0	6.0	14.0	2.5	2.5	2.0		
IP adjust	ΔIP	11	12	10	12					
Off Time	OFF	6	4	7	8	7	2	1		
Stabilizer A	SA	3	6	4	1	2	1	1		
Stabilizer B	SB	6	5	7	8	7	6	2		
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 (48.0 ~ 52.0)	30.0 (27.0 ~ 33.0)	50.0 (48.0 ~ 52.0)	41.0 (39.0 ~ 43.0)	45.0 (43.0 ~ 47.0)	48.0 (46.0 ~ 50.0)	48.0 (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	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	1.0	4.2	3.3	6.5	6.0	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	-----	171.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	202.0	127.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	233.0	158.0	128.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	247.0	172.0	142.0	132.0	-----	-----	-----	-----
Rough & 4 Skims	-----	250.0	175.0	145.0	135.0	132.0	-----	-----	-----
Rough & 5 Skims	-----	252.0	177.0	147.0	137.0	134.0	132.0	-----	-----
Rough & 6 Skims	-----								-----
Rough & 7 Skims	-----								
Stepping Increment	-----	-----	75.0	30.0	10.0	3.0	2.0		

RESULTS									
Feedrate Cutting	FC		1.1 ~ 1.3	2.8 ~ 3.4	2.4 ~ 3.0	5.9 ~ 6.5	5.3 ~ 5.9	4.5 ~ 4.9	
Average Voltage Gap	V		20 ~ 41	40 ~ 61	38 ~ 48	52 ~ 64	54 ~ 66	42 ~ 54	
Avg. Linear Feedrate	ALF		72.0	51.9	39.3	35.6	32.2	28.9	
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.)

# MV2400S 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		
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	14	15	14		
Power Setting	IP	8.0	12.0	7.0	6.0	2.5	2.5	2.0		
IP adjust	ΔIP	11	11	10	10					
Off Time	OFF	6	5	7	6	6	2	1		
Stabilizer A	SA	3	7	4	3	2	2	1		
Stabilizer B	SB	6	6	7	6	8	6	3		
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 (48.0 ~ 52.0)	35.0 (32.0 ~ 38.0)	50.0 (48.0 ~ 52.0)	43.0 (41.0 ~ 45.0)	55.0 (53.0 ~ 57.0)	47.0 (45.0 ~ 49.0)	40.0 (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	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	6	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	3.8	3.2	5.5	5.5	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	-----	177.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	214.0	129.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	249.0	164.0	132.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	266.0	181.0	149.0	134.0	-----	-----	-----	-----
Rough & 4 Skims	-----	270.0	185.0	153.0	138.0	133.0	-----	-----	-----
Rough & 5 Skims	-----	274.0	189.0	157.0	142.0	137.0	134.0	-----	-----
Rough & 6 Skims	-----								-----
Rough & 7 Skims	-----								
Stepping Increment	-----	-----	85.0	32.0	15.0	5.0	3.0		

RESULTS									
Feedrate Cutting	FC		0.8 ~ 1.0	2.8 ~ 3.4	2.4 ~ 3.1	4.9 ~ 5.6	5.1 ~ 5.6	4.5 ~ 5.3	
Average Voltage Gap	V		23 ~ 46	39 ~ 62	40 ~ 50	50 ~ 65	46 ~ 59	35 ~ 48	
Avg. Linear Feedrate	ALF		54.0	41.9	33.4	30.2	27.6	25.2	
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	
	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.)



# MV2400S 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		
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	14	16	16		
Power Setting	IP	8.0	12.0	7.0	6.0	2.5	2.5	2.0		
IP adjust	ΔIP	11	11	10	10					
Off Time	OFF	6	5	6	5	6	2	1		
Stabilizer A	SA	3	8	4	3	2	2	1		
Stabilizer B	SB	6	7	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 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	50.0 (48.0 ~ 52.0)	44.0 (42.0 ~ 46.0)	60.0 (58.0 ~ 62.0)	46.0 (44.0 ~ 48.0)	32.0 (30.0 ~ 34.0)		
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	6	6	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	3.5	3.0	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	-----	216.0	131.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	251.0	166.0	134.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	268.0	183.0	151.0	134.0	-----	-----	-----	-----
Rough & 4 Skims	-----	274.0	189.0	157.0	140.0	134.0	-----	-----	-----
Rough & 5 Skims	-----	278.0	193.0	161.0	144.0	138.0	135.0	-----	-----
Rough & 6 Skims	-----								-----
Rough & 7 Skims	-----								
Stepping Increment	-----	-----	85.0	32.0	17.0	6.0	3.0		

RESULTS									
Feedrate Cutting	FC		0.5 ~ 0.7	2.8 ~ 3.4	2.5 ~ 3.1	4.7 ~ 5.1	4.2 ~ 4.6	4.6 ~ 5.6	
Average Voltage Gap	V		29 ~ 51	37 ~ 62	41 ~ 51	55 ~ 69	39 ~ 52	29 ~ 42	
Avg. Linear Feedrate	ALF		36.0	30.2	25.6	23.5	21.6	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	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.)

# MV2400S 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	2351	2352	2353	2354	2355			
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	14			
Power Setting	IP	8.0	13.0	9.0	6.0	3.0	2.5			
IP adjust	ΔIP	11	11	10	10					
Off Time	OFF	6	5	8	4	1	1			
Stabilizer A	SA	3	9	6	3	2	1			
Stabilizer B	SB	6	9	8	4	8	8			
Stabilizer C	SC	7	7	1	1	1	1			
Stabilizer E	SE	4	5	1	1	1	1			
Voltage Gap	VG	50.0 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	42.0 (40.0 ~ 44.0)	43.0 (41.0 ~ 45.0)	60.0 (58.0 ~ 62.0)	43.0 (41.0 ~ 45.0)			
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	10			
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	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	0.4	3.5	3.0	5.0	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	-----	169.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	214.0	129.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	244.0	159.0	134.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	260.0	175.0	150.0	133.0	-----	-----	-----	-----
Rough & 4 Skims	-----	267.0	182.0	157.0	140.0	130.0	-----	-----	-----
Rough & 5 Skims	-----							-----	-----
Rough & 6 Skims	-----								-----
Rough & 7 Skims	-----								
Stepping Increment	-----	-----	85.0	25.0	17.0	10.0			

RESULTS									
Feedrate Cutting	FC		0.3 ~ 0.4	3.5 ~ 4.3	2.7 ~ 3.3	6.0 ~ 6.6	4.1 ~ 4.5		
Average Voltage Gap	V		33 ~ 50	32 ~ 54	40 ~ 50	68 ~ 81	43 ~ 55		
Avg. Linear Feedrate	ALF		21.0	19.3	17.4	16.6	15.6		
Surface Finish(u m)	Rz		16.2 ~ 19.8	13.5 ~ 16.5	11.7 ~ 14.3	7.2 ~ 8.8	5.4 ~ 6.6		
	Ra		2.43 ~ 4.05	2.25 ~ 3.75	1.62 ~ 2.70	0.81 ~ 1.35	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.)

