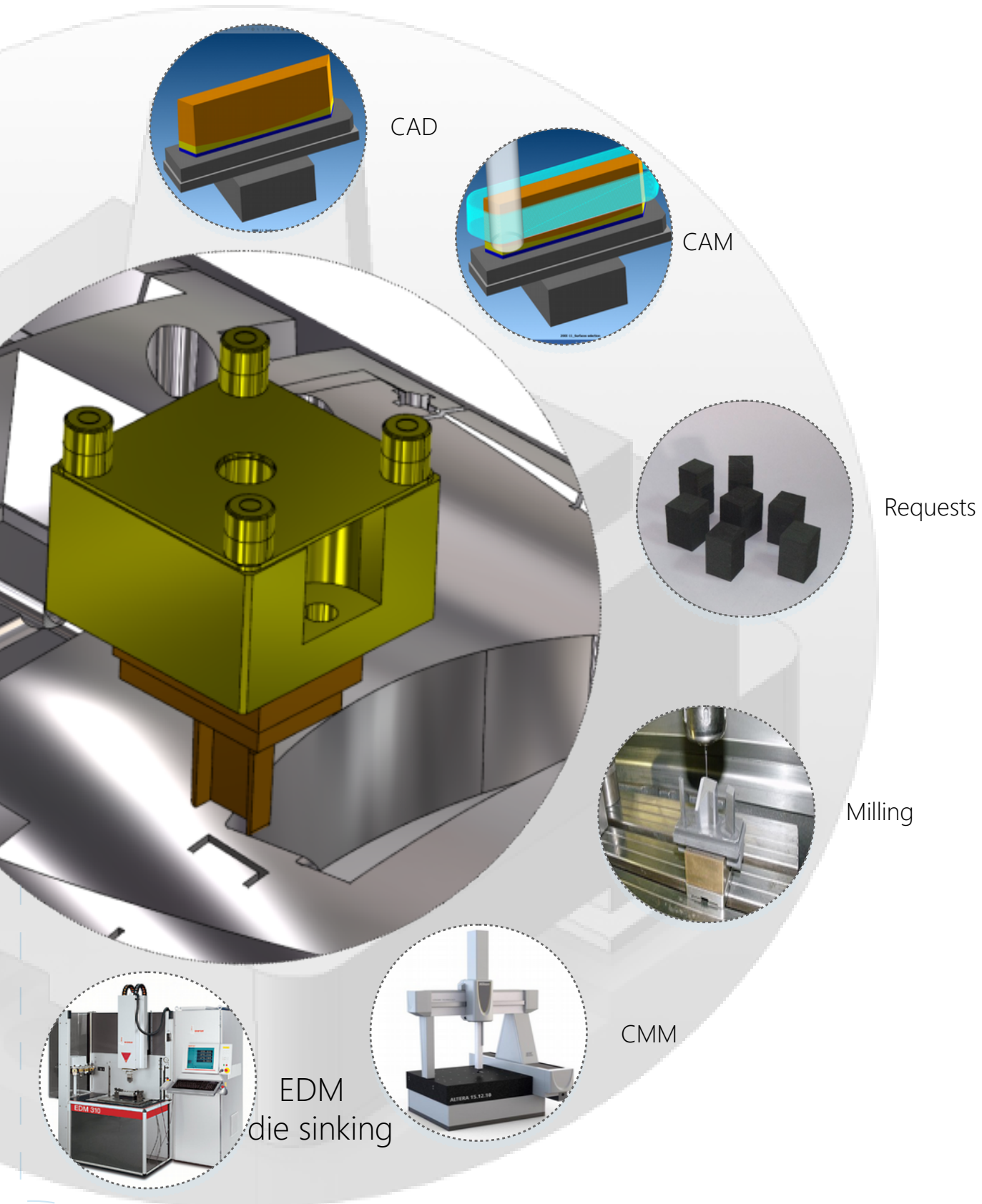
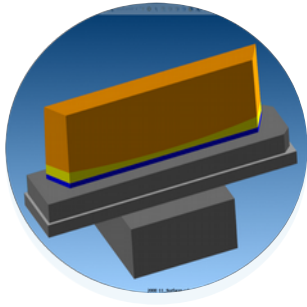




ElectroDB / PLM

Electrode Life Cycle Management
Automatic programming of EDM die sinking machines

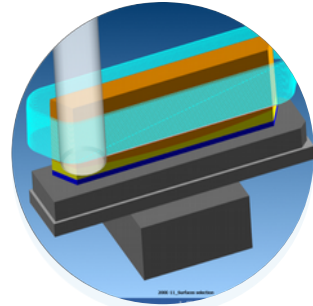




CAD

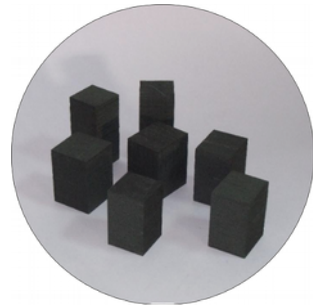
The electrodes are imported from CAD systems (Mastercam, Cimatron, TopSolid, PowerShape, WorkNC, etc.)

