



Non-traditional Machining Solution Provider

## Compact Linear Motor Drive Die Sinker EDM

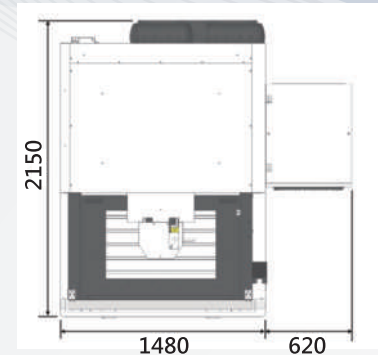
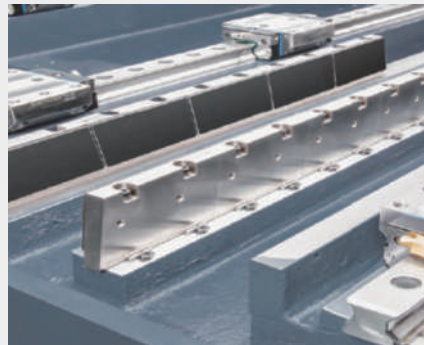
# A6040L



# FEATURES

## Compact die sinker EDM

A-series adopts compact design. The oil reservoir is underneath the work tank and the power supply cabinet is attached to the machine. It is easy for installation and can save the shipping space and factory installation footprint.

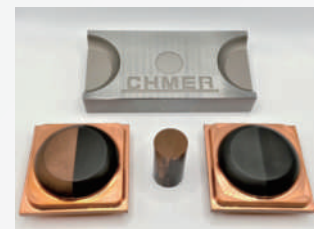


## X, Y, and Z axes are driven by linear motors

The X, Y, and Z axes are driven by CHMER developed and manufactured linear motors which adopt dual balance design to provide high thrust, quick response, very low temperature rise, no deformation due to magnetic force, maintenance free, and fast motion.

## New Machining Circuit

The new machining circuit can control discharge power precisely to enhance the profile accuracy of molds.

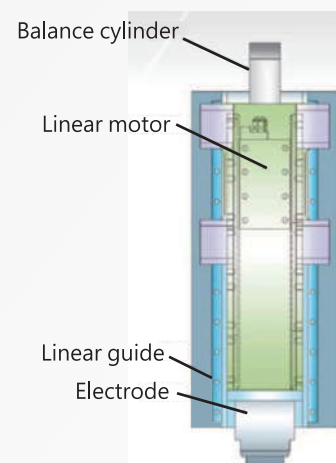


## Energy Saving Super Hard Alloy Circuit (SAC)

The advanced super hard alloy circuit (SAC) can process super hard alloy, such as tungsten carbide, machining. Compared with other circuits, it has doubled machining efficiency and 15% lower power consumption.

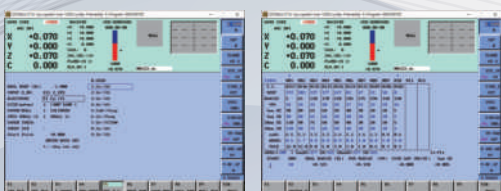
## Air Balance Spindle

The discharge Z axis uses linear motor and air balance system, so the removing chips function, especially for grooves, is greatly improved. The air source for air balance system can be recycled through patented internal circulation system and thus save energy.



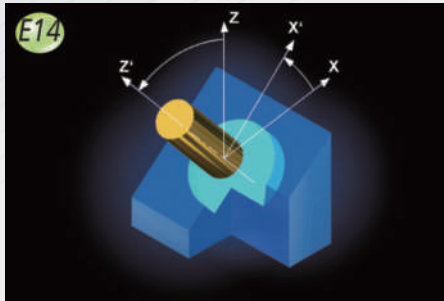
## User Friendly HMI

After inputting electrode material, workpiece material, discharge current, and surface roughness, the easy understanding dialogue HMI can give suitable machining conditions.

