



NASTA-TECH

Middle speed wire cut EDM

GZ-AS Series

NASTATECH STUDIO CO.

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GZ-AS AC series uses the body base of brass wire EDM machine, the movement wire concept of high speed machine and the filter type of brass wire EDM machine. The working accuracy and the finish both achieve the effect of brass wire EDM machine, large area processing without jumping line phenomenon and flatness phenomenon, it is the only product to replace brass wire EDM machine.

The product is widely used in: part manufacturing, automobile die, aluminum shape mold, military scientific research units etc.

This series is combined the structure of Swiss brass wire EDM machine and the Japanese high frequency discharge power supply.

Equipment sheet metal streamline is strong, the appearance is simple and generous, in line with the CE certification, body structure uses brass wire EDM machine base, Panasonic AC servo motor drive, accuracy and processing efficiency can be comparable with brass wire EDM machine.

The equipment is suitable for high precision, high finish customer, is widely used in European and American enterprises, large state-owned enterprise, precision institute, military industrial enterprise, universities, etc.

Spare parts



Gem guide wheel



water plate



conductive block



guide wire mouth (eye mask)

Machine body parameters					
Model	Unit	32GZ-AS	40GZ-AS	50GZ-AS	63GZ-AS
Overall size (about)	mm	1800*1700*1900	2000*1800*1900	2500*1900*2000	2900*2000*2400
Machine Weight (about)	kg	2000	2500	3000	3800
Max. Taper/work piece thickness		±6° /80mm(optiona)			
Machine accuracy	mm	±0.003	±0.003	±0.004	±0.005
Best surface size tolerance	mm	±0.004	±0.004	±0.005	±0.005
Wire electrode diameter	mm	0.12-0.20	0.12-0.20	0.12-0.20	0.12-0.20
Drive mode		Panasonic AC servo	Panasonic AC servo	Panasonic AC servo	Panasonic AC servo
Working Area					
Work table travel (X*Y)	mm	400*320	400*500	630*500	800*630
Work table size (X*Y)	mm	690*520	800*600	960*800	1200*800
Max. work table load	kg	400	500	600	1200
Max. cutting thickness	mm	280 (optional)			
Water tank					
Volume (about)	L	150L	150L	150L	150L
Pulsed power supply					
Max. cutting efficiency	mm/min	≥220	≥220	≥220	≥220
Three cuts average cutting efficiency	mm/min	≥80	≥80	≥80	≥80
Best surface roughness	um	0.8	0.8	0.8	0.8
Consumed power	KW	2.0	2.3	3.0	
Communication interface		USB, LAN (network interface) \RS232			
Language interface		Chinese, English, Japanese, Russian			
Standard work condition		380V ± 10% 50/60HZ, 2KVA			



- 1. Machine body castings use high quality iron material, after several high temperature annealing, thermal aging one year, ensure the machine body strong and durable, used for a long time without deformation;
- 2. Base uses the structure of brass wire EDM machine, ensure the X, Y worktable moves will not exceed the scope of base, to ensure the accuracy and stability of equipment;
- 3. Imported linear guide and screw, Japanese Panasonic motor to ensure the good work efficiency and accuracy of equipment.



In order to ensure the accuracy of each device, all use British RAINSHAW laser interferometer detects the positioning accuracy and repeat accuracy.

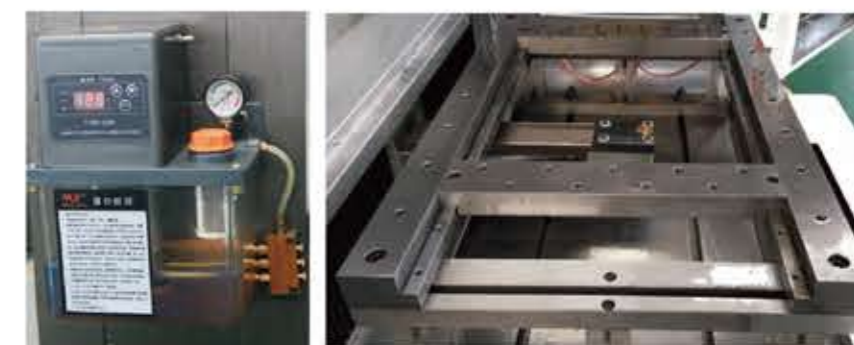
Four major characteristics of mechanical structure



UV axis-bed connection use Taiwan SHANGYIN linear guide way, improve the UV axis rigidity and the movement wire long term stability.
Guide wire mouth up and down device, can make the guide wire mouth maximum close to the surface of work piece when processing, to prevent the molybdenum wire to shake again, avoid the cutting surface line mark, greatly improve the processing surface and accuracy and roughness.

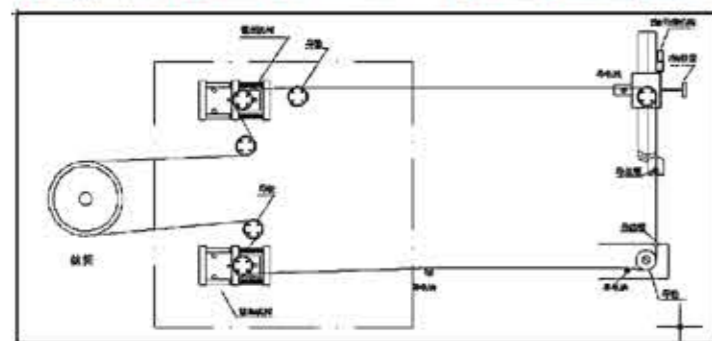
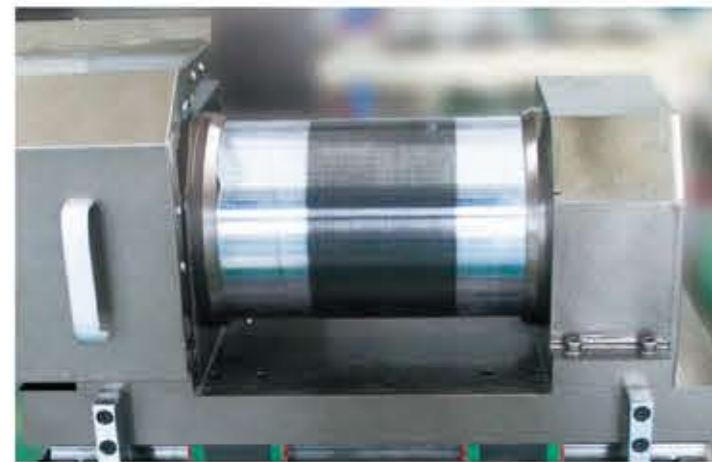


Panasonic AC servo motor directly connect the ball screw, no gap drive, with pitch compensation and reverse gap automatic compensation and many other features. All of the guide way, screw use imported well-known brands, to ensure long-term use of equipment precision.



Automatic oil adding and oil return system: the equipment has not only automatic oil adding system, to ensure that all parts of equipment long-term lubrication and wear-resisting, but also has the automatic oil return device, make sure the equipment is clean and tidy.
Brass wire EDM machine work table, easy to operate

Wire movement system



Use two directions automatic tight wire structure, long time work no need artificial tight wire; special guide wheel and the guide wheel seat, long term use without replacement; guide wire mouth can be automatically up and down, when processing, can make it maximum close to the work piece surface, not only improve the processing efficiency, but also ensure the high precision of the work piece surface.

Water filtration system



Brass wire EDM filter water tank: Brass wire EDM water tank filtering structure, multiple layers water filtration unit, greatly improving the long term use time of processing liquid, which laid the foundation for the high precision and roughness of the work piece surface.

Sample and example



profile mold

aviation work piece

extrusion die



rotor

mating parts

progressive die



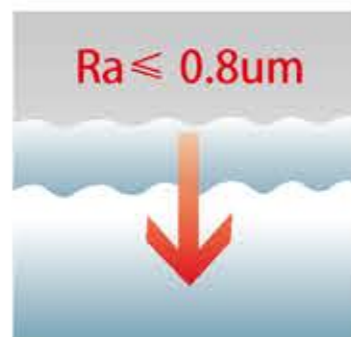
Control power supply components use world famous brands, advanced and reliable manufacturing process, control the power supply dynamic and static debugging, and after 400°C aging test for a long time, quality is more reliable and stable.



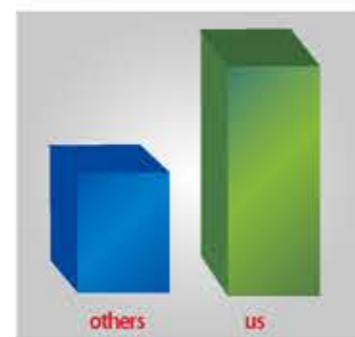
All the circuit motherboard is customized from the military enterprise, PCB uses SMT automatic assembly line, the solder joints are full, long time no oxidation, each PCB circuit board will be inspected by optical AOI visual inspection, ensure that each solder is full, no leakage welding.

Unique Power Supply High Frequency Advantage

The high frequency discharge power is a combination of Switzerland and Japan's discharge technology research and development, green, energy conservation and low loss.



Best surface roughness $Ra < 0.8\mu m$

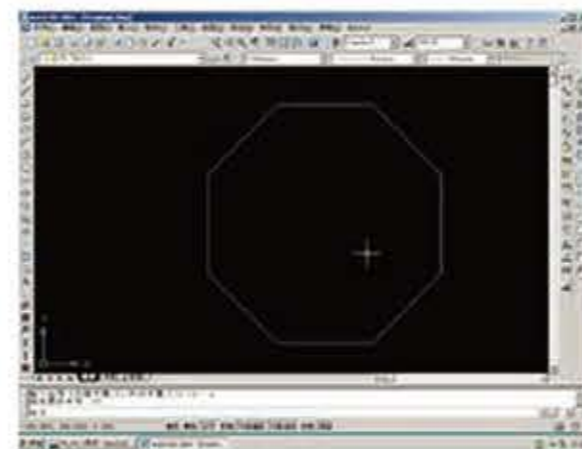


Cutting efficiency of other products 45mm²/min
our max. efficiency 80mm²/min

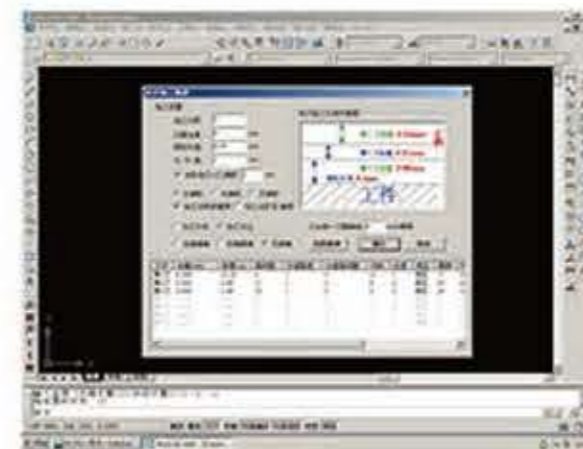


Wire loss 200000mm²

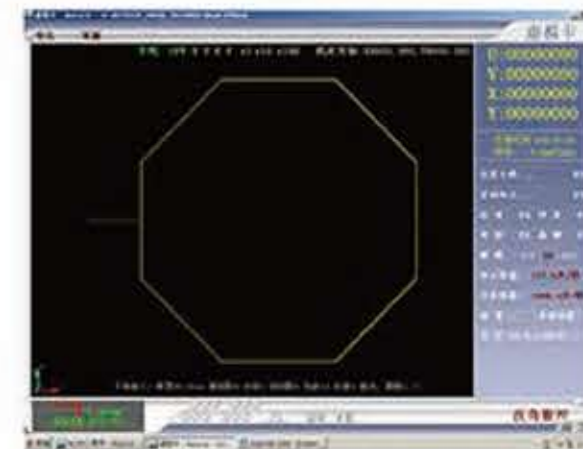
Intelligent and convenient operating system



Fool software, graphic drive technology
No need to contact the code
Two-dimensional direct drawing, network interface or USB graphics input



Man-machine dialogue, only need to fill in the parameters according to processing requirements



Direct graphics processing, real-time display of machine tracks

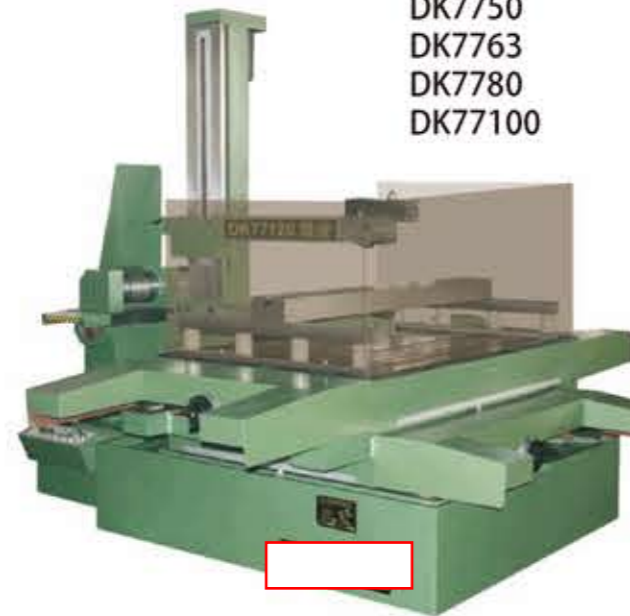
The fool software can be learned easily

The software runs in the Windows XP, through AUTOCAD, NCCAD, CAXA. 3D processing code can drive into various cutting files, truly realize the integration, in both taper machining and five-axis linkage control, operation is very convenient.

Economical CNC wire cut EDM



DK7725
DK7732
DK7745



DK7750
DK7763
DK7780
DK77100



Machine body parameters

Model	Unit	DK7725	DK7735	DK7745	DK7755
Work table travel (X*Y)	mm	280*320	350*450	450*550	550*680
Work table size (X*Y)	mm	450*640	490*730	600*880	730*1040
Max. work table load	kg	300	500	800	1000
Max. cutting thickness	mm	400	500	500	700
Max. Taper/work piece thickness		±6° /80mm(optiona)			
Machine Weight (about)	kg	1100	1300	1500	2200

Machine body parameters

Model	Unit	DK7763	DK7780	DK77100	DK77120
Work table travel (X*Y)	mm	630*800	800*1200	1000*1200	1200*1600
Work table size (X*Y)	mm	750*1140	1000*1600	1170*1700	1300*1900
Max. work table load	kg	2800	4000	6000	9000
Max. cutting thickness	mm	900	1000	1000	1000
Max. Taper/work piece thickness		±6° /80mm(optiona)			
Machine Weight (about)	kg	2800	4000	6000	9000

The GZ-AS Series are featured with beautiful shape, novel structure, superior performance, and convenient operation. Meanwhile they are of good rigidity, small cutting force, big load bearing, steady movement, and safety operation. they are suit to cut the workpiece of high precision, fairly good rigidity, high toughness, especially the cold die, extrusion die, plastic mould, gear cutter hob, precision component (including big taper, same taper, unequal cone, laid abnormality and etc.)



Lead Screw



Bearing



Step Motor



Water Tank