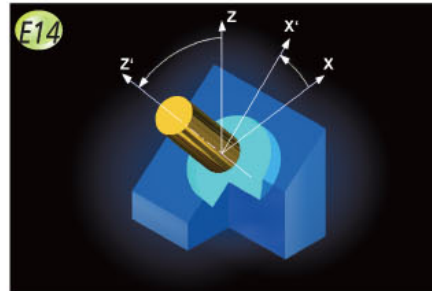
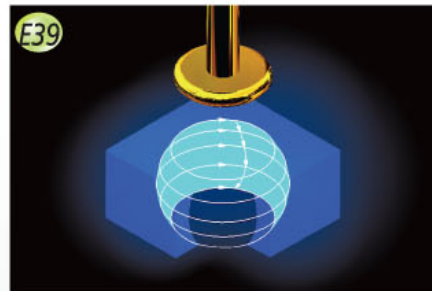
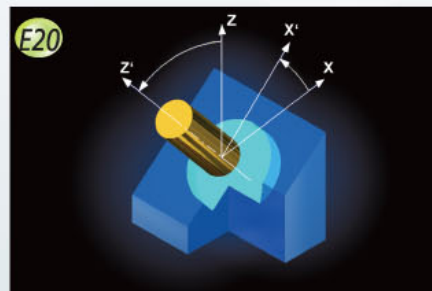


SPECIFICATION OF E CODE FUNCITON


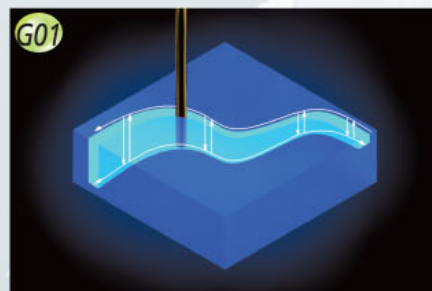
Work-piece slanted at 45 degree, the Electrode could able to do orbiting sparking at 45°Ramp accordingly.



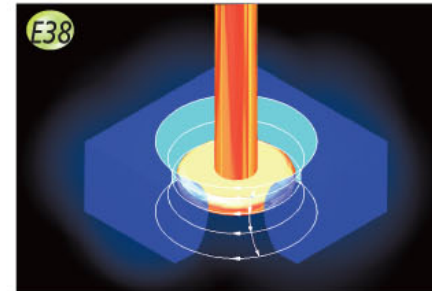
An interior global processing, Z- axis do stepwise sparking in harmony, X,Y axes act arc circular motion on its radius.



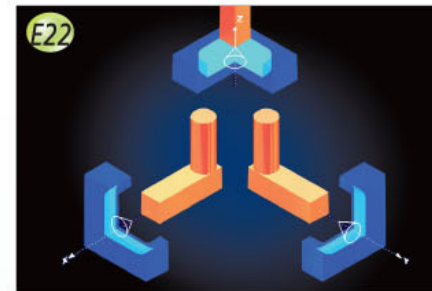
Electrode Depth lock-up, X,Y axes do orbiting sparking.



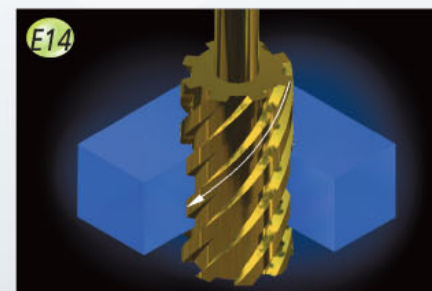
GM Code Edition mode : It's available to use GM code to do contouring job on 3D trajectory synchronization.



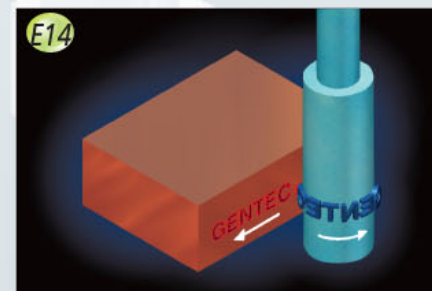
An exterior global processing, Z-axis do stepwise sparking in harmony, X,Y axes act arc circular motion on its radius.