- Can include position XYZC, dimensions of raw material, gap, type of material, images, etc.



CAM

Identify already programmed electrodes and record individual programs of each electrode



Requests

Material Management / Stocks (raw material blocks in Copper or Graphite)

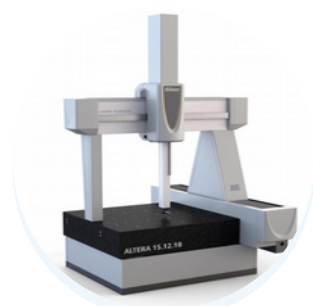
- When ordering the blocks of raw material, it allows grouping of same size electrodes, and controls the state (Requested / Received) of each electrode.



Milling

Generate programs for milling with palletizing system.

- Simulation of collisions in the electrode assembly on the palletizing system.
- Print electrode labels



CMM

Dimensional control of the electrode

- Allows to control electrode height, gap, and deviations in X, Y, Z, C
- Import measurement data from measuring machines (CMM ou manual)
- Validation of measured values through tolerances



EDM die sinking

Automatic programming of EDM die sinking machines

- Machines: Charmilles, AGIE, ONA, Sodick, Exeron, JSEDM, etc.
- Simulation of collisions in the assembly of the electrodes palletizing system





ElectroDB / PLM

Electrodos

Obra/Molde: 1350 Peça: 200 Electrodo: [dropdown] Reordenar Ver apenas não Prog: Fresa Erosão Ver Todos Elect. Molde Reordenado

| Electrodo | Material | Gap | Num | Duplo 1 | Z.Justai | CAD | CAM | Requisi | Recebi | Fresag | OQ | OK | Prograr | GapMedic | CorrX | CorrY | Ang.CorrC | CorrZ | Z.Subs.Hol | Lista |
|-----------|----------|------|-----|--------------------------|--------------------------|-------------------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|--------------------------|----------|-------|-------|-----------|-------|------------|-------|
| 200E-1 | G | 0,1 | 1 | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | | | | | | | 1,2,3 |
| 200E-1 | G | 0,1 | 2 | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | | | | | | | 1,2,3 |
| 200E-1 | G | 0,15 | 2 | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | | | | | | | 1,2,3 |
| 200E-1 | G | 0,3 | 1 | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | | | | | | | 1,2,3 |
| 200E-1 | G | 0,15 | 1 | <input type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | <input type="checkbox"/> | | | | | | | 1,2,3 |

200E-1 G : 0.1 : 1

Teste-coment-Geral

Notas Operadores

Editar Electrodo

Electrodos CAD CAM Req/Stocks Fresagem Metrologia Erosão

Não verificar conclusão das operações nas secções anteriores

| N.Pt | Sele | Pos. X | Pos. Y | Pos. Z | Pos. Ang. | Comentario |
|------|-------------------------------------|--------|--------|--------|-----------|------------|
| 1 | <input checked="" type="checkbox"/> | -65.5 | -88.3 | 20.61 | 0 | |
| 2 | <input checked="" type="checkbox"/> | -95.5 | -88.3 | 20.61 | 0 | |
| 3 | <input checked="" type="checkbox"/> | -125.5 | -88.3 | 20.61 | 0 | |
| 4 | <input checked="" type="checkbox"/> | -155.5 | -88.3 | 20.61 | 0 | |
| 5 | <input checked="" type="checkbox"/> | -65.5 | 88.3 | 20.61 | 180 | |
| 6 | <input checked="" type="checkbox"/> | -95.5 | 88.3 | 20.61 | 181 | |
| 7 | <input checked="" type="checkbox"/> | -125.5 | 88.3 | 20.61 | 180 | Pt 6 |
| 8 | <input checked="" type="checkbox"/> | -155.5 | 88.3 | 20.61 | 180 | |