# MV2400S 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	2361	2362	2363					
Power Supply	PS	RH	RH	RH	RH					
Servo	SV	NM	NM	NM	NM					
Voltage Open	Vo	7	7	12	12					
Power Setting	IP	8.0	13.0	9.0	6.0					
IP adjust	ΔIP	11	11	10	10					
Off Time	OFF	6	5	8	4					
Stabilizer A	SA	3	9	6	3					
Stabilizer B	SB	6	9	8	4					
Stabilizer C	SC	7	7	1	1					
Stabilizer E	SE	4	5	1	1					
Voltage Gap	VG	50.0 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	42.0 (40.0 ~ 44.0)	39.0 (37.0 ~ 41.0)					
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	10	14	14					
Pre-Tension	PT	14	14	14	14					
Flow Balance	FB	NM	NM	NM	NM					
Liquid Quantity	LQ	11	14	6	6					
Liquid Resistivity	LR	10	10	10	10					
Straightness cmp.	CC	0	0	0	0					
Feedrate Address	FA	0.5	0.3	2.5	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	-----	189.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	233.0	128.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	274.0	169.0	139.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----					-----	-----	-----	-----
Rough & 4 Skims	-----						-----	-----	-----
Rough & 5 Skims	-----							-----	-----
Rough & 6 Skims	-----								-----
Rough & 7 Skims	-----								
Stepping Increment	-----	-----	105.0	30.0					

RESULTS									
Feedrate Cutting	FC		0.2 ~ 0.3	1.4 ~ 1.8	2.3 ~ 2.9				
Average Voltage Gap	V		31 ~ 48	31 ~ 53	36 ~ 46				
Avg. Linear Feedrate	ALF		15.0	13.0	12.0				
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.)

# MV2400S 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	2371	2372	2373					
Power Supply	PS	RH	RH	RH	RH					
Servo	SV	NM	NM	NM	NM					
Voltage Open	Vo	7	7	12	14					
Power Setting	IP	8.0	13.0	9.0	6.0					
IP adjust	ΔIP	11	11	10	10					
Off Time	OFF	6	5	8	4					
Stabilizer A	SA	3	9	6	3					
Stabilizer B	SB	6	9	8	4					
Stabilizer C	SC	7	7	1	1					
Stabilizer E	SE	4	5	1	1					
Voltage Gap	VG	50.0 (48.0 ~ 52.0)	46.0 (43.0 ~ 49.0)	32.0 (30.0 ~ 34.0)	27.0 (25.0 ~ 29.0)					
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	10	14	14					
Pre-Tension	PT	14	14	14	14					
Flow Balance	FB	NM	NM	NM	NM					
Liquid Quantity	LQ	11	14	6	6					
Liquid Resistivity	LR	10	10	10	10					
Straightness cmp.	CC	0	0	0	0					
Feedrate Address	FA	0.5	0.2	2.0	1.5					
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	-----	189.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	256.0	131.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	303.0	178.0	133.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----				-----	-----	-----	-----	-----
Rough & 4 Skims	-----					-----	-----	-----	-----
Rough & 5 Skims	-----						-----	-----	-----
Rough & 6 Skims	-----							-----	-----
Rough & 7 Skims	-----								-----
Stepping Increment	-----	-----	125.0	45.0					

RESULTS									
Feedrate Cutting	FC		0.1 ~ 0.2	1.3 ~ 1.5	1.6 ~ 2.0				
Average Voltage Gap	V		34 ~ 54	25 ~ 42	24 ~ 34				
Avg. Linear Feedrate	ALF		9.0	8.1	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.)

**MV2400S****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	160.0	199.0	208.0	212.0					0.0
2	2112	MP	8.0	-	134.0	143.0	147.0					65.0
3	2113	LC	13.8	-	-	131.0	135.0					12.0
4	2114	LA	10.3	-	-	-	129.0					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	160.0	190.0	200.0	203.0					0.0
2	2122	MP	8.0	-	130.0	140.0	143.0					60.0
3	2123	LC	11.8	-	-	132.0	135.0					8.0
4	2124	LA	10.3	-	-	-	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 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	169.0	188.0	194.0	196.0					0.0
2	2132	MP	5.5	-	133.0	139.0	141.0					55.0
3	2133	LC	11.2	-	-	133.0	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

**MV2400S****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	165.0	199.0	206.0	208.0					0.0
2	2142	MP	3.9	-	134.0	141.0	143.0					65.0
3	2143	LC	10.0	-	-	133.0	135.0					8.0
4	2144	LA	8.0	-	-	-	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 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	195.0	203.0	204.0					0.0
2	2152	MP	3.6	-	135.0	143.0	144.0					60.0
3	2153	LC	8.2	-	-	133.0	134.0					10.0
4	2154	LA	7.3	-	-	-	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 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	2.0	165.0	200.0	206.0	208.0					0.0
2	2162	MP	3.3	-	135.0	141.0	143.0					65.0
3	2163	LC	8.0	-	-	132.0	134.0					9.0
4	2164	LA	5.0	-	-	-	131.0					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

**MV2400S****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	170.0	205.0	212.0	215.0					0.0
2	2172	MP	3.0	-	135.0	142.0	145.0					70.0
3	2173	LC	7.5	-	-	133.0	136.0					9.0
4	2174	LA	7.5	-	-	-	133.0					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	170.0	209.0	215.0	218.0					0.0
2	2182	MP	2.9	-	137.0	143.0	146.0					72.0
3	2183	LC	6.0	-	-	133.0	136.0					10.0
4	2184	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 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	174.0	212.0	218.0	220.0					0.0
2	2192	MP	2.8	-	137.0	143.0	145.0					75.0
3	2193	LC	6.0	-	-	133.0	135.0					10.0
4	2194	LA	4.0	-	-	-	130.0					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

**MV2400S****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	176.0	212.0	220.0	222.0					0.0
2	2202	MP	2.7	-	135.0	143.0	145.0					77.0
3	2203	LC	5.0	-	-	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	177.0	214.0	223.0	226.0					0.0
2	2212	MP	2.6	-	134.0	143.0	146.0					80.0
3	2213	LC	4.2	-	-	135.0	138.0					8.0
4	2214	LA	4.0	-	-	-	134.0					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	



# MV2400S 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	7	16	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	4	1	1	1				
Voltage Gap	VG	60.0 (58.0 ~ 62.0)	60.0 (57.0 ~ 63.0)	95.0 (93.0 ~ 97.0)	150.0 (148.0 ~ 152.0)	150.0 (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	-----	160.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	199.0	134.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	208.0	143.0	131.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	212.0	147.0	135.0	129.0	-----	-----	-----	-----
Rough & 4 Skims	-----					-----	-----	-----	-----
Rough & 5 Skims	-----						-----	-----	-----
Rough & 6 Skims	-----							-----	-----
Rough & 7 Skims	-----								-----
Stepping Increment	-----	-----	65.0	12.0	6.0				

RESULTS									
Feedrate Cutting	FC		10.1 ~ 10.2	11.6 ~ 14.2	12.3 ~ 13.6	9.2 ~ 10.1			
Average Voltage Gap	V		47 ~ 71	95 ~ 111	164 ~ 177	132 ~ 146			
Avg. Linear Feedrate	ALF		609.0	340.8	236.9	168.1			
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.)