Orbiting sparking, could act 3 axes in six directions moving along with rotation.



Z-axis sparking with C-axis equipment to act screws Threading, Spiraling jobs.



X,Y axes sparking with C-axis to act rollaway molds jobs.

SPECIFICATIONS

| Machine body | CM 323C | CM 434C | CM 655C | CM 865C | CM 1065C | CM 1265C |
|--|--|--------------------------------|---------------------------------|---------------------------------|-----------------------------------|-----------------------------------|
| Table size (WxD) | mm/inch 500x350/19.7x13.8 | 650x400/25.5x15.7 | 900x600/35.4x23.6 | 1200x800/47.2x31.5 | 1200x800/47.2x31.5 | 1500x800/59.1x31.5 |
| Work tank size (WxDxH) | mm/inch 820x500x300/ 32.3x19.7x11.8 | 1050x630x350/ 41.3x24.8x13.8 | 1450x950x550/ 57.1x37.4x21.7 | 1600x1000x550/ 63x39.4x21.7 | 2100x1200x600/ 82.7x47.2x23.6 | 2500x1350x700/ 98.4x53.1x27.5 |
| Table travel (X, Y) | mm/inch 300x200/11.8x7.9 | 400x300/15.7x11.8 | 600x500/23.6x19.7 | 800x600/31.5x23.6 | 1000x600/39.4x23.6 | 1200x600/47.2x23.6 |
| Ram travel (Z1) | mm/inch 300/11.8 | 350/13.8 | 500/19.7 | 500/19.7 | 500/19.7 | 500/19.7 |
| Distance from RAM platen to work table | mm/inch 250-550/9.8-21.7 | 250-600/9.8-23.6 | 300-800/11.8-31.5 | 290-790/11.4-31.1 | 450-950/17.7-37.4 | 500-1000/19.7-39.4 |
| Max. electrode weight | kg / lb 60/132 | 100/220 | 300/660 | 300/660 | 300/660 | 300/660 |
| Max. workpiece weight | kg / lb 500/1100 | 1000/2200 | 3000/6600 | 4000/8800 | 5000/11000 | 7500/16500 |
| Outside dimensions | mm/inch 1200x1350x2250/ 47.2x53.1x88.5 | 1240x1380x2230/ 48.8x54.3x87.8 | 2000x2230x2685/ 78.7x87.8x105.7 | 2200x2400x2860/ 86.6x94.4x112.5 | 2600x2600x3050/ 102.3x102.3x120.1 | 3000x2700x3200/ 118.1x106.2x125.9 |
| Weight (kg) | 1000/2200 | 1400/3080 | 3500/7700 | 4500/9900 | 6500/14300 | 8500/18700 |
| For Dielectric | D323 | D434 | D655 | D865 | D1065 | D1265 |

| Power Supply Unit | 50N | 75N | 125N | 150N |
|------------------------|-----------------|--------------|----------------------------|----------------------------|
| Max. machining current | A 50 | 75 | 125 | 150 |
| Max. power input | KVA 4 | 5 | 9 | 10 |
| Max. machining speed | mm3/min 350 | 550 | 900 | 1050 |
| Electrode wear rate | % 0.2 | 0.2 | 0.2 | 0.2 |
| Best surface roughness | µm/Ra 0.45 | 0.45 | 0.45 | 0.45 |
| Outside dimensions | mm 620x850x1860 | 620x850x1860 | 620x850x1860 +450x470x1650 | 620x850x1860 +450x470x1650 |
| Weight | kg/lb 180/396 | 220/484 | 400/880 | 440/968 |