Refresh Aberto 25 PDF G RS232

Medir Pontos : 1241 / 200 / K-03 / G / Gap=0.4 / N1 : E:\EDB\Import\Metrologia\PCDMIS\Molden\1241-200-xp-K-03

| Ponto : Face | X | Y | Z | XM | YM | ZM | Gap |
|--------------|-------|--------|------|---------|---------|--------|--------|
| 1 | -41.5 | 23.0 | 61.0 | -41.497 | 23.0 | 57.389 | -0.2 |
| 2: X+1 | 42.0 | 11.75 | 57.0 | 41.808 | 11.748 | 56.999 | -0.208 |
| 3: X+2 | 42.0 | -11.75 | 57.0 | 41.813 | -11.753 | 56.999 | -0.208 |
| 4: Y+1 | 21.0 | -23.5 | 57.0 | 20.998 | -23.318 | 57.0 | -0.202 |
| 5: Y+2 | -21.0 | -23.5 | 57.0 | -21.002 | -23.31 | 57.002 | -0.202 |
| 6: X-1 | -42.0 | -11.75 | 57.0 | -41.769 | -11.746 | 57.0 | -0.202 |
| 7: X-2 | -42.0 | 11.75 | 57.0 | -41.775 | 11.751 | 57.002 | -0.202 |
| 8: Y+1 | -21.0 | 23.5 | 57.0 | -20.996 | 23.274 | 57.0 | -0.202 |
| 9: Y+2 | 21.0 | 23.5 | 57.0 | 21.004 | 23.27 | 57.001 | -0.202 |

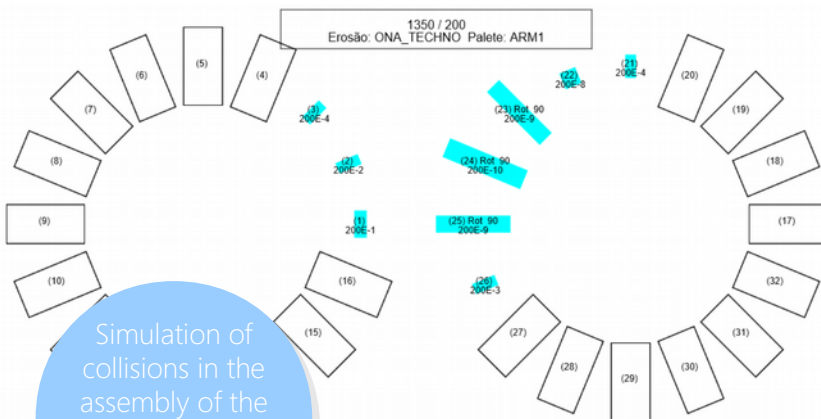
| Facas | Gap Pt1 | Gap Pt2 | Angulo |
|-------|---------|---------|---------|
| X+ | -0.192 | -0.187 | 90.012 |
| X- | -0.231 | -0.225 | 90.015 |
| Y+ | -0.226 | -0.23 | 179.995 |
| Y- | -0.182 | -0.19 | 179.989 |

| Dim Faces X | Dim Faces Y | Rotação | Gaplado |
|-------------|-------------|---------|---------|
| Teorico | 84.0 | 47.0 | 0.0 |
| Calculado | 83.582 | 46.586 | -0.008 |

| Desvio Cent. | dX Inc | dY Inc | dC Inc | Z | Gap total |
|--------------|--------|--------|--------|--------|-----------|
| | 0.02 | 0.022 | -0.008 | 57.389 | 0.416 |

Alt.Z 57,389 Gap 0,416 Corr.X 0,02 Corr.Y 0,022 Corr.C -0,008 PROG2 ADMIN 2017-07-10 17:45:54

Measuring report



Simulation of collisions in the assembly of the electrodes palletizing system

- 1 %
- 2 G54X0
- 3 M80
- 4 M06X1
- 5 G00Z119.500
- 6 M80
- 7 G00X-65.500Y-88.300C0.000
- 8 M40
- 9 G00Z108.875
- 10 G17
- 11 G69X37U3W6
- 12 G11X80.260F40
- 13 G69X35U3W6
- 14 G23X80.240
- 15 G69X34U3W6
- 16 G23X80.220
- 17 G69X33U2W6
- 18 G23X80.200
- 19 G69X32U2W6
- 20 G23X80.190
- 21 G69X31U2W6
- 22 G23X80.180
- 23 G69X29U2W6
- 24 G23X80.170
- 25 G69X27U1W6
- 26 G23X80.160
- 27 G69X25U1W6
- 28 G23X80.150

EDM Program



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