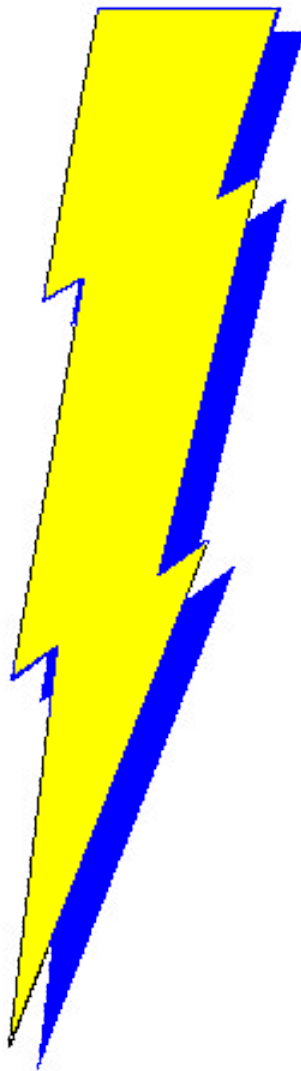
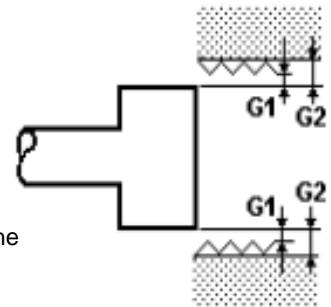


# NC SYSTEM



2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.



Note:

ALL THE INFORMATION IN THIS BOOK IS ONLY A REFERENCE DATA FROM OUR OWN TESTS.

THIS BOOK SHOULD ONLY BE USED AS A GUIDE FOR STANDARD / CORRECT OPERATION OF THIS MACHINE.

WE STRONGLY SUGGEST THAT THE OPERATOR OF THIS MACHINE MUST TEST RUN A FEW SETTINGS TO FAMILIARIZE HIMSELF TO THE MACHINE.

THE OPERATOR CAN DEVELOP HIS OWN BEST CHOICE OF SETTINGS FOR EACH JOB FROM HIS OWN EXPERIENCE AND THEREFORE BETTER RESULTS CAN BE ACHIEVED.

# ANOTRONIC LTD.™

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ANORONIC Maximart NC		Electrode	Copper			Workpiece	Steel	Polarity	+		
Amps	HV	On Time µs	Off Time µs	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2* G1		2* G2	
								mm	ins	mm	ins
0.35	100	10	12	50	15	1	<0.1	0.006	0.00024	0.007	0.00028
0.55	150	10	12	80	16	1	<0.1	0.007	0.00028	0.008	0.00031
0.7	200	10	12	140	17	1	<0.1	0.008	0.00031	0.009	0.00035
0.9	260	10	12	180	18	1	<0.1	0.009	0.00035	0.010	0.00039
1.2	200	10	240	50	19	2.9	0.1	0.010	0.00039	0.011	0.00043
1.2	200	16	240	50	20	2.7	0.1	0.010	0.00039	0.012	0.00047
1.2	200	26	240	50	21	2.5	0.2	0.010	0.00039	0.013	0.00051
1.2	200	40	240	50	22	2.2	0.2	0.015	0.00059	0.019	0.00075
1.2	200	66	350	50	23	1.8	0.3	0.020	0.00079	0.025	0.00098
1.2	200	100	350	50	24	1.4	0.3	0.030	0.00118	0.035	0.00138
1.2	200	160	350	50	25	1	0.4	0.040	0.00157	0.046	0.00181
2	200	10	140	50	20	3.6	0.2	0.028	0.00110	0.036	0.00142
2	200	16	140	50	21	3.3	0.2	0.029	0.00114	0.038	0.00150
2	200	26	140	50	22	3	0.3	0.034	0.00134	0.044	0.00173
2	200	40	140	50	24	2.6	0.3	0.040	0.00157	0.053	0.00209
2	200	66	240	50	26	2.2	0.4	0.044	0.00173	0.058	0.00228
2	200	100	240	50	28	1.6	0.4	0.047	0.00185	0.062	0.00244
2	200	160	240	50	30	1	0.5	0.050	0.00197	0.065	0.00256
3	200	10	50	40	27	14	0.3	0.044	0.00173	0.069	0.00272
3	200	16	50	40	28	12	0.3	0.047	0.00185	0.072	0.00283
3	200	26	50	40	29	10	0.4	0.050	0.00197	0.080	0.00315
3	200	40	50	40	30	7	0.4	0.055	0.00217	0.085	0.00335
3	200	66	140	40	31	5	0.5	0.060	0.00236	0.090	0.00354
3	200	100	140	40	32	4	0.4	0.065	0.00256	0.096	0.00378
3	200	160	140	40	33	3	0.4	0.070	0.00276	0.103	0.00406
3	200	240	140	40	34	1	0.3	0.075	0.00295	0.110	0.00433
6	200	10	12	30	28	18	2.5	0.050	0.00197	0.080	0.00315
6	200	16	12	30	29	16	2.8	0.053	0.00209	0.090	0.00354
6	200	26	12	30	30	14	3	0.055	0.00217	0.100	0.00394
6	200	40	12	30	31	12	3.2	0.060	0.00236	0.110	0.00433
6	200	66	12	30	32	10	3.4	0.065	0.00256	0.120	0.00472
6	200	100	50	30	33	7	3.6	0.070	0.00276	0.130	0.00512
6	200	160	50	30	34	4	3.8	0.080	0.00315	0.140	0.00551
6	200	240	50	30	35	3	4.1	0.090	0.00354	0.160	0.00630
6	200	340	50	30	36	1	4.2	0.100	0.00394	0.170	0.00669

