

How to make good use of the machining database?

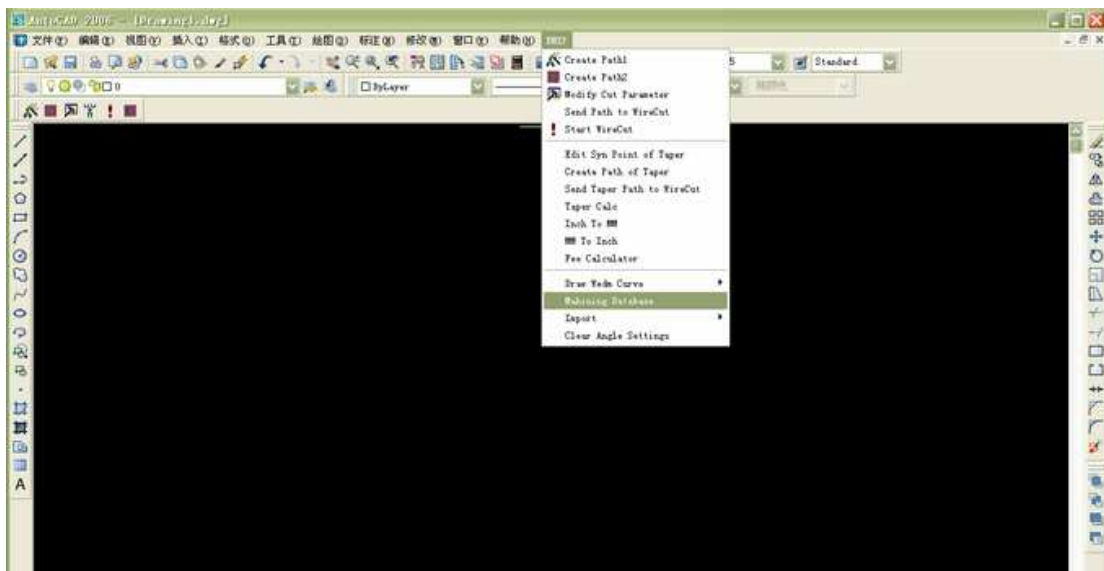
1. What do the main parameters mean?

- 1.) **Pon** means the machining time. If **Pon** is larger, the machining speed is faster, and roughness is worse.
- 2.) **Poff** means the time for the water to dash the metal chips out between the two machining times. So if **Poff** is larger, the machining speed is lower but the roughness is better.
- 3.) **IP** means the number of the power- tubes. If **IP** is larger, the current is larger and the machining speed is faster, however the roughness is worse and it is easier for the wire to be broken at the same time.

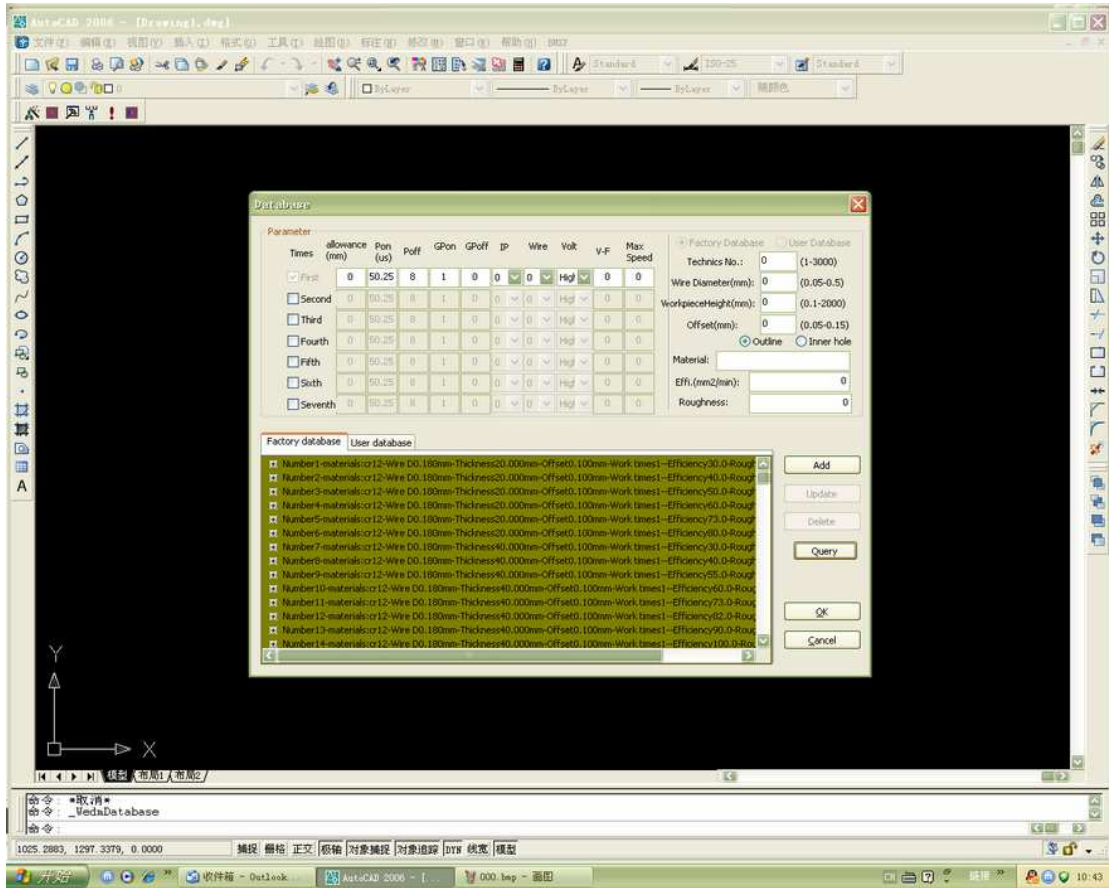
2. There is one database of 3000 groups' parameters in our BMXP software for your reference. And you can add new database to it too.

