

MINT SERIES ELECTRIC DISCHARGE MACHINE



Features

- Very low power consumption
- Like-to-like machining
- Carbide cutting
- Precision screw for x, y axes
- Reverse servo sparking
- Multistage anti-arc in-built
- Reverse polarity for every operation
- DC servo with speed-up function -NC version
- AC servo with speed-up for ZNC - 2Mtr./min
- LM guideways for X, Y, axes

Applications

- Plastic moulds
- Die-casting dies
- Forging dies
- Carbide dies
- Coining dies
- Engraving dies



Pioneers of EDM



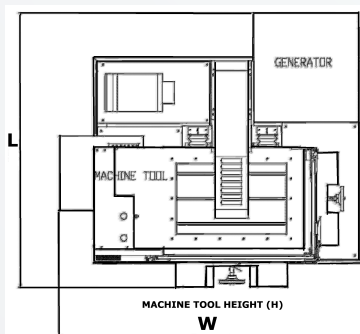
Technical Specifications

Machine Tool	Mint - 55/55Z	Mint - 60/60Z	Mint - 60Z Plus
Work tank size	800 x 500 x 350 mm	1000 x 600 x 400 mm	1000 x 600 x 400 mm
Work table size	550 x 350 mm	600 x 400 mm	600 x 400 mm
T slots for fixing	3 of 10 mm	3 of 10 mm	3 of 10 mm
Longitudinal travel (X)	300 mm	400 mm	400 mm
Transverse travel (Y)	200 mm	300 mm	300 mm
Quill travel (Z)	250 mm	250 mm	250 + 200 mm
Max. permitted load on the table	500 kg	800 kg	800 kg
Max. electrode weight	50 kg	50 kg	50 kg
Max. height above the table	250 mm	300mm	300mm
Servo system (Z axis)	DC servo / AC servo for ZNC	DC servo / AC servo for ZNC	DC servo / AC servo for ZNC
Filter element	10 µ paper filter	10 µ paper filter	10 µ paper filter
Pulse Generator			
Max. working current	35 + 2 Amp	50 A	50 A
Max. MRR (Copper to Steel)*	240 mm ³ /min.	350 mm ³ /min.	350 mm ³ /min.
(Graphite to Steel)*	300mm ³ /min.	500 mm ³ /min.	500 mm ³ /min.
Min. electrode wear	< 0.2 %	< 0.2 %	< 0.2 %
Surface finish*	0.8 µ Ra / 0.3 µ Ra for ZNC	0.8 µ Ra / 0.3 µ Ra for ZNC	0.8 µ Ra / 0.3 µ Ra for ZNC
Connected load	4 kVA	6 kVA	6 kVA
Power supply	3 phase, 415 V * AC , 50 Hz	3 phase, 415 V * AC , 50 Hz	3 phase, 415 V * AC , 50 Hz
Dielectric Unit			
Dielectric capacity	400 Litres	500 Liters	500 Liters
Filter element	10 µ Paper filter	10 µ Paper filter	10 µ Paper filter

* Alternate voltage ratings available on request

Precision Co-ordinate Table

- Table made from close-gained casting to ensure structural stability
- Independent locking of slides, free from transverse forces Trapezoidal screw on z axis



Long-life Machine Tool

- Box type construction with rectangular cross-section and heavy ribbing duly stress-relieved
- Highly deflection-resistant with excellent dynamic and static rigidity
- High-accuracy quill running on pre-loaded cross-roller bearings

Safety Interlocks

- Input supply over-voltage / under-voltage cut-off
- Low level safety shut-off (LL)
- Preset depth (PSD)
- Z Limit Switch

FLOOR PLAN

MODEL	L	W	H
MINT 55/55Z	1450	1550	2300
MINT 60/60Z	1650	1630	2300
MINT 60/60Z PLUS	1650	1630	2600

*Dimensions in mm

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Poddar Group

In keeping with our constant endeavour to meet ever-changing market needs, we reserve the right to alter or change the specifications mentioned without prior notice.

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