

**“EQUIPMENT INSTALLATION AND SERVICING”
Japax Wire EDM**

Specific items to review with customer prior to sale and/or before shipment of equipment.

1. Recommended location and environmental requirements (IDEAL):

- A. Separate room-isolated from general shop area and other fine chip and dust generating equipment, oily fumes and machining fluid mists.
- B. Air conditioned area, temperature 70 degrees F. (± 2 degrees). If general parts manufactured by customer are large in size and/or require dimensional tolerances less than 0.0005", temperature control is necessary to minimize the affect of:
 - 1) Part material-temperature coefficient of expansion.
 - 2) Stabilization of EDM equipment to ambient temperature, 4 hours.
- C. No direct sunlight from outside windows.
- D. No direct heating or cooling air blowing on machine or controls.
- E. Vibration free area:
Locate machine away from high vibration or shock producing equipment. (i.e. forging hammers, punch presses, frequently used railroad tracks)

It is the customers responsibility to spot and level equipment, have power to the machine, water or oil available for dielectric system.

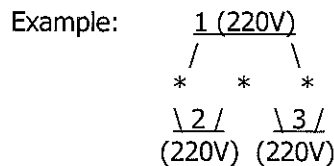
2. Power Requirements:

A. Specific requirements:

- 1) Check and record for the input line voltage variations.

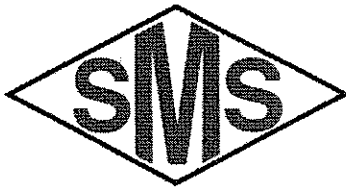
POWER REQUIREMENTS:

220 VAC (+5% /-5%) / 3 Phase; 6 KVA Rating, 50/60 Hz Main Breaker
Power at the wall from Fuse Breaker



Please Measure all there (3) Legs Phase to Phase.

(1) _____ (2) _____ (3) _____



- 2) Avoid any "in-house" high current drawing machines or equipment on the same buss line. (i.e. press, electrical furnace, welding etc.)
- 3) Can separate line be installed for machine.
- 4) Installation of individual fusible disconnect for each machine.
- 5) Provide separate earth ground isolated from building electrical ground.
- 6) Do you require Phase Converter (YES) or (NO)

Recommend copper or brass rod 3/4 inch diameter by 6 feet long driven into suitable moist soil. Locate ground rod close to input transformer.

B. Line voltage variation:

If line to line voltage variation at input to machine transformer exceeds +/- 5%, we recommend that an automatic voltage regulator be considered.

C. Affects of line voltage variation:

- 1) Voltage increase
- 2) D.C. gap voltage – increase
- 3) Machining speed Bascon 1 – increase.
- 4) Overcut – decrease.
- 5) May result in plating in workpiece gap, causing poor flushing and electrode breakage.

3. Dielectric Fluid Requirements:

A. Start up: Use distilled or deionized water 5-10 gallons. Add tap water as required to bring conductivity control reading within desired limits. Or, if preferred, use Jems 180 as the dielectric fluid.

4. Airline Requirements:

* Need 90-100 PSI With Air Dryer / Regulator at the Machine

5. Consumables:

Have you ordered?

	YES	NO
FILTERS:		
WASHABLE	___	___
THROW AWAY	___	___
RESIN:	___	___
WIRE:	___	___
GUIDES: (SIZE)	___	___
FREOX (RUST PREVENTATIVE):	___	___
HAND HELD CONDUCTIVITY METER:	___	___
WATER: DISTILLED/DEIONIZED	___	___
RS232 PORT	___	___
TRANSFORMER:	___	___