# MV2400S 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	7	16	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	4	1	1	1				
Voltage Gap	VG	60.0 (58.0 ~ 62.0)	55.0 (52.0 ~ 58.0)	85.0 (83.0 ~ 87.0)	140.0 (138.0 ~ 142.0)	140.0 (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	11.8	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	-----	160.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	190.0	130.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	200.0	140.0	132.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	203.0	143.0	135.0	131.0	-----	-----	-----	-----
Rough & 4 Skims	-----					-----	-----	-----	-----
Rough & 5 Skims	-----						-----	-----	-----
Rough & 6 Skims	-----							-----	-----
Rough & 7 Skims	-----								-----
Stepping Increment	-----	-----	60.0	8.0	4.0				

RESULTS									
Feedrate Cutting	FC		6.6 ~ 6.8	12.3 ~ 15.1	10.3 ~ 11.4	9.1 ~ 10.1			
Average Voltage Gap	V		39 ~ 58	91 ~ 105	154 ~ 166	129 ~ 141			
Avg. Linear Feedrate	ALF		402.0	270.0	190.8	143.3			
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.)

# MV2400S 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	11	16	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	4	1	1	1				
Voltage Gap	VG	60.0 (58.0 ~ 62.0)	36.0 (33.0 ~ 39.0)	74.0 (72.0 ~ 76.0)	130.0 (128.0 ~ 132.0)	95.0 (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	14	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	-----	169.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	188.0	133.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	194.0	139.0	133.0	-----	-----	-----	-----	-----
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		3.9 ~ 4.4	12.0 ~ 14.7	9.9 ~ 11.0	8.3 ~ 9.2			
Average Voltage Gap	V		54 ~ 68	85 ~ 100	147 ~ 159	110 ~ 122			
Avg. Linear Feedrate	ALF		249.0	190.0	145.8	114.1			
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.)

# MV2400S 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	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	10	16	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	4	1	1	1				
Voltage Gap	VG	50.0 (48.0 ~ 52.0)	36.0 (33.0 ~ 39.0)	77.0 (75.0 ~ 79.0)	110.0 (108.0 ~ 112.0)	80.0 (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	14	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	3.9	10.0	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	-----	165.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	199.0	134.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	206.0	141.0	133.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	208.0	143.0	135.0	131.0	-----	-----	-----	-----
Rough & 4 Skims	-----					-----	-----	-----	-----
Rough & 5 Skims	-----						-----	-----	-----
Rough & 6 Skims	-----							-----	-----
Rough & 7 Skims	-----								-----
Stepping Increment	-----	-----	65.0	8.0	4.0				

RESULTS									
Feedrate Cutting	FC		3.8 ~ 4.2	8.0 ~ 10.7	8.5 ~ 9.5	7.3 ~ 8.2			
Average Voltage Gap	V		40 ~ 54	82 ~ 95	120 ~ 146	90 ~ 100			
Avg. Linear Feedrate	ALF		240.0	168.1	128.2	100.5			
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.)

# MV2400S 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	8	16	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	4	1	1	1				
Voltage Gap	VG	50.0 (48.0 ~ 52.0)	37.0 (34.0 ~ 40.0)	80.0 (78.0 ~ 82.0)	100.0 (98.0 ~ 102.0)	70.0 (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	14	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	-----	195.0	135.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	203.0	143.0	133.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	204.0	144.0	134.0	130.0	-----	-----	-----	-----
Rough & 4 Skims	-----					-----	-----	-----	-----
Rough & 5 Skims	-----						-----	-----	-----
Rough & 6 Skims	-----							-----	-----
Rough & 7 Skims	-----								-----
Stepping Increment	-----	-----	60.0	10.0	4.0				

RESULTS									
Feedrate Cutting	FC		2.6 ~ 3.0	6.3 ~ 7.7	7.2 ~ 8.2	6.4 ~ 7.1			
Average Voltage Gap	V		25 ~ 44	79 ~ 92	117 ~ 138	81 ~ 93			
Avg. Linear Feedrate	ALF		168.0	120.0	95.3	77.1			
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.)

# MV2400S 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	7	16	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	4	1	1	1				
Voltage Gap	VG	50.0 (48.0 ~ 52.0)	35.0 (32.0 ~ 38.0)	75.0 (73.0 ~ 77.0)	90.0 (88.0 ~ 92.0)	60.0 (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	14	6	4	4				
Liquid Resistivity	LR	10	10	10	10	10				
Straightness cmp.	CC	0	0	30	20	20				
Feedrate Address	FA	0.7	2.0	3.3	8.0	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	-----	165.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	200.0	135.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	206.0	141.0	132.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	208.0	143.0	134.0	131.0	-----	-----	-----	-----
Rough & 4 Skims	-----					-----	-----	-----	-----
Rough & 5 Skims	-----						-----	-----	-----
Rough & 6 Skims	-----							-----	-----
Rough & 7 Skims	-----								-----
Stepping Increment	-----	-----	65.0	9.0	3.0				

RESULTS									
Feedrate Cutting	FC		2.6 ~ 2.8	5.3 ~ 6.0	7.0 ~ 8.2	4.8 ~ 5.2			
Average Voltage Gap	V		24 ~ 42	70 ~ 85	100 ~ 120	70 ~ 88			
Avg. Linear Feedrate	ALF		162.0	109.6	88.4	68.3			
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.)

# MV2400S 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	7	16	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	4	1	1	1				
Voltage Gap	VG	50.0 (48.0 ~ 52.0)	34.0 (31.0 ~ 37.0)	72.0 (70.0 ~ 74.0)	85.0 (83.0 ~ 87.0)	60.0 (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	14	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	-----	170.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	205.0	135.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	212.0	142.0	133.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	215.0	145.0	136.0	133.0	-----	-----	-----	-----
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 ~ 2.1	3.3 ~ 4.0	6.5 ~ 8.2	6.5 ~ 8.5			
Average Voltage Gap	V		24 ~ 39	66 ~ 77	98 ~ 109	69 ~ 80			
Avg. Linear Feedrate	ALF		120.0	77.5	65.9	57.5			
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.)

# MV2400S 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	6	16	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	4	1	1	1				
Voltage Gap	VG	50.0 (48.0 ~ 52.0)	36.0 (33.0 ~ 39.0)	60.0 (58.0 ~ 62.0)	75.0 (73.0 ~ 77.0)	53.0 (51.0 ~ 55.0)				
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	14	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	6.0	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	-----	170.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	209.0	137.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	215.0	143.0	133.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	218.0	146.0	136.0	132.0	-----	-----	-----	-----
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 ~ 1.7	3.0 ~ 3.7	5.3 ~ 6.2	3.9 ~ 4.5			
Average Voltage Gap	V		27 ~ 45	52 ~ 68	90 ~ 95	57 ~ 74			
Avg. Linear Feedrate	ALF		96.0	65.0	54.7	44.9			
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.)



