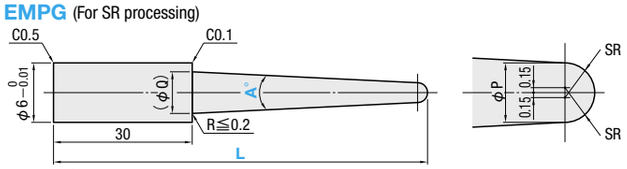
ELECTRODES FOR PIN-POINT GATE

ELECTRODES FOR OBLIQUE GATE

Non JIS material definition is listed on P.1351 - 1352

—ELECTRODES FOR PIN-POINT GATE— RoHS

EMPG (For SR processing)



$Q=2\tan\frac{A}{2}(L-30-\sqrt{SR^2+0.15^2})+P$

M Oxygen free copper (C1020)

*P	SR	Part Number Type	No.	L	A°	U/Price 1~9 L50~90	U/Price 1~9 L110
0.50	0.40	EMPG	0.8	50 70	1 2 3		—
0.70	0.50		1				
0.90	0.60		1.2	50 70 90	1 2 3		
1.20	0.75		1.5				
1.70	1.00		2	50 70 90	1 2 3		
				110	1 2 3		
2.20	1.25		2.5	50 70 90	1 2 3		
				110	1 2		
2.70	1.50		3	50 70 90	1 2 3		
				110	1 2		
3.20	1.75		3.5	50 70	1 2 3		
				90	1 2		
				110	1		
3.70	2.00		4	50 70	1 2 3		
				90	1 2		
				110	1		

Quotation

*This electrode is designed for a 0.15mm discharge gap on each side.
Because a center point of SR shifts 0.15mm from the center in one side, P dimension is 0.3mm less than nominal diameter (No.)=(2×SR)

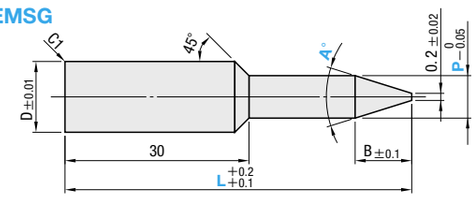
Order — Part Number — L — A
EMPG3 — 70 — A2

Days to Ship: Quotation

Price: Quotation

—ELECTRODES FOR OBLIQUE GATE— RoHS

EMSG



M Tough pitch copper (C1100)

P \ A	B 10°	B 15°	B 20°	B 30°	D	Part Number Type	P	L	A°	U/Price 1~9
1.5	—	—	3.7	—	6	EMSG	1.5	60	20	
2	10.3	6.8	5.1	3.4			2	60 70	10 15 20 30	
2.5	13.1	8.7	6.5	4.3			2.5			
3	16.0	10.6	7.9	5.2			3	60 70	10 15 20 30	
								90	20 30	
4	21.7	14.4	10.8	7.1			4	60 70	10 15 20 30	
								90	20	
5	—	—	13.6	9.0			5	60 70	20 30	
								90	20	
6	—	—	16.4	10.8			6	60 70	20 30	
								90	20	
8	—	—	—	14.6	10		8	70	30	

Quotation

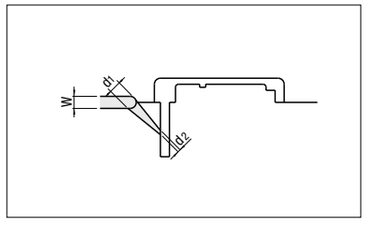
Order — Part Number — L — A
EMSG2 — 60 — 30

Note that when ordering EMSG, there is no need to enter the letter A of the alphabet.

Days to Ship: Quotation

Price: Quotation

Example

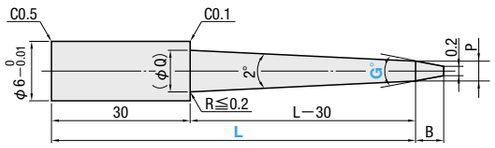


- Oblique gates require angular hole processing that are often difficult by drilling. Electro discharging is suitable for preparing an angular hole in places where the drill tip would not be well aligned or broken.
- The di dimension is dependent on the runner diameter (W). Select the appropriate P dimension in accordance with d_1.

The electrode's tip may be bent if it is dropped or its tip directly touches other objects.
If so, make sure to perform dressing before using it for rotating discharge process.

—ELECTRODES FOR PIN-POINT GATE— RoHS

EMPGA (For gate processing)



Q=2tan 1° (L−30) +P

M Oxygen free copper (C1020)

*P	Part Number Type	No.	L	G°	U/Price 1~9 L50~90	U/Price 1~9 L110
0.50	EMPGA	0.8	50 70	20		
0.70		1				
0.90		1.2	50 70 90	30		
1.20		1.5				
1.70		2	50 70 90 110	40		
2.20		2.5		50		
2.70		3				
3.20		3.5	50 70 90	60		
3.70		4				

Quotation

*This electrode is designed for a 0.15mm discharge gap on each side.
P dimension is 0.3mm less than nominal diameter (No.).

Order — Part Number — L — G
EMPGA3 — 70 — G40

Days to Ship: Quotation

Price: Quotation

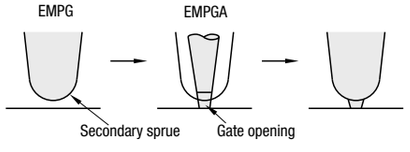
Alterations — Part Number — L — G — (A)
EMPGA3 — 70 — G40 — A1

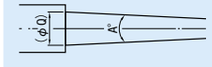
■B dimension choices

No.	B G20	B G30	B G40	B G50	B G60
0.8	0.85	0.56	0.41	0.32	0.26
1	1.42	0.93	0.69	0.54	0.43
1.2	1.99	1.31	0.96	0.75	0.61
1.5	2.84	1.87	1.37	1.07	0.87
2	4.25	2.80	2.06	1.61	1.30
2.5	5.67	3.73	2.75	2.14	1.73
3	7.09	4.67	3.43	2.68	2.17
3.5	8.51	5.60	4.12	3.22	2.60
4	9.92	6.53	4.81	3.75	3.03

Example

The electrode's tip may be bent if it is dropped or its tip directly touches other objects.
If so, make sure to perform dressing before using it for rotating discharge process.



Alterations	Code	Spec.	¥/1Code
	A	Select the taper angle A°, only available for EMPGA. 1° 3° Designation method 1°→A1, 3°→A3 ⊗A3 is not available when L110 for No2.5・3 and L90 for No3.5・4 are chosen.	0