| Dielectric | D323 | D434 | D655 | D865 | D1065 | D1265 |
|--------------------|---------------------|--------------|-----------------------------|---|---|---|
| Volume | L 280 | 390 | 1290 | 1550 | 2100 | 3500 |
| Filter | method Paper filter | Paper filter | Paper filter | Paper filter | Paper filter | Paper filter |
| Power | HP 0.5 | 0.5 | 0.5x1 1x1 | 0.5x1 1x1 | 0.5x1 1x1 | 0.5x2 1x1 |
| Weight | kg/lb Built in | 80/176 | 220/484 | 250/550 | 350/770 | 450/990 |
| Outside Dimensions | mm Built in | 1400x800x430 | 2200x1000x520 +1600x800x520 | 2750x1000x480 +1200x700x480 +1200x700x480 | 3000x1000x480 +1450x500x480 +1450x500x480 | 3000x1500x580 +1800x630x580 +1800x630x580 |

* Note: The manufacturer reserves the right to modify the design for specifications, mechanisms, ...etc. to improve the performance of the machine without notice, all the specifications above are just for reference.

PREPARING FOR INSTALLATION

| | | | |
|-------------|---|------------------------|--|
| Input power | AC220V ± 10% 3 Phase 50/60Hz ± 1Hz | Space | Take notice of the space for machine stroke to move during normal operation and daily maintenance. |
| Location | 1. Optimum room temperature: 20 ± 1°C. 2. Humidity: below 75% RH. 3. Best with minimum possible floor vibration. 4. Avoid exposing the machine to airflow from air-conditioning/heating systems or set in a place that received directly sunshine. 5. Locate machine in a low dust environment. | Grounding | 1. It is recommended to have a grounding resistance of 10Ω or less. 2. An independent ground is recommended. 3. The grounding cable should be 14mm². |
| | | Demand of air pressure | Air pressure of 6kg/cm² for options of ATC and C axis is needed. |

STANDARD ACCESSORIES:

- Paper filter ----- 1set
- Clamping kits ----- 1set
- Tool box ----- 1set
- Flushing nozzle ----- 2sets
- Machine stand ----- 1set
- Drill chuck ----- 1set
- Electrode holder ----- 1set
- Halogen work lamp ----- 1set

OPTIONAL ACCESSORIES:

- Fire extinguisher
- Magnetic base
- Tool changer
- C axis
- CE Conformity


CHMER_{EDM}
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CNC SERIES

 IT'S VERY WELL
MADE IN TAIWAN

National Award

Rising Star Award


CM 655C+75N
CHING HUNG MACHINERY & ELECTRIC INDUSTRIAL CO., LTD.

FEATURES OF CNC SERIES

COMPLETE FUNCTIONS EASY OPERATION

- ◆ Closed-loop linear scales feedback on X, Y and Z axes for precise positioning and cutting accuracy.
- ◆ Dialog programming to automatically select optimum machining conditions based on electrode size and material, work piece type, depth of cut and desired surface finish.
- ◆ E codes (canned orbit cycles) for commonly used modes i.e., side machining, square, vectoring and circular enlarging, tapering, etc.
- ◆ Automatic edge and center finding, and Z reference location.
- ◆ 3-axis linear, 2-axis arc, 3-axis spiral and 4-axis contouring offset movement.
- ◆ 15" TFT with graphics, 3 1/2" FDD, RS232.
- ◆ Sub-programming.
- ◆ 999 Z-axis automatic machining depths.
- ◆ 99 sets of working parameters available from database-operator changeable.
- ◆ Lower wear power supply with fast metal removal.
- ◆ Automatic return to center and back-up function to respond to arcing conditions.

OPERATION INTERFACE

- ◆ Friendly operation with quick start manual to shorten the operator training hours and increase operator efficiency.

FEATURES

- ◆ Stable, cast construction.
- ◆ Dialog control system.
- ◆ High precision ballscrews on X, Y, Z.
- ◆ Linear guideways X, Y, Z.
- ◆ Anti-arc circuitry

REMOTE CONTROLLER FUNCTION

- ◆ Easy operation on X, Y, Z, and C axis movement via remote controller.
- ◆ Temporary stop and continue executing function.
- ◆ ON/OFF pump.