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging. The OFF TIME should be adjusted longer to eliminate instability. Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.

ANORONIC Maximart NC		Electrode	Copper			Workpiece	Steel	Polarity	+		
Amps	HV	On Time µs	Off Time µs	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2* G1 mm	ins	2* G2 mm	ins
9	200	10	12	30	29	20	3.1	0.051	0.00201	0.080	0.00315
9	200	16	12	30	30	18	3.7	0.055	0.00217	0.090	0.00354
9	200	26	12	30	31	16	5	0.060	0.00236	0.100	0.00394
9	200	40	12	30	32	13	5.7	0.065	0.00256	0.110	0.00433
9	200	66	12	30	33	13	7.3	0.070	0.00276	0.120	0.00472
9	200	100	50	30	34	10	8.1	0.080	0.00315	0.130	0.00512
9	200	160	50	30	35	7	10	0.090	0.00354	0.150	0.00591
9	200	240	50	30	36	5	12	0.100	0.00394	0.170	0.00669
9	200	340	50	30	37	3	13	0.110	0.00433	0.180	0.00709
12	200	10	50	30	30	23	6	0.070	0.00276	0.120	0.00472
12	200	16	50	30	31	19	7	0.075	0.00295	0.130	0.00512
12	200	26	50	30	32	17	8	0.080	0.00315	0.140	0.00551
12	200	40	50	30	33	14	9	0.085	0.00335	0.150	0.00591
12	200	66	50	30	34	11	10	0.090	0.00354	0.160	0.00630
12	200	100	50	30	34	8	11	0.096	0.00378	0.170	0.00669
12	200	160	140	30	35	6	12	0.103	0.00406	0.180	0.00709
12	200	240	140	30	36	4	13	0.110	0.00433	0.190	0.00748
12	200	340	140	30	37	1.5	14	0.120	0.00472	0.210	0.00827
12	200	540	140	30	38	0.8	15	0.140	0.00551	0.230	0.00906
21	200	16	50	30	32	23	20	0.100	0.00394	0.150	0.00591
21	200	26	50	30	33	19	25	0.110	0.00433	0.160	0.00630
21	200	40	50	30	34	16	30	0.120	0.00472	0.170	0.00669
21	200	66	50	30	34	13	34	0.130	0.00512	0.180	0.00709
21	200	100	50	30	35	10	37	0.140	0.00551	0.200	0.00787
21	200	160	50	30	36	7	42	0.150	0.00591	0.220	0.00866
21	200	240	140	30	36	5	48	0.160	0.00630	0.240	0.00945
21	200	340	140	30	37	3	57	0.170	0.00669	0.260	0.01024
21	200	540	140	30	38	1	65	0.180	0.00709	0.280	0.01102
21	200	850	140	30	39	0.5	59	0.200	0.00787	0.320	0.01260
24	200	26	50	30	33	25	27	0.120	0.00472	0.180	0.00709
24	200	40	50	30	34	22	30	0.120	0.00472	0.190	0.00748
24	200	66	50	30	35	20	36	0.130	0.00512	0.200	0.00787
24	200	100	50	30	36	16	44	0.140	0.00551	0.220	0.00866
24	200	160	50	30	37	12	52	0.150	0.00591	0.240	0.00945
24	200	240	140	30	37	8	60	0.160	0.00630	0.270	0.01063
24	200	340	140	30	38	3	65	0.180	0.00709	0.300	0.01181
24	200	540	140	30	39	1	67	0.200	0.00787	0.360	0.01417
24	200	850	140	30	40	0.8	62	0.220	0.00866	0.400	0.01575

