

ED-203

CHEVALIER®

ELECTRIC DISCHARGE MACHINE



■ **Both table & saddle** travel on hand scraped one V, one flat Turcite B guideways with precision leadscrew, external table locks to ensure accurate positioning and smooth operation.

■ **Workhead** travels on SCHNEEBERGER anti-friction linear needle rollers guideways that is driven by DC servo motor for precise positioning, smooth movement, and high working efficiency.

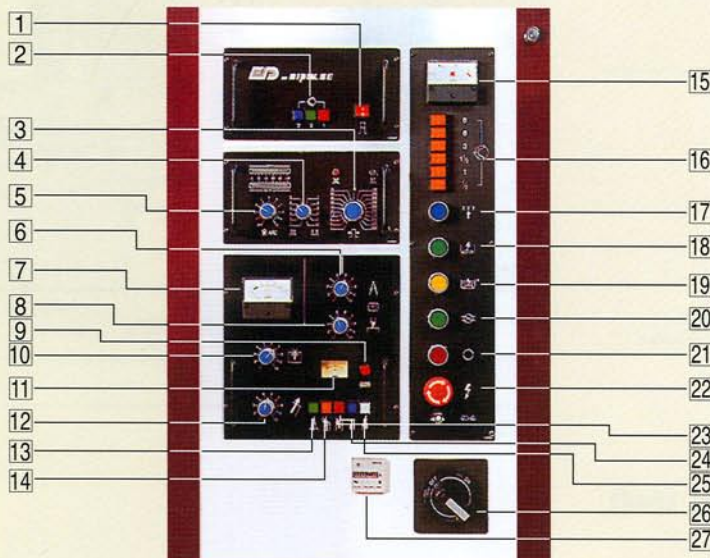
■ **Multi flushing system**(pressure,vacuum) ensures adequate dielectric fluid circulation.

■ **Four standard safety devices** are provided to prevent accidents. The safety devices are:

- Dielectric temperature sensor
- Dielectric level control
- Temperature detector with automatic fire extinguisher and power shut-off
- Photo cell detector with automatic fire extinguisher and power shut-off

■ **Control panel** layout is designed for ease of operation and maintenance. An ARC prevention circuit is utilized to prevent the accumulation of exhausted carbon from the workpiece surface. A digital servo-control is utilized to accurately control a DC servo motor for quick response and reduce vibration during machining.

CONTROL PANEL



1. High voltage current on/off switch
2. High voltage current selection
3. On time
4. Off time
5. DC ARC protection
6. Ram cycler up time
7. Gap voltage indicator
8. Ram cycler down time
9. Buzzer on/off switch
10. Gap voltage selector
11. Servo speed indicator
12. Servo speed selector
13. Pulse flushing(option)
14. Dither mode selector
15. Average current indicator
16. Ampere selection
17. Day/eve switch
18. Current on/off switch
19. Float bypass switch
20. Dielectric on switch
21. Dielectric off switch
22. Emergency stop switch
23. Ram lock(for orbiting)
24. Ram rapid traverse on
25. Ram cycler on/off
26. Main power supply switch
27. Run hour meter

SPECIFICATIONS

DESCRIPTION	ED-203
Work tank volume(WxDxH)	24 ^{-13/16} "x16 ^{-1/8} "x9 ^{-13/16} "(630x410x250mm)
Work table area(LxW)	19 ^{-11/16} "x9 ^{-13/16} "(500x250mm)
Travel(X,Y Axes)	9 ^{-13/16} "x5 ^{-7/8} "(250x150mm)
Distance between working table and electrode holder plate	3 ^{-15/16} "-17 ^{-11/16} "(100-450mm)
Machine head stroke(W Axis)	5 ^{-7/8} "(150mm)
Quill stroke (Z Axis)	5 ^{-7/8} "(150mm)
Max. electrode load	88 lbs(40kgs)
Max. workpiece weight	660 lbs(300kgs)
Dielectric reservoir	116 gal(440ℓ)
Max. process current	20A (30A)
Max. power consumption	3KVA(4KVA)
Max. working speed (20A) (30A)	0.83 in ³ /hr 2.6 oz/hr 0.98 in ³ /hr 4.26 oz/hr
Best surface roughness	RA 0.3-0.5 RMS 14-21 *RA 0.2-0.3 RMS 8-14
Machine dimensions(WxDxH)	54 ^{-5/16} "x51 ^{-3/16} "x86 ^{-5/8} "(1380x1300x2200mm)
Weight:Net weight approx. Gross weight approx.	1760 lbs(800kgs) 2200 lbs(1000kgs)
Packing dimensions(WxDxH)	60"x54"x89"(1520x1370x2260mm)

*Machine equipped with optional super finisher.

STANDARD ACCESSORIES

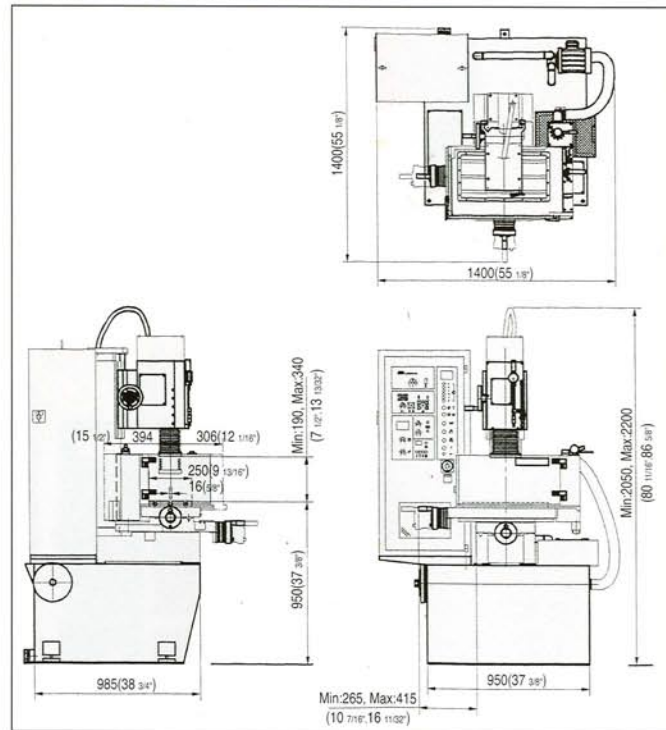
- 1.Nozzle(2)
- 2.Clamping screw(2)
- 3.Allen keys
- 4.Clamping plate(2)
- 5.Nuts(2)
- 6.Open end wrench
- 7.Chuck
- 8.Fixed support(2)
- 9.Workhead
- 10.Auto fire extinguisher

SPECIAL ACCESSORIES

- 1.Digital readout
- 2.C. P. box
- 3.Super finisher
- 4.Permanent magnetic chuck
- 5.Orbit-cut system
- 6.System 3R tooling

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

DIMENSIONAL DRAWING



DISTRIBUTOR:

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