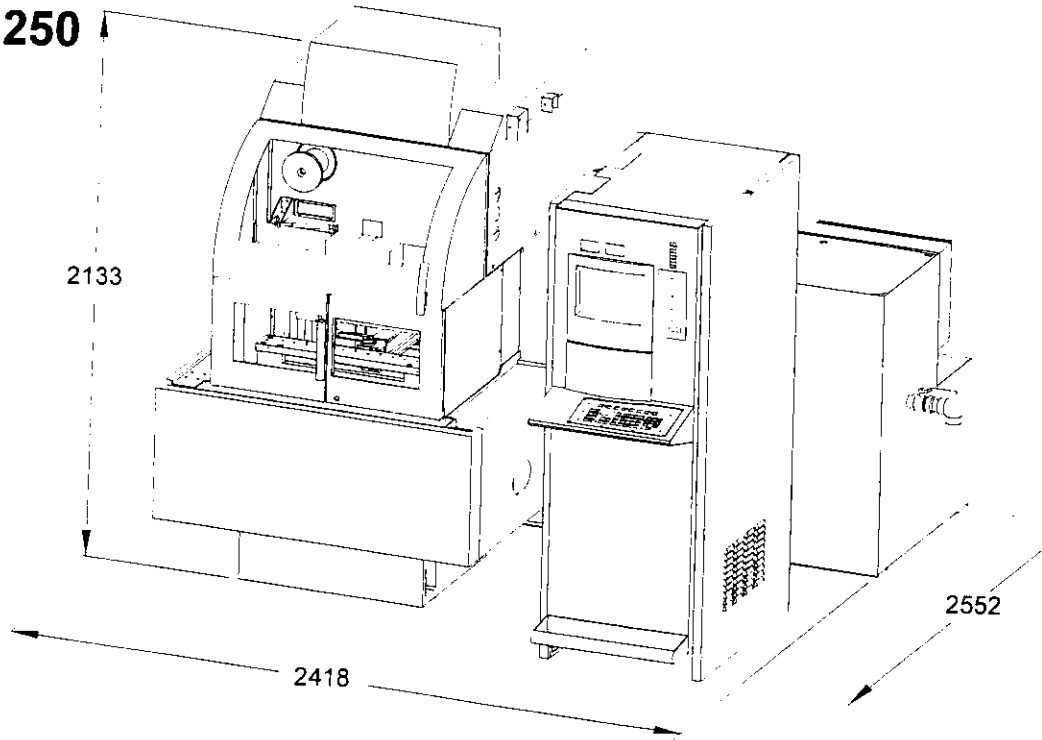


**E 250**



2133

2418

2552

## CHAPTER 2

### DESCRIPTION OF THE MACHINE

#### 2.1. CHARACTERISTICS

##### 2.1.1. TECHNICAL DATA

MODEL	PRIMA E 250	PRIMA E 400	PRIMA E 900
X - Y axes stroke (mm):	350 x 250	600 x 400	900 x 400
Z axis stroke (mm):	200	400	400
U - V axes stroke (mm):	80 x 80	80 x 80	80 x 80
Maximum workpiece size (X, Y, Z) (mm):	910 x 680 x 200	1200 x 880 x 400	1500 x 880 x 400
Maximum workpiece weight (kg):	500	850	2000
Taper cutting angle:		18° / 100 mm (Z)	
Taper cutting maximum angle:		30°	
Wire diameter (mm):		0,1 - 0,3	
Wire characteristics (uncoated wire)		Cu 63% / Zn 37%	
Wire resistance (brass) N/mm <sup>2</sup> :		900	
Wire spool:		DIN125 - DIN160	
Wire guide:		closed diamond guide	
Position resolution (X, Y, U, V) (mm):		0,001	
Programmable increment minimum (mm):		0,001	

##### 2.1.2. FRAME

The machine frame (base, column and "XY"- "UV" tables) is constructed of cast iron and stabilized.

##### 2.1.3. "X-Y" COORDINATE TABLES AND "U-V" and "Z" HEADS

The movement of "X-Y" tables and UV and Z heads is guided by high quality ball screws. Transmission from the correspondent D.C. motors, is by gear box.

# Chapter 4

## NUMERICAL CONTROL UNIT

### 4.1. TECHNICAL DATA

#### 4.1.1. NUMERICAL CONTROL

##### RESOLUTION

- Controlled axes X, Y, U, V.
- Minimum increase programmed (X, Y, U, V axes 0.001 mm).
- Minimum increase controlled (X, Y, U, V axes 0.001 mm).
- Maximum dimension programmed  $\pm 9.999,999$  mm.
- Z-axis is controlled in the same way in machines with Automatic Wire Threading.

##### OPERATION

- 14" colour CRT screen, with graphic control.
- Antidust plain keyboard.
- Assisted, conversational.
- Assisted programming language, as well as standard ISO language.
- Fast to operate and easy to learn.
- Continuous information while executing.
- Simultaneous programming while other erosion processings being carried out.
- Perpendicular, Axis change.
- Generator's parameter control.
- Input/Output total control.
- Self-explaining alarm display.
- Installation and diagnostic help.
- Normal, dry run and blocked execution.

Operational language (Spanish, Italian, English, French, German, Portuguese, Turkish and Swedish)