



CNC Spark EDM

BED MOVEMENT COLUMN MOVEMENT



ADVANCED ENGINEERING
TAILORED FOR **EXCELLENCE**
MIRROR FINISH PRECISION

Redefining Precision and Performance



BERLIN



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ADVANCE SYSTEM FEATURES



Advanced Structural Design:

- Cow Head (RAM TYPE) Design with a fixed worktable.
- Box-Type Mainframe with multi-layer stiffener distribution.
- Wide Base & Symmetrical Bed for enhanced stability.
- Stress-Relief Aging ensures long-term precision.
- Ideal for processing large molds.



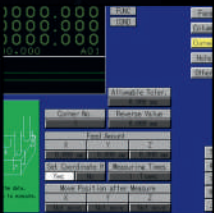
High-Quality Pulse Power Supply:

- High-Efficiency Pulse Power Supply: Ensures wide adaptability.
- Supports automated, high-quality discharge machining.
- Suitable for materials ranging from copper to graphite.



Advanced Servo Drive System:

- Full Digital AC Servo Drive: Panasonic (or equivalent) for high dynamic precision.
- Maintenance-Free with reliable performance.



Innovative CNC Discharge Control System:

- Integrated CNC Control System: Flexible and highly reliable.
- Proprietary Design: Developed with in-house intellectual property.
- Ensures stable discharge processing energy.



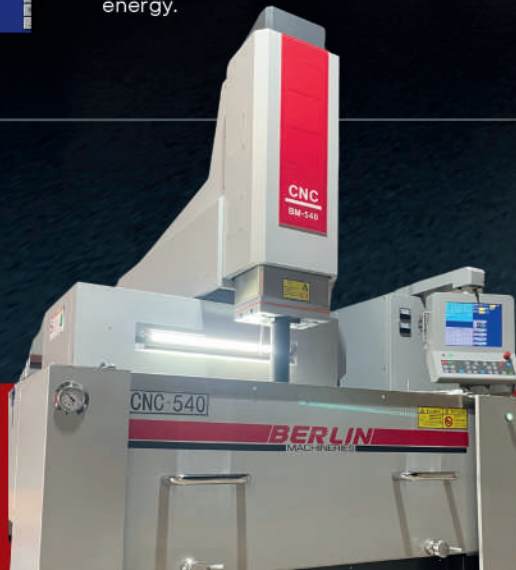
High-Precision Components:

- X, Y, Z NC Axes: Imported from Taiwan for superior quality.
- Equipped with HIWIN/PMI Precision Lead Screws and NSK Bearings.
- High-Standard Key Components ensure exceptional machine precision.



Efficient Design:

- Hand-Controlled Door: Space-saving pull-down design for the working fluid tank.
- Centralized Lubrication: Simplifies machine tool maintenance.



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COLUMN MOVEMENT

ADVANCE SYSTEM FEATURES

Multiple Cutting Modes

- Assist Cutting: Automatically optimizes cutting from rough to finish.
- Manual Cutting: Enables precise line, arc, thread, and spiral cutting.
- Multiple Cutting: Handles batch operations with random, lattice, and circular patterns.



Advanced Alignment Techniques

- Face Alignment: Aligns electrode with the workpiece surface.
- Column Center Alignment: Finds column or reference point centers.
- Corner Alignment: Aligns edges for angular machining.
- Hole Center Alignment: Positions for precise hole machining.
- Random 3-Point Alignment: For irregular or unique geometries.



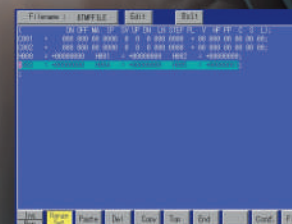
Discharge Control

- Advanced Waveform Settings: Enables precise material removal.
- Customizable Parameters: Adjust ON, OFF, IP, and PL for tailored machining.



Versatile Cutting Options

- Electrode Offset Adjustments: For intricate design precision.
- Configurable Programs: Tailored machining with user-defined settings.