# MV2400S 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	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 (48.0 ~ 52.0)	38.0 (35.0 ~ 41.0)	50.0 (48.0 ~ 52.0)	70.0 (68.0 ~ 72.0)	45.0 (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	14	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	-----	174.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	212.0	137.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	218.0	143.0	133.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	220.0	145.0	135.0	130.0	-----	-----	-----	-----
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 ~ 1.6	2.7 ~ 3.3	5.0 ~ 6.2	3.4 ~ 4.0			
Average Voltage Gap	V		28 ~ 48	47 ~ 63	80 ~ 93	53 ~ 64			
Avg. Linear Feedrate	ALF		90.0	60.0	50.9	41.4			
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.)

# MV2400S 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 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	45.0 (43.0 ~ 47.0)	65.0 (63.0 ~ 67.0)	45.0 (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	14	6	4	4				
Liquid Resistivity	LR	10	10	10	10	10				
Straightness cmp.	CC	0	0	45	20	10				
Feedrate Address	FA	0.5	1.0	2.7	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	-----	176.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	212.0	135.0	-----	-----	-----	-----	-----	-----
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		1.0 ~ 1.2	2.9 ~ 3.6	4.8 ~ 5.2	3.5 ~ 4.1			
Average Voltage Gap	V		30 ~ 50	42 ~ 58	78 ~ 91	51 ~ 63			
Avg. Linear Feedrate	ALF		66.0	49.3	42.3	35.7			
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.)

# MV2400S 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	7	15	1	1				
Stabilizer C	SC	7	7	1	4	4				
Stabilizer E	SE	4	5	1	1	1				
Voltage Gap	VG	50.0 (48.0 ~ 52.0)	43.0 (40.0 ~ 46.0)	45.0 (43.0 ~ 47.0)	60.0 (58.0 ~ 62.0)	45.0 (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	14	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	-----	177.0	-----	-----	-----	-----	-----	-----	-----
Rough & 1 Skim	-----	214.0	134.0	-----	-----	-----	-----	-----	-----
Rough & 2 Skims	-----	223.0	143.0	135.0	-----	-----	-----	-----	-----
Rough & 3 Skims	-----	226.0	146.0	138.0	134.0	-----	-----	-----	-----
Rough & 4 Skims	-----					-----	-----	-----	-----
Rough & 5 Skims	-----						-----	-----	-----
Rough & 6 Skims	-----							-----	-----
Rough & 7 Skims	-----								-----
Stepping Increment	-----	-----	80.0	8.0	4.0				

RESULTS									
Feedrate Cutting	FC		0.9 ~ 1.1	3.2 ~ 3.9	3.8 ~ 4.2	3.6 ~ 4.2			
Average Voltage Gap	V		33 ~ 52	38 ~ 53	76 ~ 89	50 ~ 62			
Avg. Linear Feedrate	ALF		60.0	46.8	39.2	33.6			
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.)

**MV2400S****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

**MV2400S****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

**MV2400S****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

**MV2400S****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	

# MV2400S 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 (58.0 ~ 62.0)	70.0 (67.0 ~ 73.0)	110.0 (108.0 ~ 112.0)	105.0 (103.0 ~ 107.0)	100.0 (98.0 ~ 102.0)	90.0 (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.)



# MV2400S 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 (58.0 ~ 62.0)	60.0 (57.0 ~ 63.0)	100.0 (98.0 ~ 102.0)	80.0 (78.0 ~ 82.0)	75.0 (73.0 ~ 77.0)	75.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	47.0 (44.0 ~ 50.0)	94.0 (92.0 ~ 96.0)	90.0 (88.0 ~ 92.0)	85.0 (83.0 ~ 87.0)	55.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	38.0 (35.0 ~ 41.0)	94.0 (92.0 ~ 96.0)	60.0 (58.0 ~ 62.0)	65.0 (63.0 ~ 67.0)	58.0 (56.0 ~ 60.0)	40.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	30.0 (27.0 ~ 33.0)	95.0 (93.0 ~ 97.0)	60.0 (58.0 ~ 62.0)	65.0 (63.0 ~ 67.0)	58.0 (56.0 ~ 60.0)	40.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	29.0 (26.0 ~ 32.0)	90.0 (88.0 ~ 92.0)	51.0 (49.0 ~ 53.0)	67.0 (65.0 ~ 69.0)	51.0 (49.0 ~ 53.0)	35.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	28.0 (25.0 ~ 31.0)	86.0 (84.0 ~ 88.0)	43.0 (41.0 ~ 45.0)	70.0 (68.0 ~ 72.0)	45.0 (43.0 ~ 47.0)	30.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	34.0 (31.0 ~ 37.0)	86.0 (84.0 ~ 88.0)	42.0 (40.0 ~ 44.0)	67.0 (65.0 ~ 69.0)	42.0 (40.0 ~ 44.0)	30.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	86.0 (84.0 ~ 88.0)	42.0 (40.0 ~ 44.0)	65.0 (63.0 ~ 67.0)	40.0 (38.0 ~ 42.0)	40.0 (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.)



# MV2400S 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 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	83.0 (81.0 ~ 85.0)	41.0 (39.0 ~ 43.0)	52.0 (50.0 ~ 54.0)	56.0 (54.0 ~ 58.0)	37.0 (35.0 ~ 39.0)	32.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	80.0 (78.0 ~ 82.0)	40.0 (38.0 ~ 42.0)	40.0 (38.0 ~ 42.0)	58.0 (56.0 ~ 60.0)	35.0 (33.0 ~ 37.0)	32.0 (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.)

**MV2400S****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

**MV2400S****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

**MV2400S****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

**MV2400S****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	

# MV2400S 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 (58.0 ~ 62.0)	78.0 (75.0 ~ 81.0)	120.0 (118.0 ~ 122.0)	105.0 (103.0 ~ 107.0)	85.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	74.0 (71.0 ~ 77.0)	115.0 (113.0 ~ 117.0)	100.0 (98.0 ~ 102.0)	80.0 (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.)



# MV2400S 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 (58.0 ~ 62.0)	66.0 (63.0 ~ 69.0)	105.0 (103.0 ~ 107.0)	105.0 (103.0 ~ 107.0)	80.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	65.0 (62.0 ~ 68.0)	104.0 (102.0 ~ 106.0)	102.0 (100.0 ~ 104.0)	80.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	64.0 (61.0 ~ 67.0)	104.0 (102.0 ~ 106.0)	100.0 (98.0 ~ 102.0)	80.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	63.0 (60.0 ~ 66.0)	102.0 (100.0 ~ 104.0)	97.0 (95.0 ~ 99.0)	77.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	62.0 (59.0 ~ 65.0)	100.0 (98.0 ~ 102.0)	95.0 (93.0 ~ 97.0)	75.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	61.0 (58.0 ~ 64.0)	98.0 (96.0 ~ 100.0)	92.0 (90.0 ~ 94.0)	72.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	60.0 (57.0 ~ 63.0)	96.0 (94.0 ~ 98.0)	90.0 (88.0 ~ 92.0)	70.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	59.0 (56.0 ~ 62.0)	96.0 (94.0 ~ 98.0)	82.0 (80.0 ~ 84.0)	65.0 (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.)