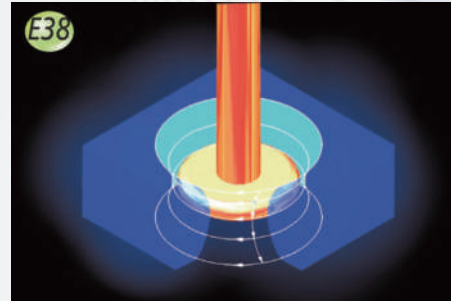


## E Code Function

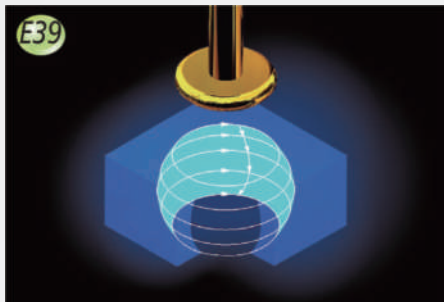
- Unique CHMER E code function to achieve 3 axis simultaneous machining without complicated G, M codes.
- Different E codes available for different working applications.
- Friendly E code illustration for operator to understand E code machining before and during the cut.



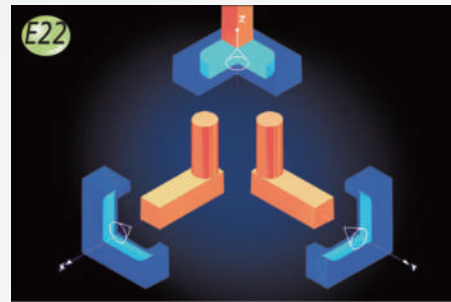
Workpiece slanted at 45 degrees, the electrode could do orbiting erosion at 45 ramp accordingly.



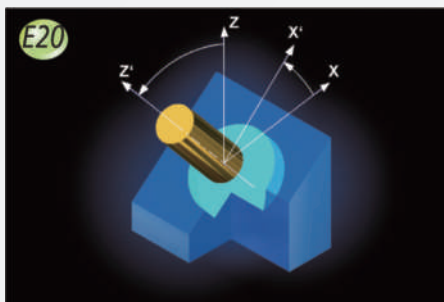
An external global processing, Z-axis do stepwise erosion in harmony, X, Y axes perform arc circular motion on its radius.



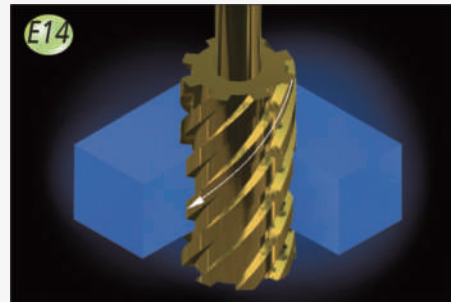
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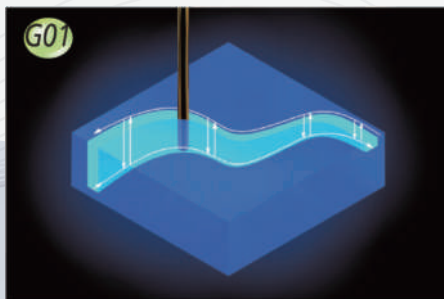
Orbiting erosion could perform 3 axes in six directions moving along with rotation.



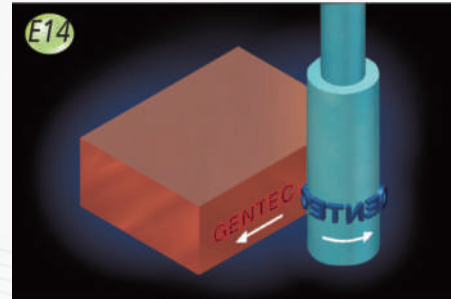
Electrode depth lock-up, X, Y axes perform orbiting erosion.



Z-axis erosion with C-axis to perform screws threading, spiraling jobs.



GM Code Edition mode: It's available to use GM code to do contouring job on 3D trajectory synchronization.



X, Y axes erosion with C-axis to perform rollaway molds jobs.

