

Portable EDM Performance Test Report									
Product Name: Portable EDM			Product Model 4000B			Machine No: CDE0902/ZK8E09020D			
Test Item: Performance Test						Tester:Xiangqian. Liu			
Parameters:									
1.Power Box: 4000B; 2. Work Head: ZK8;									
3. High Frequency Power Cord Specification: Copper Cable 2*2.5mm², Length: 2m;									
4.Electrode Material: H62 Copper.									
Test Condition: 1.Clean tap water as working liquid; 2.Cables connected well, good electrical conductivity; 3.All parts fixed well.									
No	Item	Test Project	Electrode Size	Workpiece Material	Input Voltage	Stepping Current	Processing Depth	Processing Time	Electrode Wastage
1		φ2mm hole	φ2mm	Hardened Steel	40V	Low current 3A	10mm	7min 55sec	5.5mm
2		φ4mm hole	φ4mm	Hardened Steel	50V	Low current 4A	10mm	20min 50sec	6.5mm
3		M4 broken tap	φ2mm	HSS	40V	Low current 4A	15mm	12min 40sec	8mm
4		M6 broken tap	φ4mm	HSS	40V	Low current 4A	15mm	14min	7.5mm
5		M10 broken tap(Blind hole)	φ5mm	HSS	25V	High current 8A	20mm	15min 21sec	14mm
6		M16 broken tap	8mm Hexagonal	HSS	25V	High current 10A	30mm	51min 25sec	10mm
7		M20 broken tap	2*15mm Sheet	HSS	40V	Low current 4A	35mm	42min 11sec	28mm
8		M24 broken tap	2*20mm Sheet	HSS	50V	High current 5A	40mm	55min 13sec	27mm
9		M12 broken bolt, Length 30mm	6mm Hexagonal	High Strength Bolt	25V	High current 8A	12mm	22min 10sec	6.5mm
10		M20 broken bolt, Length 50mm	10mm Hexagonal	High Strength Bolt	30V	High current 8A	14mm	41min 20sec	7mm
11		M30 broken bolt, Length 50mm	16mm Hexagonal	High Strength Bolt	35V	High current 10A	15mm	64min 50sec	8.5mm
12		Mark 1962mm²	φ50mm	Hardened Steel	25V	High current 14A	1mm	12min 20sec	0.5mm
13		Mark 2400mm²	30*80mm	Hardened Steel	25V	High current 14A	0.5mm	9min	0.3mm
14		Mark 4000mm²	50*80mm	Hardened Steel	30V	High current 12A	0.5mm	8min 32sec	0.3mm