# MV2400S 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 (48.0 ~ 52.0)	58.0 (55.0 ~ 61.0)	96.0 (94.0 ~ 98.0)	75.0 (73.0 ~ 77.0)	60.0 (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.)

**MV2400S****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

**MV2400S****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

**MV2400S****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

**MV2400S****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

# MV2400S

## 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	

# MV2400S 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 (58.0 ~ 62.0)	72.0 (69.0 ~ 75.0)	130.0 (128.0 ~ 132.0)	100.0 (98.0 ~ 102.0)	90.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	62.0 (59.0 ~ 65.0)	124.0 (122.0 ~ 126.0)	90.0 (88.0 ~ 92.0)	85.0 (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.)



# MV2400S 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 (58.0 ~ 62.0)	56.0 (53.0 ~ 59.0)	120.0 (118.0 ~ 122.0)	95.0 (93.0 ~ 97.0)	90.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	58.0 (55.0 ~ 61.0)	117.0 (115.0 ~ 119.0)	87.0 (85.0 ~ 89.0)	80.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	60.0 (57.0 ~ 63.0)	114.0 (112.0 ~ 116.0)	80.0 (78.0 ~ 82.0)	80.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	62.0 (59.0 ~ 65.0)	112.0 (110.0 ~ 114.0)	75.0 (73.0 ~ 77.0)	75.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	65.0 (62.0 ~ 68.0)	110.0 (108.0 ~ 112.0)	70.0 (68.0 ~ 72.0)	70.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	65.0 (62.0 ~ 68.0)	105.0 (103.0 ~ 107.0)	70.0 (68.0 ~ 72.0)	70.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	66.0 (63.0 ~ 69.0)	100.0 (98.0 ~ 102.0)	70.0 (68.0 ~ 72.0)	70.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	64.0 (61.0 ~ 67.0)	103.0 (101.0 ~ 105.0)	65.0 (63.0 ~ 67.0)	65.0 (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.)



# MV2400S 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 (48.0 ~ 52.0)	62.0 (59.0 ~ 65.0)	106.0 (104.0 ~ 108.0)	60.0 (58.0 ~ 62.0)	60.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	61.0 (58.0 ~ 64.0)	102.0 (100.0 ~ 104.0)	52.0 (50.0 ~ 54.0)	52.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	60.0 (57.0 ~ 63.0)	98.0 (96.0 ~ 100.0)	45.0 (43.0 ~ 47.0)	45.0 (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.)

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.25BS	Graphite	Class1

Thickness 10 mm

No.	Cutting process			Offset										Step 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 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 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

**MV2400S****Digest**

Wire Dia. and Type	Material Type	Class
0.25BS	Graphite	Class1

Thickness 40 mm

No.	Cutting process			Offset										Step 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 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 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

**MV2400S****Digest**

Wire Dia. and Type	Material Type	Class
0.25BS	Graphite	Class1

Thickness 70 mm

No.	Cutting process			Offset										Step 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 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 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

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.25BS	Graphite	Class1

Thickness 100 mm

No.	Cutting process			Offset										Step 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 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 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	

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.25BS	Graphite	Class2

Thickness 10 mm

No.	Cutting process			Offset										Step 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 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 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



**MV2400S****Digest**

Wire Dia. and Type	Material Type	Class
0.25BS	Graphite	Class2

Thickness 40 mm

No.	Cutting process			Offset										Step 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 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 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

**MV2400S****Digest**

Wire Dia. and Type	Material Type	Class
0.25BS	Graphite	Class2

Thickness 70 mm

No.	Cutting process			Offset										Step 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 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 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

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.25BS	Graphite	Class2

Thickness 100 mm

No.	Cutting process			Offset										Step 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 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 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	

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.25BS	Graphite	Class3

Thickness 10 mm

No.	Cutting process			Offset										Step 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 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 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

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.25BS	Graphite	Class3

Thickness 40 mm

No.	Cutting process			Offset										Step 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 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 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

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.25BS	Graphite	Class3

Thickness 70 mm

No.	Cutting process			Offset										Step 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 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 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

# MV2400S

## Digest

Wire Dia. and Type	Material Type	Class
0.25BS	Graphite	Class3

Thickness 100 mm

No.	Cutting process			Offset										Step 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 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 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	

## MV2400S 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 (58 ~ 62)	70.0 (67 ~ 73)		70.0 (67 ~ 73)		75.0 (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.)



## MV2400S 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 (58 ~ 62)	70.0 (67 ~ 73)		70.0 (67 ~ 73)		65.0 (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.)

## MV2400S 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 (48 ~ 52)	60.0 (57 ~ 63)		65.0 (62 ~ 68)		60.0 (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.)

## MV2400S 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 (48 ~ 52)	50.0 (47 ~ 53)		60.0 (57 ~ 63)		60.0 (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.)

## MV2400S 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 (48 ~ 52)	45.0 (42 ~ 48)		50.0 (47 ~ 53)		55.0 (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.)

## MV2400S 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 (48 ~ 52)	45.0 (42 ~ 48)		45.0 (42 ~ 48)		50.0 (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.)

## MV2400S 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 (48 ~ 52)	45.0 (42 ~ 48)		50.0 (47 ~ 53)		55.0 (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.)

## MV2400S 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 (48 ~ 52)	50.0 (47 ~ 53)		60.0 (57 ~ 63)		60.0 (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.)

## MV2400S 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 (48 ~ 52)	55.0 (52 ~ 58)		60.0 (57 ~ 63)		60.0 (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.)



## MV2400S 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 (48 ~ 52)	60.0 (57 ~ 63)		60.0 (57 ~ 63)		60.0 (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**

**MV2400S****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

**MV2400S****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

**MV2400S****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

**MV2400S****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

**MV2400S****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

**MV2400S****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



# MV2400S 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 (58.0 ~ 62.0)	60.0 (57.0 ~ 63.0)	98.0 (96.0 ~ 100.0)	75.0 (73.0 ~ 77.0)	190.0 (188.0 ~ 192.0)	145.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	60.0 (57.0 ~ 63.0)	85.0 (83.0 ~ 87.0)	55.0 (53.0 ~ 57.0)	150.0 (148.0 ~ 152.0)	130.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	50.0 (47.0 ~ 53.0)	88.0 (86.0 ~ 90.0)	65.0 (63.0 ~ 67.0)	140.0 (138.0 ~ 142.0)	120.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	50.0 (47.0 ~ 53.0)	85.0 (83.0 ~ 87.0)	62.0 (60.0 ~ 64.0)	120.0 (118.0 ~ 122.0)	115.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	50.0 (47.0 ~ 53.0)	78.0 (76.0 ~ 80.0)	61.0 (59.0 ~ 63.0)	100.0 (98.0 ~ 102.0)	90.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	48.0 (45.0 ~ 51.0)	76.0 (74.0 ~ 78.0)	57.0 (55.0 ~ 59.0)	95.0 (93.0 ~ 97.0)	80.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	46.0 (43.0 ~ 49.0)	74.0 (72.0 ~ 76.0)	55.0 (53.0 ~ 57.0)	90.0 (88.0 ~ 92.0)	70.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	44.0 (41.0 ~ 47.0)	74.0 (72.0 ~ 76.0)	55.0 (53.0 ~ 57.0)	87.0 (85.0 ~ 89.0)	67.0 (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.)