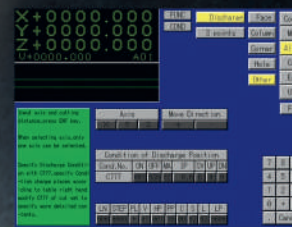
Customizable Parameters

- Wide range of machining configurations to suit different materials and tasks.
- Adaptability for various electrode materials like copper, graphite, and more.



Loran Function

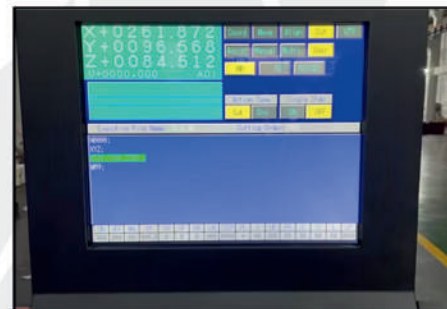
- The LORAN (Logical Operation of Rotation and Alignment) function in CNC EDM machines enhances machining versatility by enabling precise operations across multiple planes.



CONTROLLER SPECIFICATIONS

Controlled axis	3axis (5axis)
Communication port	USB,LAN
Display mode	15 inch LCD
Input mode	Touch screen/keyboard
Saving mode	SSD
Language	English (UK)
Driving type	Digital AC servo motor
Machining efficiency	300-500mm ³ /min
Electrode loss	≤0.1%
Optimal finish	Ra0.2

Minimum driving unit	0.001
Maximum feed speed	0.1m/min
Movement speed	5m/min
Speed of cutter lifting	10m/min
Processing electric current	50A
Fireproofing	Automatic control
Input power	3PH AC380/415V, 50-60Hz
Power supply cabinet size	1470*700*1960mm
Power supply cabinet weight	360kg
Total power input	9KVA



Important Note:

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SINGLE HEAD STRUCTURE

Item		Unit	BM-540	BM-650	BM-850	BM-1060	BM-1260	BM-1370
Work slot size (length * width * depth)		mm	1300*900*450	1600*980*540	1800*1100*570	2000*1300*600	2100*1300*600	2400*1340*700
Workbench (length * width)		mm	800*500*65	900*500*75	1150*600*100	1380*800*100	1400*800*100	1600*800*100
T-shaped slot on workbench (number of slots *width)		mm	3*12	3*12	3*14	5*18	5*18	5*18
Attachment mounting plate T-slot (number of slots* width)		mm	3*12	3*12	3*12	3*12	3*12	3*12
work travel x*y*z	X axis	mm	500*400*300	600*400*350	800*500*400	1000*600*400	1200*600*450	1300*700*450
Accessory mounting plate Distance to work surface		mm	350-650	450-800	500-900	550-950	600-1050	650-1100
maximum workpiece weight		kg	1800	2000	3000	4000	4000	4000
Maximum electrode weight		kg	100	150	180	200	200	200
Filter capacity		L	800	1100	1300	1800	1800	1500*2
Fuel tank size (length * width * height)		mm	1700*1500*450	1900*1600*510	2260*1650*510	2460*1900*550	2460*1900*550	1600*2100*600
Overall dimensions(length * width * height)		mm	2100*2650*2350	2450*2900*2600	2500*3050*3100	2800*3550*3120	2800*3550*3120	3300*4500*3250
Machine tool weight		kg	2800	3500	4800	5500	6000	9000

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DOUBLE HEAD STRUCTURE

Item		Unit	BM-1260		BM-1470		BM-1680		BM-1880	
Work slot size (length * width * depth)		mm	2000*1140*600		2400*1340*700		2800*1540*700		3300*1540*700	
Workbench (length * width)		mm	1200*600*100		1600*800*100		1700*1000*120		2000*1000*120	
T-shaped slot on workbench (number of slots * width)		mm	5*14		5*18		6*18		6*18	
Attachment mounting plate T-slot (number of slots * width)		mm	3*12		3*12		3*12		3*12	
work travel	X axis	mm	single	1200	single	1400	single	1600	single	1800
			double	600	double	850	double	1100	double	1200
	Y axis	mm	580		700		800		800	
	Z axis	mm	400		450		550		600	
Accessory mounting plate Distance to work surface	min	mm	320		650		550		600	
	max	mm	720		1100		1100		1200	
Maximum workpiece weight		kg	3000		4000		6000		7000	
Maximum electrode weight		kg	150		200		220		250	
Maximum liquid level of working oil tank		mm	500		600		600		600	
Filter capacity		L	1400		1500*2		1500*2		1500*2	
Fuel tank size (length * width* height)		mm	2460*1600*510		1600*2100*600*2pcs		1800*2000*600*2pcs		1600*2100*600*2pcs	
Overall dimensions (length * width * height)		mm	2500*3000*2550		3300*4500*3250		3850*4800*3550		3800*4900*3700	
Machine tool weight		kg	double 6800		single	9000	single	11000	single	13000
					double	10000	double	12000	double	15000

