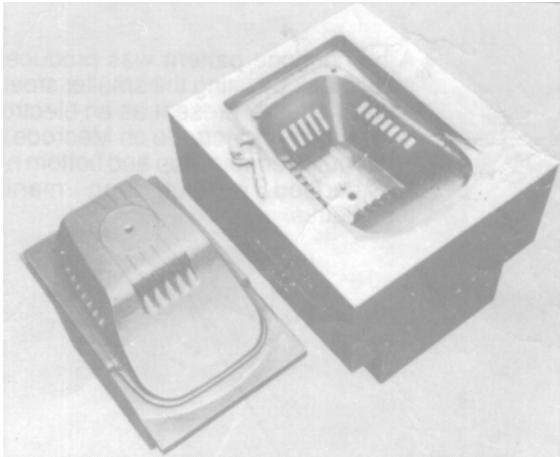
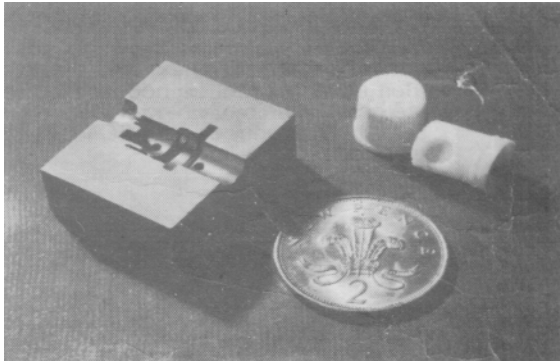


EDM electro discharge machining

application bulletin



A complete one piece bottom mould tool for an automatic tea maker body. Only EDM can produce such detail without using inserts. 3 complete electrodes similar to the one shown were used differing only in size to allow for different cutting gaps.



Most complex pattern glass moulds such as this one are now produced by EDM. Moulds used to have to be produced in two halves to allow for machining access and polishing. A one piece mould not only saves on time but eliminates evidence of the split line showing on the finished drinking glass.

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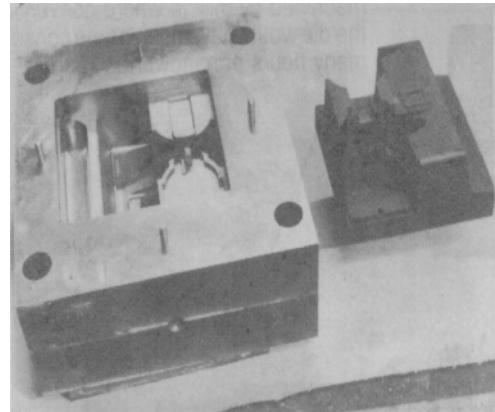
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The electrode and mould tool for producing a lawnmower motor cover. With only limited pre-machining using a 100mm diameter cutter, the mould tool was EDM'd with one roughing electrode and one finishing electrode. End wear was only 0,15mm on both electrodes.



One half of a plastic mould insert produced entirely by EDM. The coin and aerosol can buttons indicate the small size. The hemispherical aperture and slot at one end of the insert is the entry point for the molten plastic.