# MV2400S 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 (58.0 ~ 62.0)	42.0 (39.0 ~ 45.0)	74.0 (72.0 ~ 76.0)	55.0 (53.0 ~ 57.0)	85.0 (83.0 ~ 87.0)	65.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	41.0 (38.0 ~ 44.0)	72.0 (70.0 ~ 74.0)	52.0 (50.0 ~ 54.0)	80.0 (78.0 ~ 82.0)	62.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	40.0 (37.0 ~ 43.0)	70.0 (68.0 ~ 72.0)	49.0 (47.0 ~ 51.0)	75.0 (73.0 ~ 77.0)	60.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	43.0 (40.0 ~ 46.0)	72.0 (70.0 ~ 74.0)	60.0 (58.0 ~ 62.0)	85.0 (83.0 ~ 87.0)	70.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	46.0 (43.0 ~ 49.0)	75.0 (73.0 ~ 77.0)	70.0 (68.0 ~ 72.0)	90.0 (88.0 ~ 92.0)	75.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	46.0 (43.0 ~ 49.0)	60.0 (58.0 ~ 62.0)	55.0 (53.0 ~ 57.0)	70.0 (68.0 ~ 72.0)	50.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	38.0 (35.0 ~ 41.0)	48.0 (46.0 ~ 50.0)	45.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	38.0 (35.0 ~ 41.0)	38.0 (36.0 ~ 40.0)	40.0 (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.)



# MV2400S 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	3161	3162	3163					
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 (58.0 ~ 62.0)	30.0 (27.0 ~ 33.0)	30.0 (28.0 ~ 32.0)	40.0 (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.)

# MV2400S 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	3171	3172	3173					
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 (58.0 ~ 62.0)	30.0 (27.0 ~ 33.0)	25.0 (23.0 ~ 27.0)	35.0 (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.)

**MV2400S****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

**MV2400S****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

**MV2400S****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

# MV2400S 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 (58.0 ~ 62.0)	50.0 (47.0 ~ 53.0)	95.0 (93.0 ~ 97.0)	65.0 (63.0 ~ 67.0)	140.0 (138.0 ~ 142.0)	130.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	50.0 (47.0 ~ 53.0)	90.0 (88.0 ~ 92.0)	63.0 (61.0 ~ 65.0)	125.0 (123.0 ~ 127.0)	110.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	50.0 (47.0 ~ 53.0)	85.0 (83.0 ~ 87.0)	61.0 (59.0 ~ 63.0)	110.0 (108.0 ~ 112.0)	90.0 (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.)



# MV2400S 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 (58.0 ~ 62.0)	48.0 (45.0 ~ 51.0)	83.0 (81.0 ~ 85.0)	60.0 (58.0 ~ 62.0)	105.0 (103.0 ~ 107.0)	85.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	46.0 (43.0 ~ 49.0)	81.0 (79.0 ~ 83.0)	60.0 (58.0 ~ 62.0)	100.0 (98.0 ~ 102.0)	80.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	46.0 (43.0 ~ 49.0)	81.0 (79.0 ~ 83.0)	60.0 (58.0 ~ 62.0)	95.0 (93.0 ~ 97.0)	77.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	46.0 (43.0 ~ 49.0)	81.0 (79.0 ~ 83.0)	60.0 (58.0 ~ 62.0)	90.0 (88.0 ~ 92.0)	75.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	46.0 (43.0 ~ 49.0)	79.0 (77.0 ~ 81.0)	57.0 (55.0 ~ 59.0)	85.0 (83.0 ~ 87.0)	72.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	46.0 (43.0 ~ 49.0)	77.0 (75.0 ~ 79.0)	54.0 (52.0 ~ 56.0)	80.0 (78.0 ~ 82.0)	70.0 (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.)

**MV2400S****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

**MV2400S****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



**MV2400S****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

**MV2400S****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

# MV2400S

## 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	

# MV2400S 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 (58.0 ~ 62.0)	58.0 (55.0 ~ 61.0)	135.0 (133.0 ~ 137.0)	111.0 (109.0 ~ 113.0)	100.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	57.0 (54.0 ~ 60.0)	132.0 (130.0 ~ 134.0)	108.0 (106.0 ~ 110.0)	85.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	57.0 (54.0 ~ 60.0)	130.0 (128.0 ~ 132.0)	105.0 (103.0 ~ 107.0)	70.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	56.0 (53.0 ~ 59.0)	127.0 (125.0 ~ 129.0)	100.0 (98.0 ~ 102.0)	70.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	55.0 (52.0 ~ 58.0)	125.0 (123.0 ~ 127.0)	95.0 (93.0 ~ 97.0)	70.0 (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.)



# MV2400S 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 (58.0 ~ 62.0)	55.0 (52.0 ~ 58.0)	124.0 (122.0 ~ 126.0)	95.0 (93.0 ~ 97.0)	65.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	55.0 (52.0 ~ 58.0)	123.0 (121.0 ~ 125.0)	95.0 (93.0 ~ 97.0)	60.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	54.0 (51.0 ~ 57.0)	121.0 (119.0 ~ 123.0)	94.0 (92.0 ~ 96.0)	60.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	53.0 (50.0 ~ 56.0)	119.0 (117.0 ~ 121.0)	94.0 (92.0 ~ 96.0)	60.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	53.0 (50.0 ~ 56.0)	116.0 (114.0 ~ 118.0)	90.0 (88.0 ~ 92.0)	55.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	53.0 (50.0 ~ 56.0)	113.0 (111.0 ~ 115.0)	86.0 (84.0 ~ 88.0)	50.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	55.0 (52.0 ~ 58.0)	103.0 (101.0 ~ 105.0)	81.0 (79.0 ~ 83.0)	45.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	57.0 (54.0 ~ 60.0)	98.0 (96.0 ~ 100.0)	78.0 (76.0 ~ 80.0)	40.0 (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.)



**MV2400S****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

**MV2400S****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

**MV2400S****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

# MV2400S 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 (58.0 ~ 62.0)	64.0 (61.0 ~ 67.0)	117.0 (115.0 ~ 119.0)	106.0 (104.0 ~ 108.0)	80.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	63.0 (60.0 ~ 66.0)	116.0 (114.0 ~ 118.0)	105.0 (103.0 ~ 107.0)	85.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	62.0 (59.0 ~ 65.0)	115.0 (113.0 ~ 117.0)	104.0 (102.0 ~ 106.0)	90.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	62.0 (59.0 ~ 65.0)	115.0 (113.0 ~ 117.0)	103.0 (101.0 ~ 105.0)	80.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	62.0 (59.0 ~ 65.0)	115.0 (113.0 ~ 117.0)	102.0 (100.0 ~ 104.0)	70.0 (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.)



