

HIGH SPEED SMALL HOLE DRILLING EDM



FEATURES AD5L

Compact Design

Single platform design for small footprint enclosed in 1900 x 2100mm space (75"x83").

Invert High Pressure Water

Inverter controlled high pressure pump to increase flush pressure as the hole goes deeper. Ensures constant flush pressure and improve chip removed.

Linear Motor Drive

Linear Motor Drive with Glass Scales, on X Axis (opt. on Y Axis) to increase positioning speeds and hold better accuracies.

Submerged Machining

Large capacity submerged work tank to allow for addition of submergible AB tables from various manufactures. All 6 axes are controlled by The Industry PC utilizing AMStech software. Ethernet, USB, Rs232 and MDI input.

Invert Spindle Speed Control

Invert Spindle for reduced electrode wear and improve accuracy of the small holes. Built in measuring cycles to precisely EDM Blind holes without "backstrikes".

Canned Cycles & Programming

Various canned cycles can be used such as CHMER and edge find, correction of program during the cut for casting variations, etc. Software for offline programming is also available.



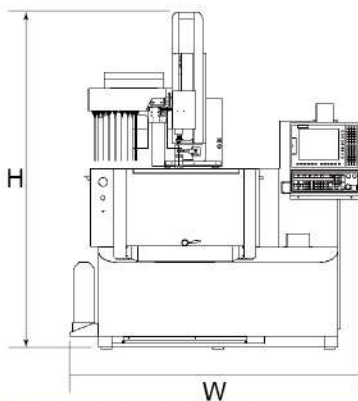
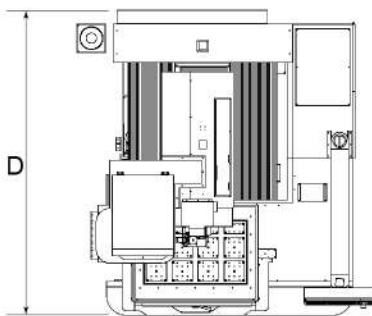
AMStech® HIGH SPEED SMALL HOLE DRILLING EDM



SPECIFICATION	AD3L	AD4L	AD5L	AD6L
Work table spec. (mm / inch)	530x350 (20.9x13.8)	550x430 (21.6x16.9)	720x430 (28.3x16.9)	720x500 (28.3x19.7)
X,Y axis travel (mm / inch)	350x250 (13.8x9.8)	400x300 (15.8x11.8)	500x300 (19.7x11.8)	600x400 (23.6x15.7)
Max. job load size (WxDxH mm)	710x670x435 (29.7x26.4x17.1)	800x550x330 (31.5x21.6x13)	890x670x485 (35x26.4x19.1)	950x780x535 (37.4x30.7x21.1)
Max. job load weight (kgw / lb)	800 (1764)	900 (1980)	1000 (2205)	1200 (2646)
Z axis ram travel (mm / inch)	250 (9.8)	300 (11.8)	300 (11.8)	350 (13.8)
W axis travel (mm / inch)	500 (19.7)	500 (19.7)	500 (19.7)	500 (19.7)
Automatic Tool Changer	10 or 20	10 or 20	10 or 20	10 or 20
Automatic Guide Changer	5~20	5~20	5~20	5~20
Max. electrode (mm / inch)	Ø0.2-Ø3.0 (Ø0.008-Ø0.12)	Ø0.2-Ø3.0 (Ø0.008-Ø0.12)	Ø0.2-Ø3.0 (Ø0.008-Ø0.12)	Ø0.2-Ø3.0 (Ø0.008-Ø0.12)
Max. electrode length (mm / inch)	400 (15.7)	400 (15.7)	400 (15.7)	400 (15.7)
Distance from guide to table ▶ Standard	30~280 (1.2~11)	30~330 (1.2~13)	30~330 (1.2~13)	30~380 (1.2~15)
Distance from guide to table ▶ For AB Axis Table	185~435 (7.3~17.1)	185~485 (7.2~19.1)	185~485 (7.2~19.1)	185~535 (7.2~21.1)
Dielectric capacity (L / Gallon)	450 (119)	90 (23.8)	450 (119)	600 (159)
Dielectric type	Pure Water	Pure Water	Pure Water	Pure Water
Floor layout (WxDxH mm)	1925x2100x2100 (75.8x82.7x82.7)	1750x1830x2100 (68.9x72x82.7)	2045x2230x2300 (80.5x87.8x90.6)	2200x2560x2300 (86.6x100.8x90.6)
Machine body net (kgw)	2800 (6173)	2300 (5071)	3000 (6614)	3200 (7055)
No. of Axis Control	X, Y, Z, W axis			

Work Tank height = 350mm, Submerge level = 250mm (Standard) ; Work Tank height = 500mm, Submerge level = 400mm (AB indexer)

FLOOR LAYOUT



Unit:mm

STANDARD ACCESSORIES

- Ceramic Guide
0.5mm x1pcs ; 1.0 mm x1pcs
- Paper Filter
5µm x 2 pcs
- Electrode Tube
0.5mm x10pcs ; 1.0 mm x10pcs
- Work Lamp
LED:1 set
- Rubber Seal
ER / 20 pcs
- ER Chuck (Optional-ATC)
1pcs / 10pcs / 20pcs

OPTIONAL ACCESSORIES

- ATC/AGC
- 3.0~6.0mm Electrode
- Linear Motor Drive Y Axis
- Linear Scale
- Invert Spindle
- Water Cooler
- Indexer