EASY CNC OPERATION

S CODE FUNCTION

- ◆ Built-in working conditions applicable for different workpieces and electrodes for most efficient machining.
- ◆ 200 sets of working conditions edition and memory store. Convenient for downloading during operation.
- ◆ Working conditions can be changed and saved in memory during cutting.

AUTO EDIT FUNCTION

- ◆ Friendly conversation window available. Suitable working conditions easily and quickly come up by just keying in electrode and work piece material, sparking current and desired surface roughness.
- ◆ Working depth will be automatically adjusted by controller after changing sparking depth for ideal working condition.

E CODE FUNCTION

- ◆ Unique CHMER E code function to achieve 3 axis simultaneous machining without complicated G, M codes.
- ◆ Different E codes available for different working applications.
- ◆ Friendly E code illustration for operator to understand E code machining before and during the cut.



CM 323C+50N



CM 434C+50N



CM 865C+75N



CM 1065C+150N

A-SERIES

FEATURES

- ◆ Comply with CE conformity, Bridge design to fit heavy workpieces with small footprint.
- ◆ Linear glass scale with close-loop control system for consistent precision over time.
- ◆ Friendly dialogue PC BASED CNC controller for easy operation.
- ◆ Intelligent CNC editing, working program is made automatically after inputting electrode and workpiece materials, and size of electrode. Prevent arcing from finish machining, known with APC protection circuit.



CM A53C+50N

SPECIFICATIONS

| Machine body | Unit | CM A43C | CM A53C | CM A64C |
|--|-----------|---------------------------------|-----------------------|---------------------------------|
| Table size (WxD) | mm / inch | 650X 400 / 25.6x 15.7 | 800X 500 / 31.5x 19.7 | |
| Work tank siz (WxDxH) | mm / inch | 1100x 640x 400 | 43.3x 25.2x 15.7 | 1420x 740x 450 55.9x 29.1x 17.7 |
| Table travel (X, Y) | mm / inch | 400x 300 / 15.7x 11.8 | 500x 350 / 19.7x 13.8 | 600x 400 / 23.6x 15.7 |
| Ram travel (Z) | mm / inch | 300 / 11.8 | 350 / 13.8 | 350 / 13.8 |
| Distance from RAM platen to work table | mm / inc | 320- 620 | 300- 650 | 300-650 |
| Max. electrode weight | kg / lb | 60 / 132 | 100 / 220 | 100 / 220 |
| Max. workpiece weight | kg / lb | | 1000 / 2200 | 1500 / 3300 |
| Outside dimensions | mm / inc | 1910X1800X2800/ 75.1X70.8X110.2 | | 2185X1950X2370 86.1X76.7X93.3 |
| Weight | kg / lb | 2150 / 4730 | 2200 / 4840 | 3000 / 6600 |
| For Dielectric | | DA43 | DA53 | DA64 |

| Power Supply | Unit | 50N | 75N |
|------------------------|----------------------|-------|----------------------------|
| Max. machining current | A | 50 | 75 |
| Max. power input | 220/440 Volts | 4 KVA | 5 KVA |
| Max. machining speed | mm ³ /min | 350 | 550 |
| Electrode wear rate | % | | 0.2 |
| Best surface roughness | µm/Ra | | 0.45 / 0.2 (microfinish) |
| Outside dimensions | mm | | Built in |
| Weight | kg | | Built in |

| Dielectric | Unit | DA43 | DA53 | DA64 |
|--------------------|--------|------|--------------|---------|
| Volume | L | 440 | 480 | 850 |
| Filter | method | | Paper filter | |
| Power | HP | | 0.5 | 0.5 x 2 |
| Weight | kg | | Built in | |
| Outside Dimensions | mm | | Built in | |

* Note: The manufacturer reserves the right to modify the design and specifications, to improve the performance of the machine without notice, all the specifications above are just for reference.

