

3. Machine Specification

3.1 Machine unit specification

Item		Unit	Model: 254Y ✓	Model: 355Y
Max. work piece dimensions(W × D × H)		mm	600 × 400 × 210	700 × 500 × 300
Max. work piece loading mass		kg	400 (submersible 300)	600 (submersible 450)
Working tank inner size (W × D × H)		mm	870 × 655	970 × 755
X, Y, Z axis travel distance		mm	400 × 250 × 210	500 × 350 × 300
U, V axis travel distance		mm	200 × 200 (±100)	
X, Y axis rapid feed rate		mm/min	1500	
Max. wire bobbin mountable (standard)		kg	JIS 10 kg	
Wire diameter	Standard	mm	0.25 dia.	
	Option	mm	0.1 dia., 0.2 dia., 0.3 dia.	
Wire feed rate		mm/s	20 to 300	
Wire tension		N	2-28 (200-2800gf)	
Max. taper angle *2	Standard	°/t	±12°/210	
	Option		±30°/140, ±°/70	
Net mass *1		kg	4000	4700

*1 Power source, CNC device and tank are included.

*2 AWF is not usable at taper angle of 12 to 30°.

*3 AWF is not usable at wire of 0.1 dia.

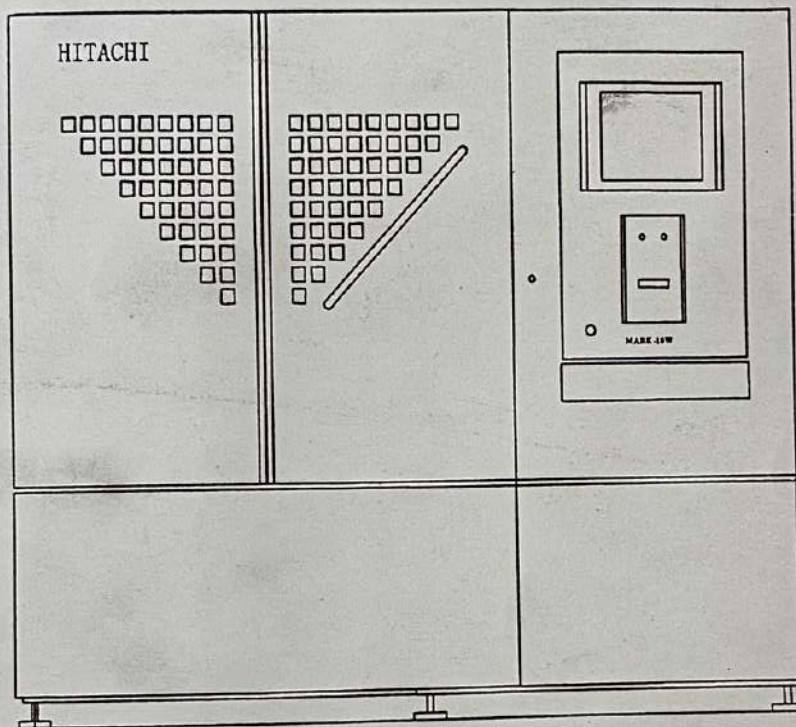
3.2 Working Fluid Tank

Item	Unit	Specification	
		254Y	355Y
Working fluid tank capacity	Liter	470 (dirty+clean)	600 (dirty+clean)
		Cartridge paper filter	
Filtration system	—	Cartridge paper filter	
Deionizer capacity (ion exchange resin)	Liter	5 liters	
Working fluid cooling unit	—	Room temperature tuned system (cooling capacity: 2000 kcal/hr, 50 Hz 2200 kcal/hr, 60 Hz)	
Working fluid conductivity control	μs/cm	5 to 150	
Supplied working fluid quality (tap water; industrial water)	μs/cm	<150 μs/cm pH 6.5 to 8.5 Cl ⁻ <120 mg/liter	

HITACHI WIRE ELECTRICAL DISCHARGE MACHINE


MODEL : 254Y - 355Y

MACHINE UNIT



IMPORTANT

- ◆ Summary of important points of handling , operation has been explained in this manual.
- ◆ Before attempting operation of this machine, please read thoroughly and understand the cautionary instructions contained in this instruction manual.
- ◆ Keep this instruction manual in a handy place with care.

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