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging.

The OFF TIME should be adjusted longer to eliminate instability.

Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.

ANORONIC Maximart NC		Electrode	Copper	Workpiece		Steel	Polarity	+			
Amps	HV	On Time µs	Off Time µs	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2* G1		2* G2	
								mm	ins	mm	ins
36	200	26	50	30	34	27	29	0.130	0.00512	0.190	0.00748
36	200	40	50	30	35	22	33	0.130	0.00512	0.200	0.00787
36	200	66	50	30	35	18	41	0.140	0.00551	0.210	0.00827
36	200	100	50	30	36	15	52	0.150	0.00591	0.230	0.00906
36	200	160	50	30	37	10	76	0.160	0.00630	0.260	0.01024
36	200	240	140	30	38	7	88	0.170	0.00669	0.290	0.01142
36	200	340	140	30	39	4	99	0.190	0.00748	0.310	0.01220
36	200	540	140	30	40	1	105	0.210	0.00827	0.330	0.01299
36	200	850	140	30	41	0.8	98	0.230	0.00906	0.380	0.01496
36	200	1300	140	30	42	0.6	92	0.250	0.00984	0.410	0.01614
47	200	40	140	30	35	37	69	0.150	0.00591	0.220	0.00866
47	200	66	140	30	36	32	73	0.160	0.00630	0.240	0.00945
47	200	100	140	30	37	27	80	0.170	0.00669	0.260	0.01024
47	200	160	140	30	38	21	90	0.180	0.00709	0.280	0.01102
47	200	240	140	30	39	15	130	0.190	0.00748	0.300	0.01181
47	200	340	240	30	40	9	160	0.200	0.00787	0.320	0.01260
47	200	540	240	30	41	3	190	0.220	0.00866	0.360	0.01417
47	200	850	240	30	42	1	198	0.240	0.00945	0.400	0.01575
47	200	1300	240	30	43	0.8	200	0.280	0.01102	0.470	0.01850
96.2	200	40	50	30	40	60	70	0.190	0.00748	0.290	0.01142
96.2	200	66	50	30	41	50	100	0.210	0.00827	0.310	0.01220
96.2	200	100	50	30	41	42	140	0.230	0.00906	0.340	0.01339
96.2	200	160	50	30	42	34	190	0.250	0.00984	0.370	0.01457
96.2	200	240	50	30	43	26	250	0.270	0.01063	0.400	0.01575
96.2	200	340	140	30	43	18	300	0.290	0.01142	0.430	0.01693
96.2	200	540	140	30	44	11	314	0.330	0.01299	0.510	0.02008
96.2	200	850	140	30	45	7	312	0.400	0.01575	0.600	0.02362
96.2	200	1300	140	30	45	5	310	0.500	0.01969	0.780	0.03071

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging. The OFF TIME should be adjusted longer to eliminate instability. Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.