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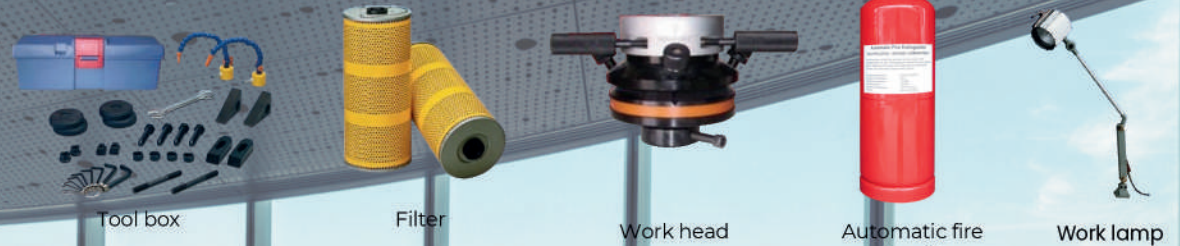
Item		Unit	BM-2180		BM-2510		BM-3510	
Work slot size (length * width * depth)		mm	3500*1800*750		3500*1800*750		4000*1800*750	
Workbench (length * width)		mm	2500*1200*120		2700*1200*120		3500*1200*120	
T-shaped slot on workbench (number of slots * width)		mm	6*18		6*18		6*18	
Attachment mounting plate T-slot (number of slots * width)		mm	3*12		3*12		3*12	
work travel	X axis	mm	single	2100	single	2500	double 2400	1600
			double	1400	double	1800		1100
	Y axis	mm	850		1000		1000	
	Z axis	mm	650		650		650	
Accessory mounting plate	min	mm	650		700		750	
Distance to work surface	max	mm	1300		1350		1400	
Maximum workpiece weight		kg	7000		10000		15000	
Maximum electrode weight		kg	250		300		300	
Maximum liquid level of working oil tank		mm	650		650		650	
Filter capacity		L	1500*2		1500*2		1500*2	
Fuel tank size (length * width* height)		mm	1600*2100*600*2pcs		1800*2000*600*2pcs		1800*2000*600 *2pcs	
Overall dimensions (length * width * height)		mm	4200*5100*3800		4850*5100*3900		5350*5100*3950	
Machine tool weight		kg	single	15000	single	17000	double 26000	11000
			double	17000	double	19500		12000

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STANDARD ACCESSORIES



OPTIONAL ACCESSORIES



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BED MOVEMENT CNC MIRROR EDM



MODEL	Unit	H30CNC	H35CNC	H40CNC	H45CNC
Work table size(L*W)	mm	600*400	600*400	700*400	700*400
X/Y/Z Axis travel	mm	300*210*270	350*250*270	400*300*300	450*350*300
Range of liquid surface	mm	50~292	50~292	50~292	50~292
Working liquid slot (L*W*H)	mm	940*600*360	940*600*360	1150*660*435	1200*680*450
Max.electrode weight	kg	25	50	50	80
Max workpiece weight	mm	400	400	600	600
Max/Min distance from plate electrode work table	mm	295~565	330~660	295~615	300~600
Positioning accuracy(JIS standard)	mm	5μm/100mm			
Repeat nositioning accuracy(JIS standard)	mm	2μm/100mm			
Tank capacity	L	400	400	600	600
Machine weight	KG	2000	2200	2500	3500
Outside dimension(L*W*H)	mm	1900*1900*2300	1900*1900*2300	2500*2500*2400	2500*2500*2400

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