

CS-10/20

MANUAL RAM EDM



HANSVEDT

Manual Ram EDM Systems
for precision and affordability

Manual Ram EDM Machining.
Perfected by

HANSVEDT®



Manual Ram Electrical Discharge Machining.

Perfected by Hansvedt.®

Hansvedt...simplifying the EDM process.



CS-10/20 EDM FEATURES:

- Economical, rugged, compact floor-standing machine tool
- Workpiece capacities:
CS-10—200 pounds
CS-20—500 pounds
- Precision cast iron XY table with Turcite® lined dovetail ways
- Rigid cast iron quill-type ram with 6.375x4" platen to accept a V-block or precision tooling
- High-response AC servo and ballscrew drive
- Dial indicator infeed device, .001" resolution, depth limit stop and automatic ram retract cycle
- High-flow dielectric fluid system including reservoir, pump and 5 micron filter
- Flushing controls for pressure, worktank bypass and fluid level
- Fluid level safety switch, transparent worktank door and guards with gap power interlock
- High-performance 32-peak amp H-pulse power supply (64-peak amp optional)
- Ammeter and percent on-time/efficiency meters
- Automatic DC arc protection system with Gap Monitor LED
- Ram cyler provides automatic retract/advance movement for blind cavity flushing

PRODUCTIVITY YOU DEMAND:

- Audible edge find and dither controls enable fast, accurate workpiece set-ups
- Reliable surface finish control using Hansvedt's charts and graphs
- Dependable DC arc sensing avoids damaged parts and electrodes
- High-speed ram advance/retract manual override

PERFORMANCE YOU EXPECT:

- Higher metal removal rates:
1.2 in³/hr, graphite to steel
2.4 in³/hr optional
- Exceptional operation with both graphite and metallic electrodes
- Fast worktank fill and drain rates
- Continuous filtration system provides a high flow of clean fluid to the work area

PROFITABILITY YOU DESERVE:

- Customize an option package to suit your requirements and your budget with:
2- or 3-axis digital readouts
First arc sensing and program rapid retract with 3-axis DRO
Orbiting attachment
Dielectric chiller
32-peak amp booster
Capacitor module
Pulse flush manifold
- Outstanding customer support with installation, training and phone assistance

CS-10 EDM SPECIFICATIONS:

Machine	
Table Dimensions (WxD)	15x9"/381x229mm
Worktank Dimensions (WxDxH)	24x16x11"
	610x407x280mm
Table Travel	
X-Axis	8"/203mm
Y-Axis	6"/152mm
Ram Travel (Z-Axis)	8"/203mm
Platen-to-Table Distance	10 to 18"
	254 to 457mm
Electrode Weight (Max.)	75lb/34kg
Workpiece Capacity (Max.)	200lb/91kg

Dielectric System

Reservoir Capacity	65 US gal / 225 liter
Filter Type	Dense Pack

CS-10 Floor Space

(WxDxH)	70x60x84"
	1778x1524x2134mm

Net Weight

1,850lb/839 kg

CS-20 EDM SPECIFICATIONS:

Machine	
Table Dimensions (WxD)	20x12"/508x305mm
Worktank Dimensions (WxDxH)	35.5x20.5x13.0"
	902x521x330mm
Table Travel	
X-Axis	13"/330mm
Y-Axis	10"/254mm
Ram Travel (Z-Axis)	8"/203mm
Platen-to-Table Distance	12 to 20"
	305 to 508mm
Electrode Weight (Max.)	75lb/34kg
Workpiece Capacity (Max.)	500lb/227kg

Dielectric System

Reservoir Capacity	100 US gal / 378 liter
Filter Type	Dense Pack

CS-20 Floor Space

(WxDxH)	85x74x84"
	2159x1880x2134mm

Net Weight

2,500lb/1134kg

CS-10 AND CS-20 POWER SUPPLY:

Peak Current	32 amp
	64 amp optional
Electrode Wear	<1%
Input Power	195 to 250 VAC
	60 Hz, 1 phase

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