



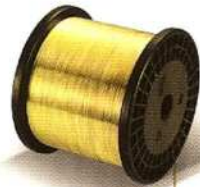
YUANCUT

High Performance EDM WIRES





High Performance EDM WIRES





EDM Cutting Wire

EDM Wire Cutting Requirement

- (1) Grain size uniform, good electric conductivity and well heat-ventilation.
- (2) Well and stable tensile strength.
- (3) Less power, well sparking.
- (4) Well feeding, easy operated.

Special Feature of YUAN CUT

(1) High quality in unify process

The high quality of wire's metallurgy was processing technology was by upward continuous casting. High purity of material was used to keep material stable and special elements were added to minimize the micro structure to have a high quantity maintain.

(2) Well property of sparking erosion

The wire was treated by continuous annealed, the grain size more uniform and the tensile strength more stable.

(3) Smooth surface

The wire surface was treated to reduce the wire creak, flaws and powder, it get higher efficiency while cutting.

(4) High dimension precision

The wire diameter was controlled under allowance within accuracy ± 0.001 m/m.

(5) Loading currency

The wire much straighten enhance the operated and feeding efficiency is suitable for automatic threading and feeding.

YUAN CUT

Type E

Brass C2700 (65/35), most popular material for EDM high speed cutting, Suitable for any brand of EDM machine. The wire tensile strength is 980-1080N/m².

Type B

Brass C2720, the wire surface was treaded to less the powder, it make much cutting speed, the speed efficiency is 10-15% higher than C2700, it is much suitable for Euro and Japanese EDM machine. The wire tensile strength is 1000-1100N/m².

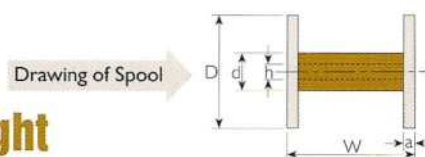
Type F

Elements added, much higher tensile, suitable for higher precision cutting and finer finishing, the speed efficiency is 20% more than C2700. The wire tensile strength is 1100-1200 N/m².



Wire Strength and Cutting

Hardness	Tensile Strength			Elongation %	Cutting Selection
	Kg / mm ²	N / mm ²	PSI		
Hard	> 100	> 980	> 14,400	< 2	Surface straighten cutting
Medium hard	60-70	≐ 650	≐ 9,400	< 5	Tape cutting under 10 degree
Soft	45-60	≐ 445	≐ 6,400	> 20	Tape cutting between 7~30 degree



Spool-Type, Size, Package and Wire Weight

Type	Wire Weight		Size (m/m)					Package
	Kg	lbs	a	w	d	D	h	
P-3	3.0	6.6	10	110	82	130	20	4# / ct.
P-5	5.0	11.0	12	114	90	160	20	4# / ct.
P-10	10.0	22.0	12	134	90	200	25	2# / ct.
P-15	20	44.0	15	140	110	250	34	1# / ct.
D-125	3.5	7.7	12	125	82	125	20	4# / ct.
D-160	6.5	14.3	15	160	100	160	22	4# / ct.
D-200	15	33.0	19	200	120	200	22	1# / ct.

Wire Diameter and Length in Spool

Diameter		Length in Spool (m)						
(m/m)	(inch)	P-3	P-5	P-10	P-15	D-125	D-160	D-200
0.10	0.004	44500	—	—	—	52000	—	—
0.15	0.006	19800	—	—	—	23100	—	—
0.20	0.008	11100	18670	37340	74680	13000	24200	56000
0.25	0.010	7200	12000	24000	48000	8400	15600	36000
0.30	0.012	—	8300	16600	33200	—	10790	16600

Products Code



Wire Strength:
Hard, Medium hard, Soft

Diameter(m/m):
0.10, 0.15, 0.20, 0.25, 0.30

Yuan Cut: **Type E** Most popular cutting
Type B Much speed cutting
Type F Speed, Precision, Finer cutting

Order selection:

Example:

Case 1. Need most popular cutting, hard wire, 0.25m/m
Select : **YEW-25H**

Case 2. Euro or Japanese EDM machine, need high speed cutting, hard wire, 0.20m/m
Select : **YBW-20H**

Case 3. Need high speed, precision, finer cutting, hard wire, 0.15m/m
Select : **YFW-15H**