# MV2400S 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 (58.0 ~ 62.0)	61.0 (58.0 ~ 64.0)	115.0 (113.0 ~ 117.0)	103.0 (101.0 ~ 105.0)	65.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	60.0 (57.0 ~ 63.0)	115.0 (113.0 ~ 117.0)	104.0 (102.0 ~ 106.0)	60.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	59.0 (56.0 ~ 62.0)	114.0 (112.0 ~ 116.0)	104.0 (102.0 ~ 106.0)	60.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	58.0 (55.0 ~ 61.0)	113.0 (111.0 ~ 115.0)	104.0 (102.0 ~ 106.0)	60.0 (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**

**MV2400S****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

**MV2400S****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	

# MV2400S 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 (78.0 ~ 82.0)	50.0 (47.0 ~ 53.0)	44.0 (42.0 ~ 46.0)	54.0 (52.0 ~ 56.0)	150.0 (148.0 ~ 152.0)	105.0 (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.)



# MV2400S 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 (78.0 ~ 82.0)	57.0 (54.0 ~ 60.0)	44.0 (42.0 ~ 46.0)	48.0 (46.0 ~ 50.0)	140.0 (138.0 ~ 142.0)	100.0 (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.)

# MV2400S 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 (78.0 ~ 82.0)	52.0 (49.0 ~ 55.0)	44.0 (42.0 ~ 46.0)	42.0 (40.0 ~ 44.0)	110.0 (108.0 ~ 112.0)	90.0 (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.)

# MV2400S 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 (78.0 ~ 82.0)	56.0 (53.0 ~ 59.0)	43.0 (41.0 ~ 45.0)	41.0 (39.0 ~ 43.0)	95.0 (93.0 ~ 97.0)	80.0 (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.)

# MV2400S 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 (78.0 ~ 82.0)	60.0 (57.0 ~ 63.0)	42.0 (40.0 ~ 44.0)	40.0 (38.0 ~ 42.0)	80.0 (78.0 ~ 82.0)	70.0 (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.)

**MV2400S****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	

# MV2400S 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 (78.0 ~ 82.0)	52.0 (49.0 ~ 55.0)	44.0 (42.0 ~ 46.0)	54.0 (52.0 ~ 56.0)	160.0 (158.0 ~ 162.0)	135.0 (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.)

# MV2400S 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 (78.0 ~ 82.0)	62.0 (59.0 ~ 65.0)	44.0 (42.0 ~ 46.0)	48.0 (46.0 ~ 50.0)	140.0 (138.0 ~ 142.0)	95.0 (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.)

**MV2400S****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



**MV2400S****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	

# MV2400S 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 (78.0 ~ 82.0)	60.0 (57.0 ~ 63.0)	46.0 (44.0 ~ 48.0)	58.0 (56.0 ~ 60.0)	140.0 (138.0 ~ 142.0)	125.0 (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.)

# MV2400S 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 (78.0 ~ 82.0)	58.0 (55.0 ~ 61.0)	46.0 (44.0 ~ 48.0)	52.0 (50.0 ~ 54.0)	110.0 (108.0 ~ 112.0)	85.0 (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.)

# MV2400S 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 (78.0 ~ 82.0)	50.0 (47.0 ~ 53.0)	46.0 (44.0 ~ 48.0)	50.0 (48.0 ~ 52.0)	75.0 (73.0 ~ 77.0)	70.0 (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.)

# MV2400S 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 (78.0 ~ 82.0)	50.0 (47.0 ~ 53.0)	42.0 (40.0 ~ 44.0)	43.0 (41.0 ~ 45.0)	62.0 (60.0 ~ 64.0)	57.0 (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.)

# MV2400S 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 (78.0 ~ 82.0)	50.0 (47.0 ~ 53.0)	40.0 (38.0 ~ 42.0)	37.0 (35.0 ~ 39.0)	50.0 (48.0 ~ 52.0)	45.0 (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.)

**MV2400S****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	

# MV2400S 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 (78.0 ~ 82.0)	70.0 (67.0 ~ 73.0)	46.0 (44.0 ~ 48.0)	58.0 (56.0 ~ 60.0)	140.0 (138.0 ~ 142.0)	125.0 (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.)



# MV2400S 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 (78.0 ~ 82.0)	58.0 (55.0 ~ 61.0)	46.0 (44.0 ~ 48.0)	52.0 (50.0 ~ 54.0)	110.0 (108.0 ~ 112.0)	85.0 (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.)

**MV2400S****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

# MV2400S 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 (78.0 ~ 82.0)	60.0 (57.0 ~ 63.0)	54.0 (52.0 ~ 56.0)	60.0 (58.0 ~ 62.0)	138.0 (136.0 ~ 140.0)	84.0 (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.)

# MV2400S 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 (78.0 ~ 82.0)	60.0 (57.0 ~ 63.0)	54.0 (52.0 ~ 56.0)	58.0 (56.0 ~ 60.0)	118.0 (116.0 ~ 120.0)	64.0 (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.)

# MV2400S 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 (78.0 ~ 82.0)	60.0 (57.0 ~ 63.0)	54.0 (52.0 ~ 56.0)	52.0 (50.0 ~ 54.0)	84.0 (82.0 ~ 86.0)	40.0 (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**

**MV2400S****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

**MV2400S****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	



# MV2400S 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 (68.0 ~ 72.0)	76.0 (73.0 ~ 79.0)	48.0 (46.0 ~ 50.0)	70.0 (68.0 ~ 72.0)	165.0 (163.0 ~ 167.0)	90.0 (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.)

# MV2400S 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 (68.0 ~ 72.0)	62.0 (59.0 ~ 65.0)	38.0 (36.0 ~ 40.0)	70.0 (68.0 ~ 72.0)	140.0 (138.0 ~ 142.0)	95.0 (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.)

# MV2400S 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 (68.0 ~ 72.0)	52.0 (49.0 ~ 55.0)	30.0 (28.0 ~ 32.0)	58.0 (56.0 ~ 60.0)	100.0 (98.0 ~ 102.0)	75.0 (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.)

# MV2400S 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 (68.0 ~ 72.0)	49.0 (46.0 ~ 52.0)	30.0 (28.0 ~ 32.0)	59.0 (57.0 ~ 61.0)	85.0 (83.0 ~ 87.0)	65.0 (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.)

# MV2400S 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 (68.0 ~ 72.0)	46.0 (43.0 ~ 49.0)	30.0 (28.0 ~ 32.0)	60.0 (58.0 ~ 62.0)	70.0 (68.0 ~ 72.0)	55.0 (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.)

**MV2400S****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	

# MV2400S 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 (68.0 ~ 72.0)	76.0 (73.0 ~ 79.0)	58.0 (56.0 ~ 60.0)	70.0 (68.0 ~ 72.0)	160.0 (158.0 ~ 162.0)	85.0 (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.)

# MV2400S 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 (68.0 ~ 72.0)	62.0 (59.0 ~ 65.0)	48.0 (46.0 ~ 50.0)	70.0 (68.0 ~ 72.0)	140.0 (138.0 ~ 142.0)	90.0 (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.)



