

CNC Small Hole Drilling EDM

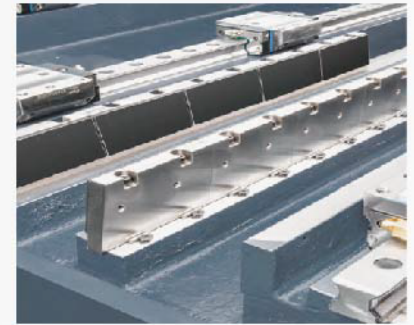
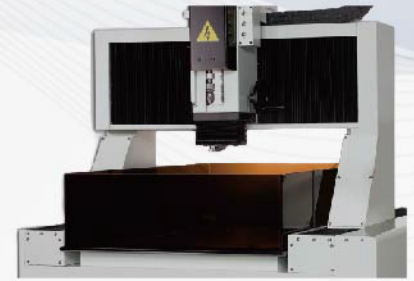
H32C, H64CL, H86CL



FEATURES

Gantry type structure for H64CL and H86CL and Y axis is driven by linear motors

H64CL and H86CL adopt gantry type structure with longer Y axis travel. The fixed table design can accommodate heavy weight workpieces up to 1,500 kg. Y axis is driven by CHMER in house developed and manufactured linear motors which are dual balance design to provide high thrust, quick response, very low temperature rise, no deformation due to magnetic force and maintenance free fast motion.

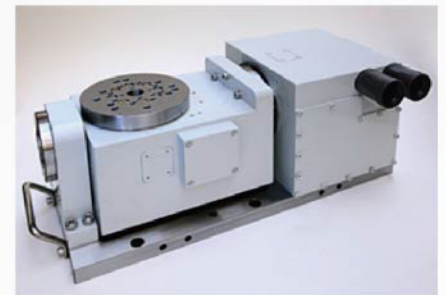


Optional Automatic Electrode Changer (AEC) with electrode stabilizer

The optional 10-position AEC, or called ATC, Automatic Tool Changer, with electrode stabilizer can automatically change electrodes for unattended drilling operation. The electrode stabilizer can hold the long, originally 400mm, electrode to prevent whipping, bending and vibration of the electrode.

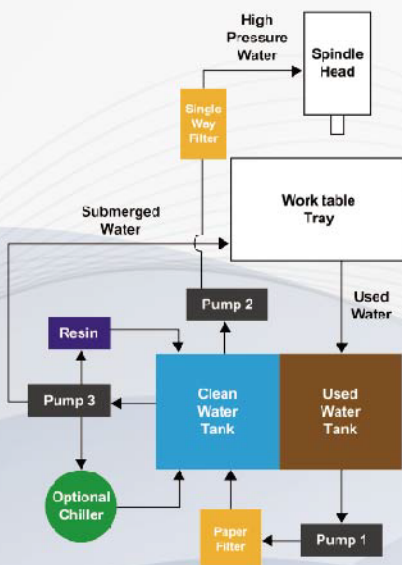
Optional tilting rotary table for drilling angled holes

For drilling angled holes, there are many tilting rotary tables, or called AB indexers, for choice. Our controller can control up to 6 axes. For 3D tilting machining.



Complete water circulation system

The filtering system with paper filter, single way filter, resin filter, and high pressure pumps can provide clean and deionized high pressure water for accurate small hole drilling, especially below $\Phi 0.5\text{mm}$ holes. The automatic water conductivity control can stabilize the machining gap and high water conductivity and prevent molds from rusting. Optional chiller can control the water temperature to enhance the accuracy of the hole dimensions.



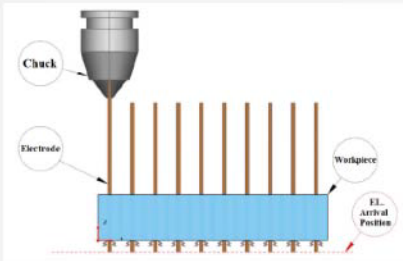
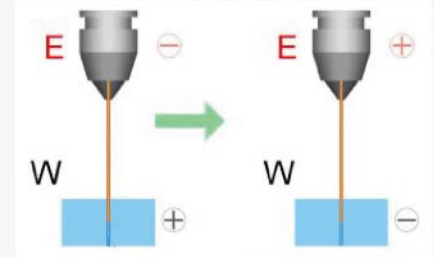


Super hard alloy drilling

The built-in 200V high-voltage discharge circuit has a significant effect on drilling tungsten steel, nickel-based alloy and other hard materials.

Polarity switching circuit

For aluminum alloy drilling, the optional polarity switching circuit can avoid the failure of the wire cut EDM machining due to insulation issue.



Break out detection (BOD)

Drilling will stop when the electrode reaches the bottom of the workpiece and sparks appear. This function is combined with the design of worktable tray with shallow water.

Standard / Option Accessories

Standard ● Option ○

Features & Item	Specification	Unit	H32C	H64CL	H86CL
Guide dia	1.0mm	1set	●	●	●
Guide dia	0.5mm	1set	●	●	●
Insert Rubbers	1.0mm	3set	●	●	●
Insert Rubbers	0.5mm	3set	●	●	●
Air Fast Connector		1set	●	●	●
Electrode Brass dia.	∅ 1.0 x 400mm	10set	●	●	●
Electrode Brass dia.	∅ 0.5 x 400mm	10set	●	●	●
Table Cover	(Front)	1set	●	●	●
Table Cover	(Back)	1set	●	●	●
Tool Box		1set	●	●	●
Flushing pipe		1set	●	●	●
Filter	5-7μm	1set	●	●	●
Air pipe		1set	●	●	●
ER Collet Chucks	0.2-0.7 mm 0.5-1.0 mm 1.0-2.0 mm 2.0-3.0 mm 3.0-4.0 mm 4.0-5.0 mm 5.0-6.0 mm	1set 2set 2set 2set 1set 1set 1set	○	○	○
AEC Device	10-position	1set	○	○	○
Rotary Axis		1set	○	○	○
Tilting Axis		1set	○	○	○
Chiller	1 ton	1set	○	○	○

Specifications

Machine Specifications	H32C	H64CL	H86CL
Work Table (mm)	660 x 320	570 x 740	770 x 950
X, Y Travel (mm)	350 x 250	400 x 600	600 x 800
Z Axis RamTravel (mm)	250	400	400
W Axis Travel (mm)	400	400	400
Max. Workpiece (WxDxH mm)	800 x 400 x 250	600 x 1000 x 380	800 x 1100 x 380
Max. Workpiece Weight (kg)	180	1000	1200
Electrode Diameter (mm)	Ø0.20-3.0 Ø6.0 (Optional ER)	Ø0.20-3.0 Ø6.0 (Optional ER)	Ø0.20-3.0 Ø6.0 (Optional ER)
Max. Length of Electrode Tube (mm)	400	400	400
Table Top to Bottom of Guide (mm)	30-280	35-435	35-435
Tank Capacity (L)	90	90	130
Dielectric Fluid Type	Pure Water/Flush	Pure Water/Flush	Pure Water/Flush
Machine Dimension (WxDxH mm)	2000 x 1875 x 2100	2300 x 2380 x 2000	2300 x 2580 x 2000

Power Supply Unit	Unit	
Max.Machining Current	A	60
Max.Power Input	kva	3
Current Setting	step	59
Pulse Width	µs	Ton 1µs~512µs

■ Due to continuous improvements, the design and specifications are subject to change without prior notice.

Machine Dimensions Unit : mm