ANORONIC Maximart NC		Electrode	Graphite	Workpiece		Steel	Polarity	+			
Amps	HV	On Time µs	Off Time µs	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2* G1		2* G2	
								mm	ins	mm	ins
6	100	40	12	35	27	20	7.5	0.120	0.00472	0.140	0.00551
6	100	66	12	35	28	10	6.3	0.130	0.00512	0.160	0.00630
6	100	100	12	35	29	6	5.3	0.150	0.00591	0.180	0.00709
6	100	160	12	35	30	4	4.5	0.160	0.00630	0.200	0.00787
6	100	240	12	35	31	1	4.5	0.170	0.00669	0.210	0.00827
12	100	66	12	35	32	6	11.5	0.070	0.00276	0.120	0.00472
12	100	100	12	35	33	4	15.5	0.090	0.00354	0.150	0.00591
12	100	160	12	35	34	3	14	0.110	0.00433	0.170	0.00669
12	100	240	12	35	35	1	12.5	0.130	0.00512	0.190	0.00748
12	100	340	12	35	36	0.5	11.5	0.150	0.00591	0.230	0.00906
12	100	540	12	35	37	0.3	10	0.170	0.00669	0.300	0.01181
18	100	66	12	35	30	3	19.5	0.150	0.00591	0.190	0.00748
18	100	100	50	35	31	2.5	22.5	0.170	0.00669	0.220	0.00866
18	100	160	50	35	32	2	31.3	0.190	0.00748	0.240	0.00945
18	100	240	50	35	33	1	29	0.210	0.00827	0.290	0.01142
18	100	340	50	35	34	0.5	27	0.230	0.00906	0.320	0.01260
18	100	540	50	35	35	0.3	25	0.250	0.00984	0.350	0.01378
24	100	66	50	35	32	10	30	0.130	0.00512	0.215	0.00846
24	100	100	50	35	33	8	33.5	0.150	0.00591	0.230	0.00906
24	100	160	50	35	34	5.5	38	0.170	0.00669	0.260	0.01024
24	100	240	50	35	35	3	61	0.190	0.00748	0.290	0.01142
24	100	340	50	35	36	1	66	0.210	0.00827	0.320	0.01260
24	100	540	50	35	37	0.8	46.5	0.230	0.00906	0.350	0.01378
42	100	160	50	35	37	15	31	0.210	0.00827	0.300	0.01181
42	100	240	50	35	38	10	45	0.230	0.00906	0.320	0.01260
42	100	340	50	35	39	7	62.5	0.250	0.00984	0.370	0.01457
42	100	540	50	35	40	3	83	0.270	0.01063	0.400	0.01575
42	100	850	50	35	41	1	95	0.290	0.01142	0.450	0.01772
42	100	1300	50	35	42	0.5	105	0.310	0.01220	0.460	0.01811
45	100	160	50	35	42	1.5	107	0.270	0.01063	0.390	0.01535
45	100	240	50	35	43	1	120	0.290	0.01142	0.430	0.01693
45	100	340	50	35	44	0.8	112.5	0.300	0.01181	0.450	0.01772
45	100	540	50	35	45	0.5	100	0.310	0.01220	0.470	0.01850
45	100	850	50	35	46	0.5	90	0.330	0.01299	0.500	0.01969
45	100	1300	50	35	47	0.4	78	0.340	0.01339	0.520	0.02047

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging. The OFF TIME should be adjusted longer to eliminate instability. Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.

<b>ANORONIC Maximart NC</b>		<b>Electrode</b> Graphite		<b>Workpiece</b> Steel		<b>Polarity</b> +					
<i>Amps</i>	<i>HV</i>	<i>On Time</i> µs	<i>Off Time</i> µs	<i>Gap Volts</i>	<i>VDI</i>	<i>Wear Rate</i> %	<i>Removal Rate</i> mm <sup>3</sup> /min	<i>2* G1</i>		<i>2* G2</i>	
								mm	ins	mm	ins
95	100	160	140	35	43	20	138.8	0.290	0.01142	0.430	0.01693
95	100	240	140	35	44	15	163.5	0.330	0.01299	0.500	0.01969
95	100	340	140	35	45	5	172.5	0.400	0.01575	0.600	0.02362
95	100	540	140	35	46	4	187.5	0.430	0.01693	0.650	0.02559
95	100	850	140	35	48	3	202.5	0.500	0.01969	0.800	0.03150
95	100	1300	140	35	50	2	185	0.550	0.02165	0.900	0.03543
150	100	160	40	35	47	3	1300			0.840	0.03307
150	100	240	50	35	48	1.5	1200			0.970	0.03819
150	100	340	60	35	50	0.8	1100			1.040	0.04094
150	100	540	60	35		0.5	1000			1.130	0.04449
150	100	850	80	35		0.5	900			1.340	0.05276
150	100	1300	140	35		0.3	900			1.370	0.05394
200	100	160	40	35	48	3	1800			1.020	0.04016
200	100	240	50	35	51	1.5	1650			1.150	0.04528
200	100	340	60	35		0.7	1500			1.240	0.04882
200	100	540	80	35		0.5	1400			1.280	0.05039
200	100	850	80	35		0.5	1400			1.470	0.05787
200	100	1300	140	35		0.3	1300			1.570	0.06181

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging. The OFF TIME should be adjusted longer to eliminate instability. Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.

