

Diamond Wheel Profiling Machine



ED-252 Wheel Profiling Machine – for precision reprofiling

The Glassline Model ED-252 is a state-of-the-art EDM machine featuring heavy duty construction, D.C. Servo RAM with ballscrew and precision bearings, and a 50 amp solid state power supply field that is proven for reliability. An optional Video Comparator can be mounted on the machine for in-process gauging of profiles.

Diamond wheels to be re-trued (reprofiled/redressed) are mounted on a special arbor for the particular wheel size/shape and indicated for run out. The arbor is fitted to a spindle and bracket mounted to the worktable, and driven by a DC gear motor for variable rotation. The gear motor is directly coupled to the spindle, but mounted outside of the work tank.

The ED-252 machine is furnished with an electrical box providing controls for both the diamond wheel drive and the electrode drive. Each of these drives has an on/off switch and a potentiometer for speed control. The electrode used is up to a 100-mm circular disc made of carbon, mounted on the arbor of a spindle bracketed off the ram. A DC gear motor drives the spindle through a right angle gearbox.

Each electrode can be either profiled on a lathe, or by running the disc into a new diamond wheel, or into a used diamond wheel with the correct profile. Normally, one disc is used for roughing and another for the finish cut. The disc used for the finished cut can be used for the next rough-cut for the same profile. The discs can be reused many times down to a minimum diameter of approximately 50-mm. Electrodes are available in 100-mm diameter bars or cut-to-width pieces.

GLASSLINE

Model ED-252 Diamond Wheel Profiling

SPECIFICATIONS

ED-252	Equipment Specifications
Ram Travel	200 mm Z-axis
Table Travel	200 mm Y-axis, 300 mm X-axis
Open Height	500 mm maximum
T-Slotted Work Table	600 x 300 mm
Work Tank Dimensions	770 mm wide x 510 mm deep x 270 mm high
Overall Dimensions	1600 mm wide x 1000 mm deep x 2000 mm high
Net Weight	1170 kgs (approximately)

FEATURES

- ▶ Heavy Duty Construction – for long life, low maintenance
- ▶ D.C. Servo ram with ballscrew and precision bearings
- ▶ 50 amp solid state power supply field – proven for reliability
- ▶ Electrical box controlling both the diamond wheel drive and electrode drive
- ▶ Individual drive On-Off switches, and Potentiometer for speed control
- ▶ 330-mm long 100-mm diameter carbon bar included
- ▶ 3 pressure port dielectric manifold
- ▶ Tee slotted flat platen
- ▶ 303 liter dielectric reservoir
- ▶ Oil level control of dielectric flushing oil
- ▶ Z-axis lock: any position
- ▶ Leveling pads
- ▶ 13 micron filter system (other filters available), dual cartridge
- ▶ Z-axis indicator
- ▶ Micrometer depth limit switch
- ▶ Audio edge finder circuit

Power Supply Specifications

DC Arc protection
Independent pulse timer for improving cutting efficiency
Microprocessor control
Solid state circuits
Power output: (1) 50 amp module
Gap monitor meter
Dither feature for locating the electrode and work piece
Pause ratio control
One (1) Amp meter
Fully transistorized oscillator
Electrode cables
Self diagnostics and efficiency indicators
Maximum power consumption of 6 KVA

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