# Options

3 Pos. ATC, 4 Pos. ATC, C-axis, Magnetic Chucks, Fast Fill & Auto Drain, B-axis, Automatic Drop Tank Door, SAC, Oil Cooler, 75A Booster

## Notes

1. B-axis can only be operated under flushing condition.
2. C-axis and ATC have System 3R and Erowa for choice.
3. The maximum working current is 300A with 50A or 75A boosters.

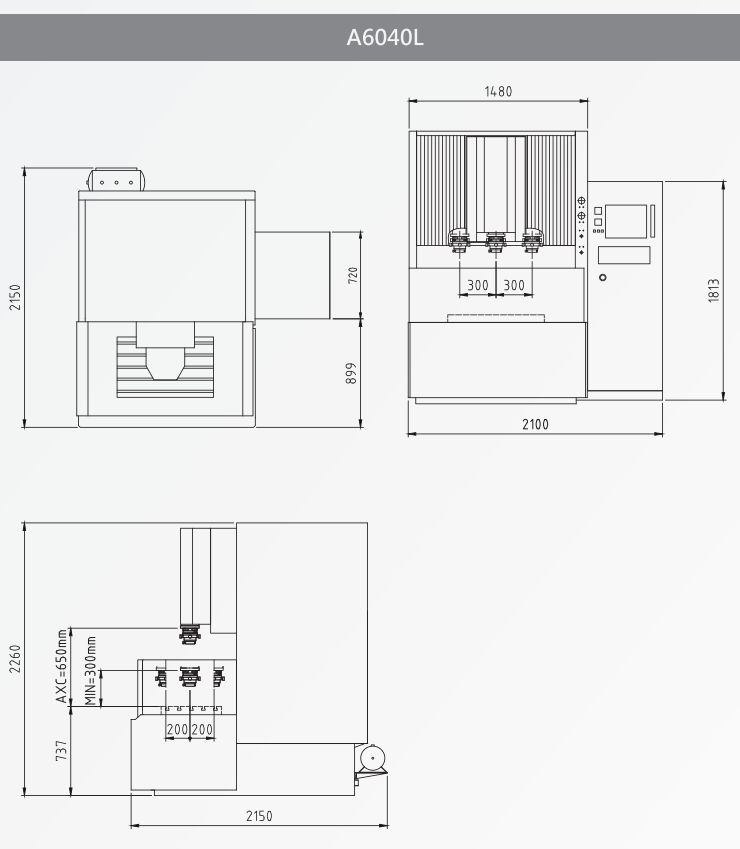


C-axis System 3R or Erowa.

## Specifications

## Machine Dimensions Unit : mm

Machine Specifications	Unit	Unit	
Worktable Size	mm	800 x 500	
Work Table Size(WxDxH)	mm	1200 x 740 x 450	
Max. Workpiece size(WxDxH)	mm	1050 x 700 x 300	
X, Y Axes Travel	mm	600 x 400	
Z Axis Travel	mm	350	
X, Y, Z Axes Drive	method	X, Y, Z Axes By Linear Motors	
Distance from Ram Platen to Worktable	mm	250 - 600	
Max. Electrode Weight	kg	50	
Max. Workpiece Weight	kg	1500	
Machine Dimensions	mm	2100 x 2150 x 2260	
Machine Net Weight	kg	3000	
Air Requirement	Kgf/cm <sup>2</sup>	6	
Dielectric Tank Model	-	DA64	
<b>Power Supply Specifications</b>	<b>Unit</b>	<b>50N</b>	<b>75N</b>
Max. machining current	A	50	75
Max. power unput	KVA	5	6
Electrode wear rate	%	0.2	0.2
Best surface roughness	µm/Ra	0.45	0.45
Unit Dimensions	mm	Built in	Built in
Unit Weight	kg	Built in	Built in
<b>Dielectric Tank Specifications</b>	<b>Unit</b>	<b>DA64</b>	
Dielectric Fluid Capacity	L	635	
Filtration	Type	Paper filters	
Pump Power	HP	0.5	



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