A. For 1 time cutting: Firstly, you need to check the database according to the workpiece such as material, thickness and clients' requirement about the efficiency and roughness. Please refer to Picture1, 2 and 3. Secondly, you use the parameters during machining.

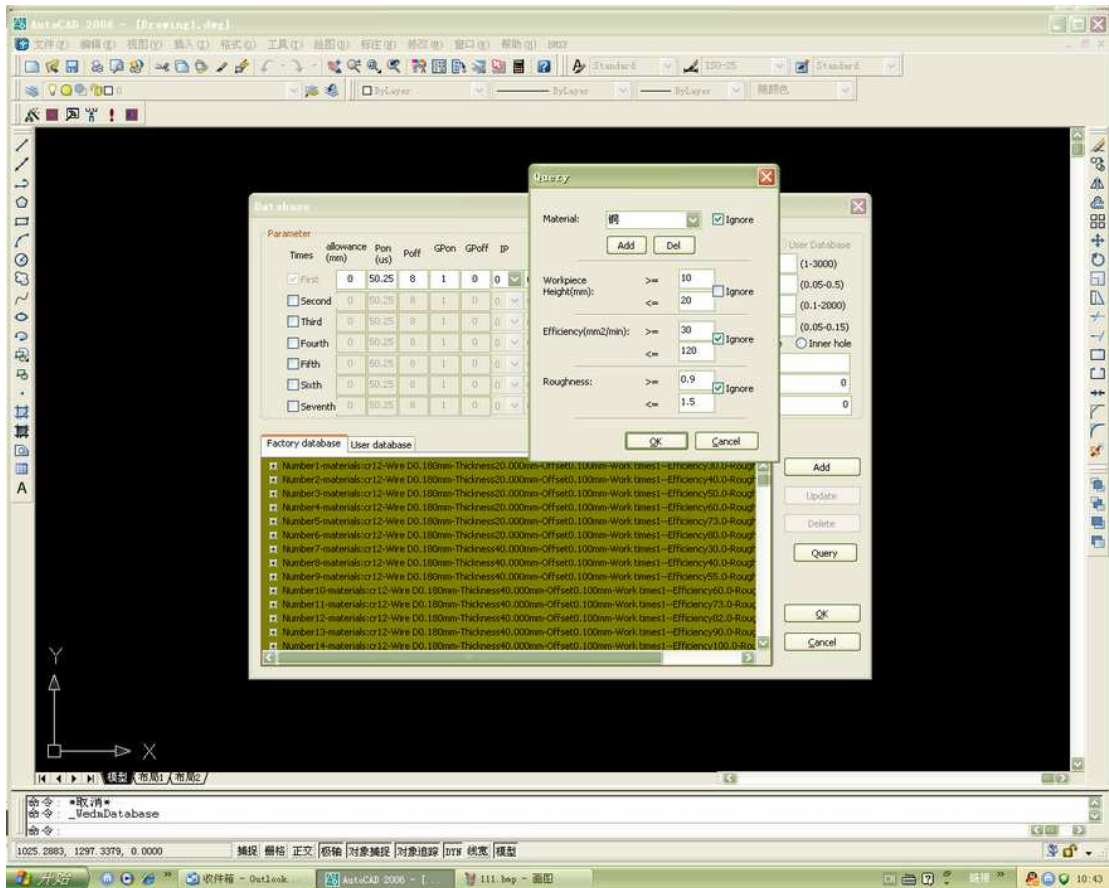
Picture 1



Picture 2



Picture3:



B. For mutual cutting:: You can use the database during the machining: Please refer to the following pictures:

