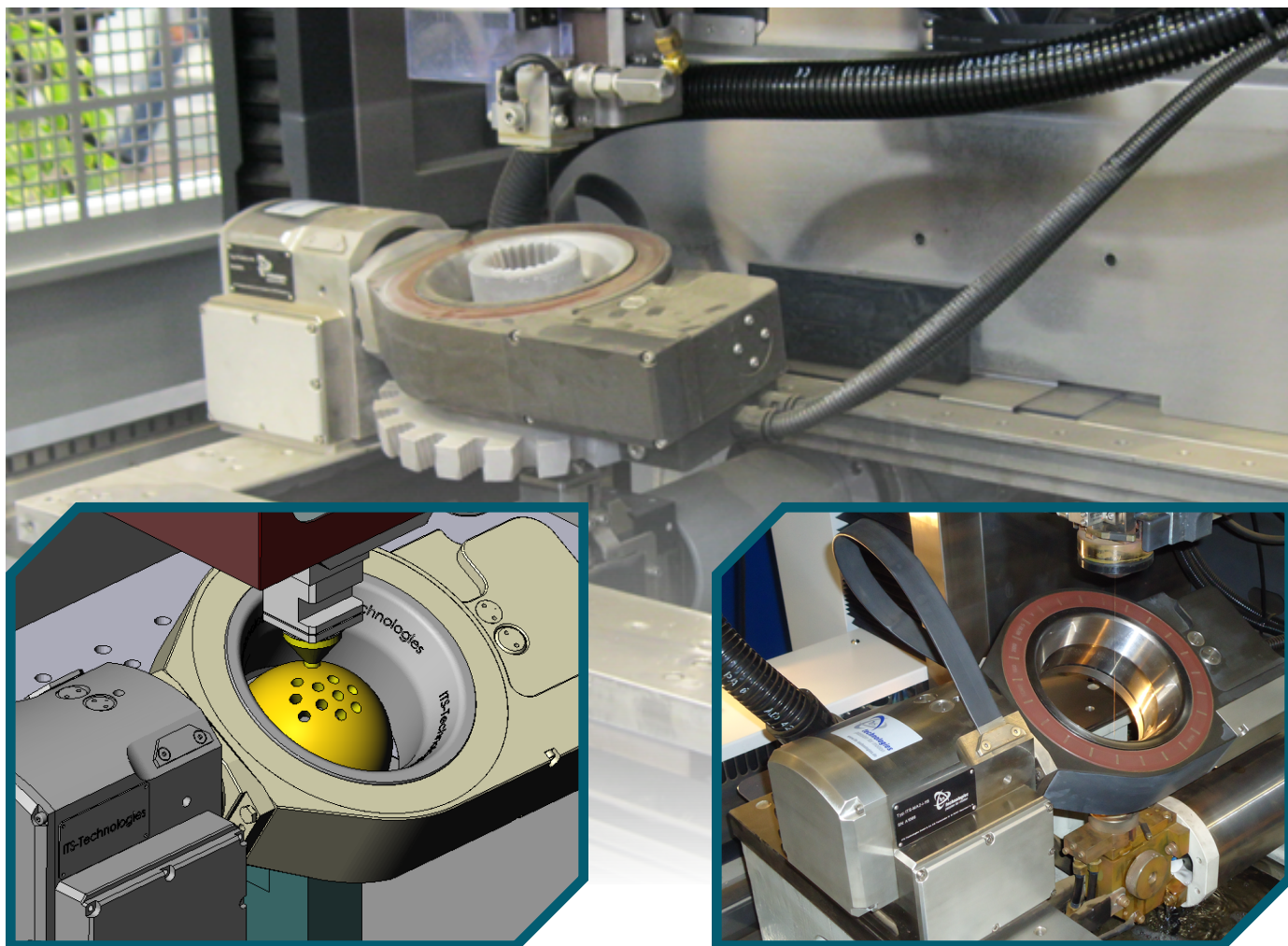


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ESPRIT for Hollow Axis Rotary Wire EDM

Rotary EDM technology has taken a completely new turn with the development of a rotary table with a hollow axis by ITS-Technologies. In the ITS-MA2-i, the part is mounted and rotated inside the opening of a hollow shaft.

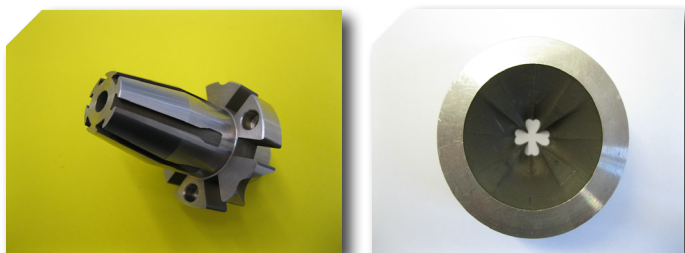
The advantage is that all sides of a part can be cut without anything to obstruct the wire guides. And the hollow shaft makes it possible to cut to the part center without any problem.

Hollow Axis Technology

Introduced in 2010, the ITS-MA2-i-115 has a range of 360 degrees and can rotate endlessly. The opening of the hollow shaft has a diameter of 115 mm to allow for parts up to 4.5 inches across. Because the workpiece continuously rotates, the wire can stay perpendicular the entire time to improve stability and flushing.

ESPRIT for Multi-axis Wire EDM

ESPRIT has supported full 5-axis wire EDM technology since the release of ESPRIT 2010, when Turn-While-Burn technology was introduced. Enabling rotary EDM technology is as easy as defining rotary motion in ESPRIT's machine setup function. ESPRIT supports 4- and 5-axis positioning (indexing), continuous 5-axis EDM, and EDM turning on a high-speed spindle to provide a complete solution for our EDM customers with rotary capabilities.

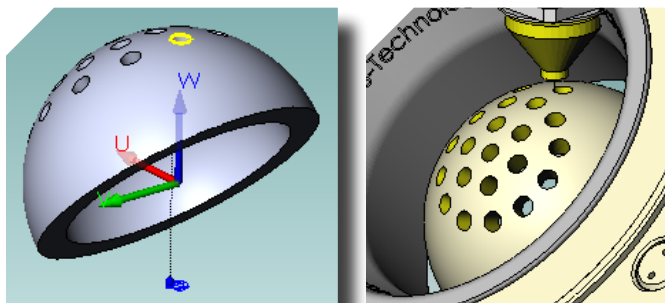


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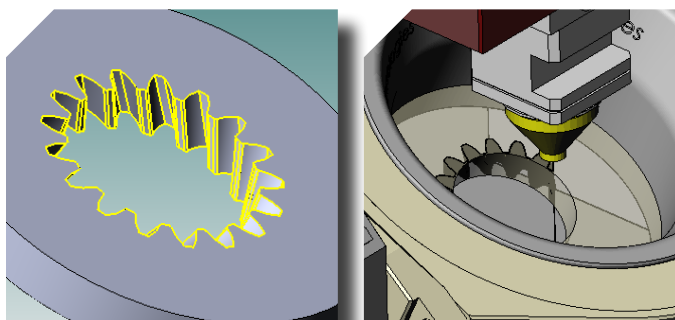
Simplified Programming

Multi-axis wire EDM is easily programmed in ESPRIT. Indexing operations are programmed like any other 2-axis EDM operation and continuous 5-axis motion is programmed much like a 4-axis EDM operation. This keeps the programming process simple and familiar.

The power lies in the advanced EDM Feature Recognition in ESPRIT. When 2-axis EDM features are recognized, knowledge of the active work plane is saved with the feature to allow for automatic positioning of the workpiece for rotary indexing. For each feature, the part is automatically rotated to align the wire vertically along the W axis.



Specialized multi-axis Ruled features are used for operations that require continuous rotation. The match lines contained in the feature automatically control the synchronization of the wire throughout the cut.



Factory Certified

As with other types of rotary tables, the Hollow Axis can be installed as a stand-alone unit or integrated directly into the machine by the manufacturer. Regardless of how it's installed, ESPRIT's machine-specific EDM technology provides you with a full range of cutting features, automation, and factory-certified post processors to maximize the performance of your make and model of EDM. Readily access each EDM manufacturer's unique cutting technology and methodologies through machine-specific technology pages.

Plus, the ESPRIT Expert System includes databases of factory recommended machining data for Makino, Mitsubishi, ONA, Sodick and AgieVision and ESPRIT offers support for the Charmilles CT-Expert database for cutting technology.

Learn More

Additional information is available in the ESPRIT@Work section of ESPRITWeb (www.dptechnology.com/ew/), the central on-line point for the ESPRIT community. To watch a video and download the ESPRIT part files highlighted here, log in to bulletin #4259 "[ESPRIT for Hollow Axis Rotary Wire EDM](#)" (an ESPRITWeb login is required).



DP Technology Corp.
1150 Avenida Acaso
Camarillo, CA
93012 USA
Tel: + 1 800 627 8479
Outside the US: + 1 805 388 6000
Email: esprit@dptechnology.com

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