

HB Series EDM Case Study

Stainless Steel Valve Body Cut Off

Application: 316 Stainless Steel valve body. LPBF 3D Metal printed. Part had extensive small support material and multiple open voids.

Originally done on a brass EDM with an average cut off time on 6-8 hour depending on delays caused by wire breaks and shorts.

Cut off time using the HB moly cut EDM was 44 minutes. The cut encountered no shorts or wire breaks.

Machine: HB600

Cut Time: 44 minutes (5+ Hour Reduction)

Cut Cost: \$0.70 (\$60-70 savings)

Wire: .007" Molybdenum

Fixturing/Set-up Time: Under 5 minutes