ANORONIC Maximart NC		Electrode	Graphite	Workpiece		Steel	Polarity	■			
Amps	HV	On Time µs	Off Time µs	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2* G1		2* G2	
								mm	ins	mm	ins
3	100	10	12	35	25	50	10.1	0.070	0.00276	0.120	0.00472
3	100	16	12	35	26	26	8.85	0.090	0.00354	0.130	0.00512
3	100	26	12	35	27	15	6.25	0.100	0.00394	0.140	0.00551
3	100	40	12	35	28	10	5.35	0.120	0.00472	0.170	0.00669
6	100	40	12	35	29	30	14	0.130	0.00512	0.170	0.00669
6	100	66	12	35	30	26	15.63	0.140	0.00551	0.190	0.00748
6	100	100	12	35	31	23.5	16.5	0.160	0.00630	0.210	0.00827
6	100	160	12	35	32	21	17.85	0.175	0.00689	0.230	0.00906
6	100	240	12	35	33	18	19	0.190	0.00748	0.250	0.00984
12	100	40	12	35	33	28	23.5	0.100	0.00394	0.160	0.00630
12	100	66	12	35	33	26	31	0.120	0.00472	0.180	0.00709
12	100	100	12	35	34	22	41.5	0.140	0.00551	0.220	0.00866
12	100	160	12	35	35	18	52	0.160	0.00630	0.260	0.01024
12	100	240	12	35	36	15.5	61	0.180	0.00709	0.300	0.01181
12	100	340	12	35	37	12	62.5	0.200	0.00787	0.330	0.01299
18	100	66	12	35	35	35	50	0.220	0.00866	0.280	0.01102
18	100	100	12	35	36	30	55	0.240	0.00945	0.330	0.01299
18	100	160	12	35	37	15	62.5	0.260	0.01024	0.360	0.01417
18	100	240	12	35	38	13	78	0.280	0.01102	0.400	0.01575
18	100	340	12	35	39	12	104	0.300	0.01181	0.440	0.01732
18	100	540	12	35	40	12	93.5	0.320	0.01260	0.460	0.01811
24	100	66	12	35	39	35	75	0.160	0.00630	0.220	0.00866
24	100	100	12	35	40	30	97	0.180	0.00709	0.300	0.01181
24	100	160	12	35	41	27	109	0.200	0.00787	0.320	0.01260
24	100	240	12	35	42	20	122.5	0.230	0.00906	0.480	0.01890
24	100	340	12	35	43	17	140.5	0.250	0.00984	0.510	0.02008
24	100	540	12	35	44	15	125	0.270	0.01063	0.530	0.02087
24	100	850	12	35	45	10	117.5	0.290	0.01142	0.560	0.02205
42	100	160	50	35	42	22	112.5	0.290	0.01142		
42	100	240	50	35	44	18	160.5	0.350	0.01378		
42	100	340	50	35	46	16	168.5	0.400	0.01575		
42	100	540	50	35	48	14	157.5	0.460	0.01811		
42	100	850	50	35	49	12	112.5	0.480	0.01890		
42	100	1300	50	35	50	10	97.5	0.560	0.02205		

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging.

The OFF TIME should be adjusted longer to eliminate instability.

Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.

ANORONIC Maximart NC		Electrode	Graphite	Workpiece		Steel	Polarity		■		
Amps	HV	On Time μs	Off Time μs	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2* G1		2* G2	
								mm	ins	mm	ins
45	100	160	50	35	44	25	168.7	0.320	0.01260		
45	100	240	50	35	46	22	200	0.380	0.01496		
45	100	340	50	35	48	19	207.5	0.440	0.01732		
45	100	540	50	35	50	14	200	0.480	0.01890		
45	100	850	50	35	51	13	168.7	0.510	0.02008		
45	100	1300	50	35	53	10	150	0.550	0.02165		

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging. The OFF TIME should be adjusted longer to eliminate instability. Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.





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