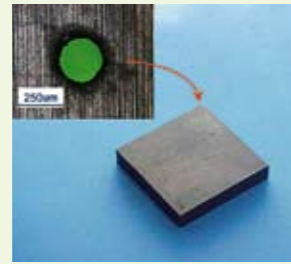




Start Hole Drilling

A start hole for wire cut EDM can be easily and quickly made by the K1C. Neither specialised skills nor experience are required to work with the machine.



Through machining

Workpiece material: Cemented carbide
 Workpiece thickness: 10 mm (through hole)
 Electrode material: Copper pipe
 Dielectric fluid: Water
 Electrode diameter: ø 0.2 mm
 Machining time: 3 min 38 sec

Wide Range of Cutting Conditions

In order to cover potentially limitless demands from customers, Sodick offers a wide range of cutting conditions.

Workpiece: SKD11, WC, Aluminum, Copper, Stainless Steel, Graphite
 Material thickness: 10, 20, 50, 100mm
 Electrode diameter: 0.25, 0.30, 0.50, 1.0, 2.0, 3.0mm



Through-hole

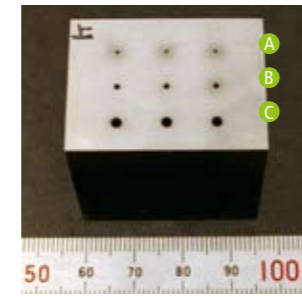
Workpiece material: WC
 Workpiece thickness: 20 mm
 Electrode material: Cu pipe
 Dielectric fluid: Water
 Electrode diameter: ø 0.6 mm, 5 min
 ø 1.0 mm, 6 min
 ø 2.0 mm, 7 min
 ø 3.0 mm, 6 min

K3HN Options

- Column up (100/ 200mm)
- 30A booster (electrode up to ø6.0mm)
- Rotary table
- Oscilloscope

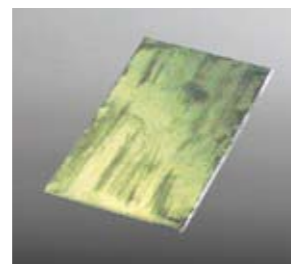
Through-hole Cutting

Workpiece material: STAVAX
 Workpiece thickness: 20mm
 Electrode material: Cu pipe
 Electrode diameter: A ø 0.5 mm, B ø 1.0 mm, C ø 2.0 mm
 Dielectric fluid: Oil (VITOL-KS)
 Cutting time: A 40 seconds, B 40 seconds, C 1 min 40 sec
 Electrode wear rate: A 146% per hole, B 80% per hole, C 58% per hole



AEF

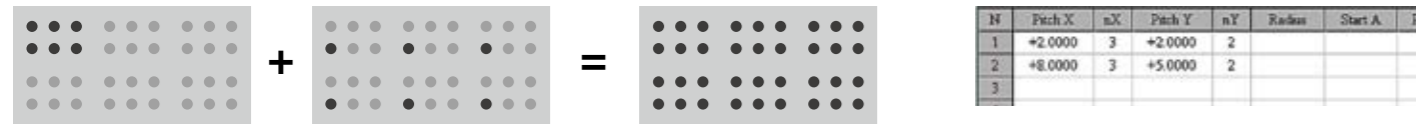
AEF (Automatic Electrode Feeder) comes equipped as standard on the K3HN. It enables continuous cutting with several electrodes.



Through machining

Workpiece material: SUS316
 Workpiece thickness: 0.8 mm (through hole)
 Electrode material: Copper pipe
 Dielectric fluid: Water
 Electrode diameter: ø 0.3mm
 Machining time: 5 sec

