

ECM electro chemical machining

application bulletin

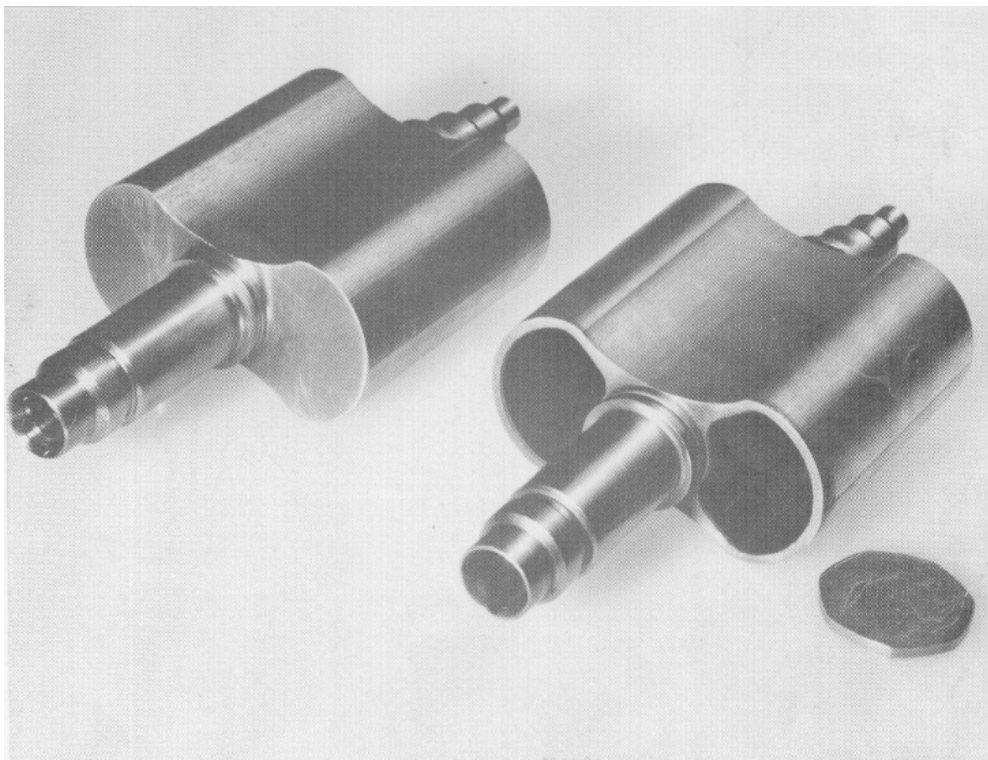
The problem of producing unusual shapes in difficult to machine materials has long troubled engineers. For these reasons Electro Chemical Machining (ECM) was adopted to produce the pockets in this rotor component made from stainless steel. Three operations are carried out on the components.

1. Producing the square blind hole in the centre.
2. Producing 2 off kidney shaped pockets simultaneously.
3. Adding a balancing relief within the pockets.

The square hole is produced by ECM in 10 minutes

The two kidney pockets are produced by ECM in 55 minutes

The relief is put in by ECM in 12 minutes



Rotor before ECM

Rotor after ECM

Previously, the two kidney shaped pockets alone took 8 hours to produce by conventional

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