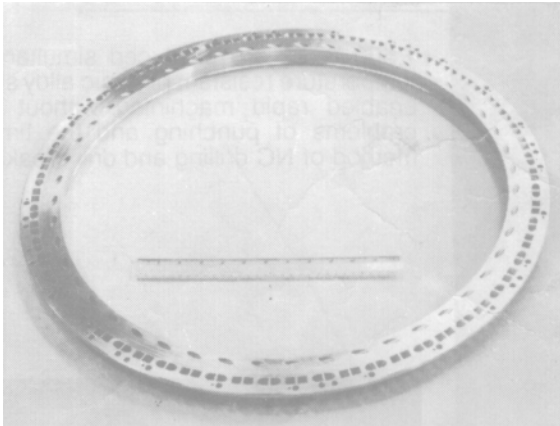


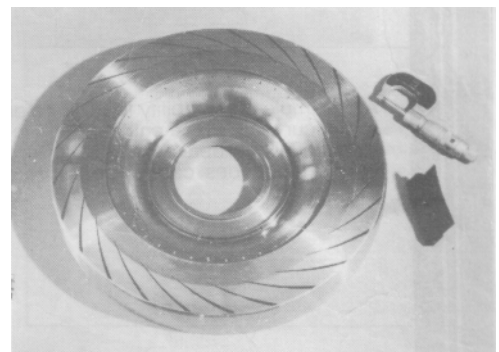
EDM electro discharge machining

application bulletin

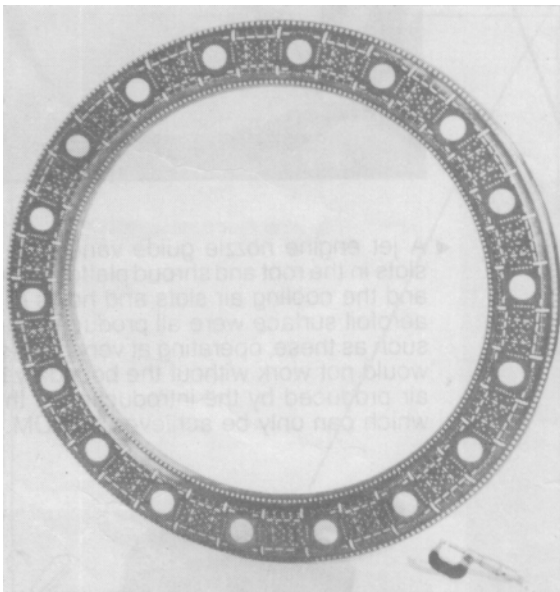


The slots and holes in this component are all angled to the surface at approx. 45° - a task easily performed by EDM. The angled holes and slots provide cooling air onto a high speed turbine disc.

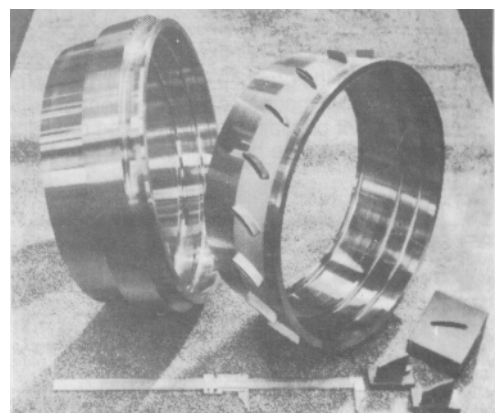
25 slots produced in a helicopter engine diffuser. A 0,05mm profile tolerance is held on the slots to enable a vane to be vacuum brazed in position. The slots narrow to 0,5mm wide.



A jet engine combustion chamber part. All holes and slots are produced in only 9 passes by using a multiple electrode set-up. Tool costs are relatively low compared to punching, and punch breakages on the angled side walls are eliminated.



An example of aerofoil stubs being produced using the reverse erosion technique. Hollow vanes are welded to the stubs in a later operation. EDM is more economical than NC milling on these complex 3D shapes.



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