Easy to Make Cutting Programmes Without Any Difficult Calculations

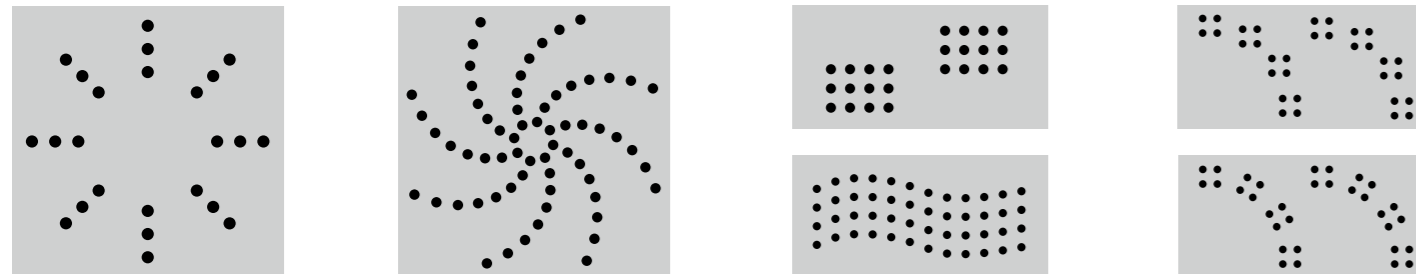


only by inputting basic pattern

and positioning pattern

easy to get a complete and complex cutting programme with two programming steps only

Even complex layouts with a large number of holes can be programmed easily!



Specification

Specification	K1C	K3HN	K1BL	K3BL
Table size (WxD)	250 x 350 mm	400x450mm	200 x 250 mm	600x300 (ceramics) mm
X- Y- Z-axis travel	200 x 300 x 300 mm	300 x 400 x 300 mm	120 x 150 x 300 mm	300 x 200 x 300 mm
W-axis travel	250 mm	230 mm (NC control: option)	160 mm	250 mm
Max. workpiece weight	100 kg	200 kg	50 kg	300 kg
Max. workpiece size (WxDxH)	250 x 350 x 300 mm	400 x 450 x 300 mm	240x290x95	height: 160 mm
Applicable electrode diameter	ø 0.2 ~ ø 3.0 mm	ø 0.25 ~ ø 3.0 mm	ø 0.08 ~ ø 0.25 mm	ø 0.08 ~ ø 3.0 mm
Distance from guide bottom to table top	50 ~ 300 mm	70 ~ 300 mm	60 ~ 220 mm	60 ~ 310 mm
Distance from the floor to table top	1,020 mm	900 mm	910 mm	810 mm
Machine dimensions (WxDxH)	890 x 870 x 2,015 mm	1,425 x 1,120 x 2,080 mm	1,600 x 1,530 x 2,305 mm	1,130 x 1,645 x 2,360 mm
Machine installation space (WxD) (not including maintenance space)	1,600 x 1,750 mm	1,425 x 1,620 mm	2,700 x 2,900 mm	1,820 x 2,255 mm
Machine weight	550 kg	850 kg	990 kg	1,500 kg
Air pressure	-*	0.5 MPa/30 NL/min	0.5 MPa	0.5-0.6 MPa
Total power input	3phases 50/60Hz 3.3 kVA	3phases 50/60Hz 4.0 kVA	3phases 50/60Hz 3.3 KVA	3-phase 200/220V 0.75 kw
Work Tank size (WxDxH)	-	-	400 x 510 x 200 mm	774 x 639 x 270 mm
Dielectric fluid	Water (VITOL-KS)	Water (VITOL-KS)	VITOL-V2 (oil-based)	VITOL-V2(oil-based)
Dielectric tank total capacity	20 litre	110 litre	172 litre	245 litre
Dielectric fluid filtration method	Replaceable sponge filter	Replaceable paper filter HF-17	Replaceable sponge filter	Replaceable paper filter (MF-2400, Pressurised)
Linear Motor	-	-	Standard on Z axis	Standard on Z axis
Operation	Manual	NC Control	NC Control	NC Control
Automation	Not available	AEF (Automatic Electrode Feeder)	AEC (Automatic Electrode Changer)	ATC18/ AEF+ATC15
30A booster (up to ø6.0mm electrode available)	Available as option	Available as option	Not available	Not available
Rotary Table	Not available	Available as option	Not available	Not available
LN Assist	Not available	Standard Feature	Standard Feature	Standard Feature

*= K1C has no Air pressure, no work tank. K3HN has no Work Tank.
 Due to ongoing research, specifications are subject to change without prior notice.



K-Series

High Speed Small Hole Drilling Machines

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