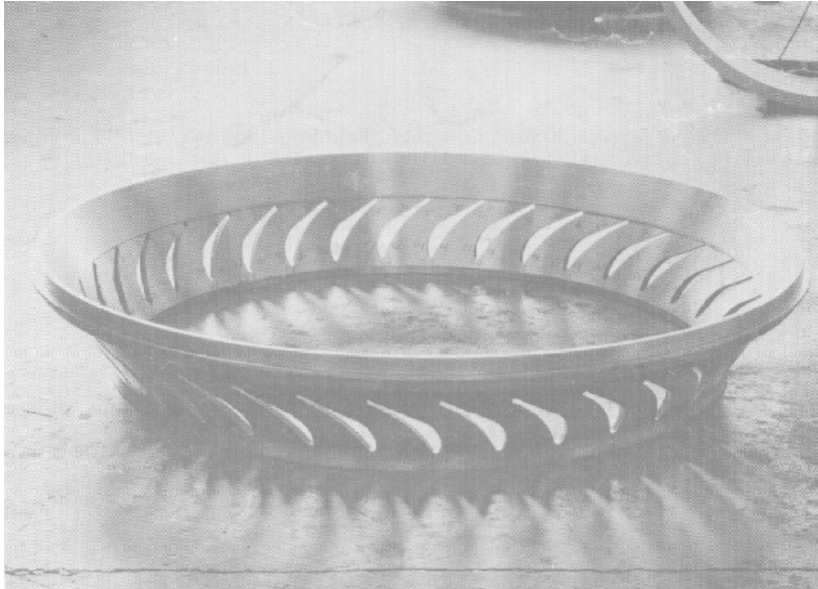


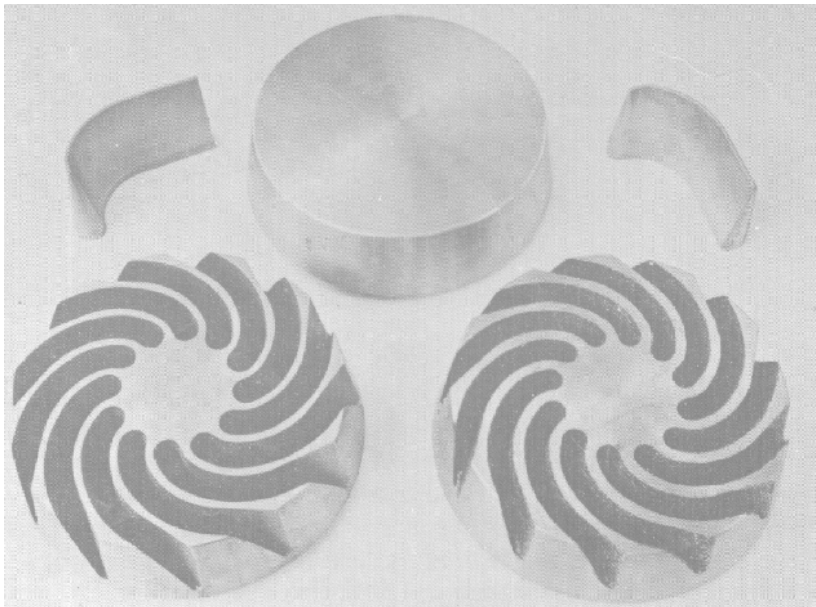
# EDM

electro discharge machining

## application bulletin



The ring shown is part of a steam turbine sub-assembly used to drive large electricity generating sets. The turbine assembly consists of the outer ring shown, an inner ring with similar shaped apertures and a set of blades which are welded into the apertures to form the assembly. These apertures are EDM'd



This picture shows the distinct machining stages in the manufacture of this part. The condition of supply is a plain circular disc approximately 12" diameter. Two discs are mounted on a fixture and all the slots in both components are eroded simultaneously. The bottom right hand view shows the condition of the component after the first stage of eroding together with the cast type of electrode used. The bottom left hand view shows the component after the second and last stage of eroding. Copy-milled graphite electrodes are used for the final operation. Even allowing for amortised electrode costs this component is only approximately half the cost of producing the component by milling on a multi-spindle machine.

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**AN11**