**MV2400S****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

**MV2400S****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	

# MV2400S 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 (68.0 ~ 72.0)	70.0 (67.0 ~ 73.0)	40.0 (38.0 ~ 42.0)	45.0 (43.0 ~ 47.0)	120.0 (118.0 ~ 122.0)	80.0 (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.)

# MV2400S 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 (68.0 ~ 72.0)	62.0 (59.0 ~ 65.0)	40.0 (38.0 ~ 42.0)	40.0 (38.0 ~ 42.0)	100.0 (98.0 ~ 102.0)	60.0 (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.)

# MV2400S 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 (68.0 ~ 72.0)	55.0 (52.0 ~ 58.0)	36.0 (34.0 ~ 38.0)	34.0 (32.0 ~ 36.0)	70.0 (68.0 ~ 72.0)	50.0 (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.)

# MV2400S 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 (68.0 ~ 72.0)	61.0 (58.0 ~ 64.0)	43.0 (41.0 ~ 45.0)	32.0 (30.0 ~ 34.0)	60.0 (58.0 ~ 62.0)	40.0 (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.)

# MV2400S 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 (68.0 ~ 72.0)	68.0 (65.0 ~ 71.0)	50.0 (48.0 ~ 52.0)	30.0 (28.0 ~ 32.0)	50.0 (48.0 ~ 52.0)	30.0 (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.)

**MV2400S****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	



# MV2400S 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 (68.0 ~ 72.0)	76.0 (73.0 ~ 79.0)	50.0 (48.0 ~ 52.0)	45.0 (43.0 ~ 47.0)	115.0 (113.0 ~ 117.0)	80.0 (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.)

# MV2400S 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 (68.0 ~ 72.0)	57.0 (54.0 ~ 60.0)	40.0 (38.0 ~ 42.0)	40.0 (38.0 ~ 42.0)	100.0 (98.0 ~ 102.0)	60.0 (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**

MV2400S

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	

MV2400S

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	

MV2400S

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	

MV2400S

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**



## MV2400S 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 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 (58 ~ 62)	25.0 (22 ~ 28)		25.0 (22 ~ 28)		25.0 (22 ~ 28)		25.0 (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

## MV2400S 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 adjast	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 (58 ~ 62)	125.0 (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 )

## MV2400S 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 (58 ~ 62)	25.0 (22 ~ 28)		25.0 (22 ~ 28)		25.0 (22 ~ 28)		30.0 (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

## MV2400S 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 (58 ~ 62)	125.0 (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**

# MV2400S 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 (39 ~ 45)	44 (41 ~ 47)	30 (27 ~ 33)	44 (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.)

# MV2400S 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 (37 ~ 43)	45 (42 ~ 48)	30 (27 ~ 33)	60 (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**



## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.20 (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 (56 ~ 70)	100.0 (90 ~ 110)	90.0 (80 ~ 100)	120.0 (110 ~ 130)	80.0 (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.)

## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.20 (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 (56 ~ 70)	100.0 (90 ~ 110)	90.0 (80 ~ 100)	120.0 (110 ~ 130)	80.0 (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.)

## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.20 (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 (57 ~ 63)	50.0 (47 ~ 53)	40.0 (37 ~ 43)	55.0 (52 ~ 58)	80.0 (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.)

## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.20 (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 (56 ~ 70)	100.0 (90 ~ 110)	90.0 (80 ~ 100)	115.0 (110 ~ 130)	80.0 (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.)

## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.20 (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 (56 ~ 70)	100.0 (90 ~ 110)	90.0 (80 ~ 100)	115.0 (110 ~ 130)	80.0 (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.)

## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.20 (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 (57 ~ 63)	50.0 (47 ~ 53)	46.0 (43 ~ 49)	55.0 (52 ~ 58)	60.0 (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.)

## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.20 (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 (57 ~ 63)	55.0 (52 ~ 58)	50.0 (47 ~ 53)	55.0 (52 ~ 58)	66.0 (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.)

## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.20 (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 (57 ~ 63)	50.0 (47 ~ 53)	46.0 (43 ~ 49)	55.0 (52 ~ 58)	80.0 (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.)



## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.25 (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 (56 ~ 70)	100.0 (90 ~ 110)	90.0 (80 ~ 100)	125.0 (115 ~ 135)	86.0 (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.)

## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.25 (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 (56 ~ 70)	100.0 (90 ~ 110)	90.0 (80 ~ 100)	125.0 (115 ~ 135)	86.0 (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.)

## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.25 (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 (57 ~ 63)	76.0 (73 ~ 79)	61.0 (58 ~ 64)	115.0 (112 ~ 118)	86.0 (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.)

## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.25 (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 (57 ~ 63)	76.0 (73 ~ 79)	61.0 (58 ~ 64)	108.0 (105 ~ 111)	80.0 (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.)

## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.25 (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 (56 ~ 70)	100.0 (90 ~ 110)	90.0 (80 ~ 100)	125.0 (115 ~ 135)	86.0 (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.)

## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.25 (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 (56 ~ 70)	100.0 (90 ~ 110)	90.0 (80 ~ 100)	125.0 (115 ~ 135)	86.0 (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.)

## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.25 (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 (47 ~ 53)	76.0 (73 ~ 79)	75.0 (72 ~ 78)	115.0 (112 ~ 118)	86.0 (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.)

## MV2400S Machning Data Sheet

Wire Dia. and Type	Material Type	Material Thickness	Taper Angle	Flush cup clearance (Upper)	Flush cup clearance (Lower)
φ0.25 (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 (61 ~ 67)	78.0 (75 ~ 81)	75.0 (72 ~ 78)	108.0 (105 ~ 111)	80.0 (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 ø0.20 Wire**  
**Machining Characteristics Data**

**MV2400S****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

**MV2400S****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

**MV2400S****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

# MV2400S

## 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	

# MV2400S 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 (58.0 ~ 62.0)	46.0 (43.0 ~ 49.0)	30.0 (28.0 ~ 32.0)	155.0 (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.)

# MV2400S 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 (58.0 ~ 62.0)	42.0 (39.0 ~ 45.0)	30.0 (28.0 ~ 32.0)	120.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	46.0 (43.0 ~ 49.0)	30.0 (28.0 ~ 32.0)	116.0 (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.)



# MV2400S 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 (48.0 ~ 52.0)	50.0 (47.0 ~ 53.0)	30.0 (28.0 ~ 32.0)	112.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	44.0 (41.0 ~ 47.0)	30.0 (28.0 ~ 32.0)	98.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	38.0 (35.0 ~ 41.0)	30.0 (28.0 ~ 32.0)	85.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	40.0 (37.0 ~ 43.0)	30.0 (28.0 ~ 32.0)	65.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	42.0 (39.0 ~ 45.0)	30.0 (28.0 ~ 32.0)	65.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	44.0 (41.0 ~ 47.0)	30.0 (28.0 ~ 32.0)	60.0 (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.)

# MV2400S 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 (48.0 ~ 52.0)	46.0 (43.0 ~ 49.0)	30.0 (28.0 ~ 32.0)	50.0 (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.)