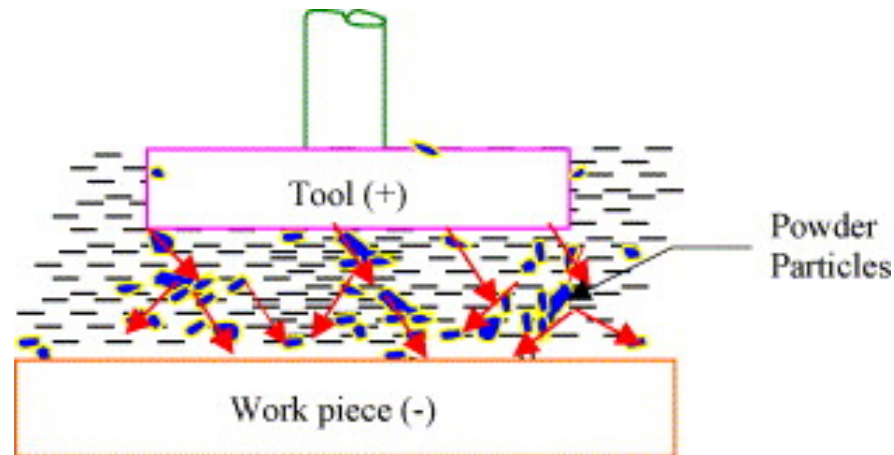


NANO POWDER MIXED MICRO EDM

Nano Powder Mixed Micro EDM

Conductive nano-powder is mixed into dielectric fluid



Advantages:

Lower dielectric strength

Increase spark gap

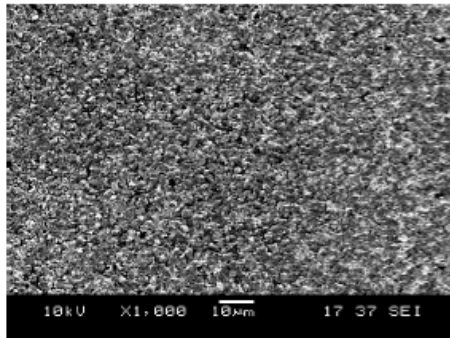
Disperse discharge energy

higher MRR

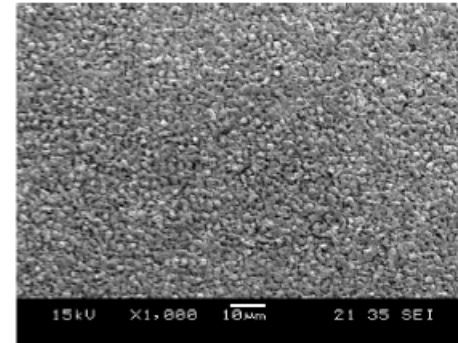
better flushing

better surface finish

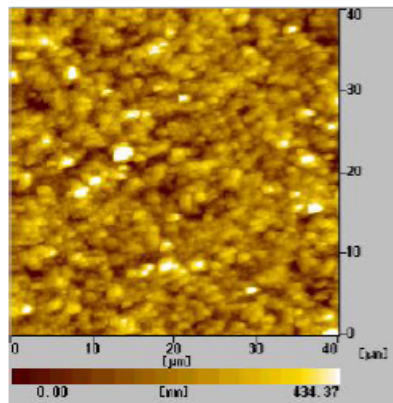
Nano Powder Mixed Micro EDM



(a)



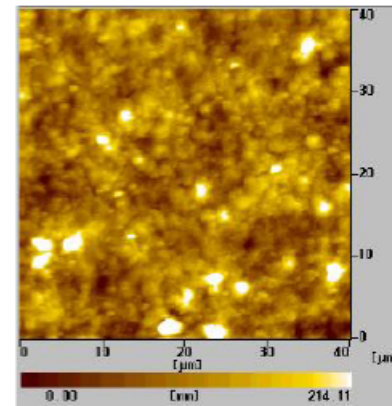
(b)



(c)

Die-sinking (R_a 54 nm)

Without powder-mixed

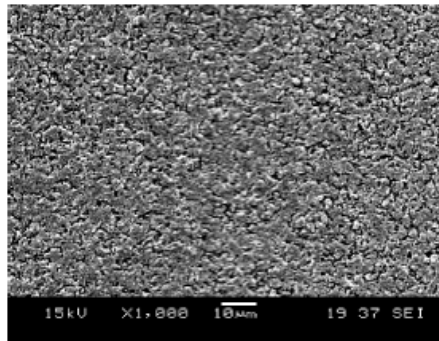


(d)

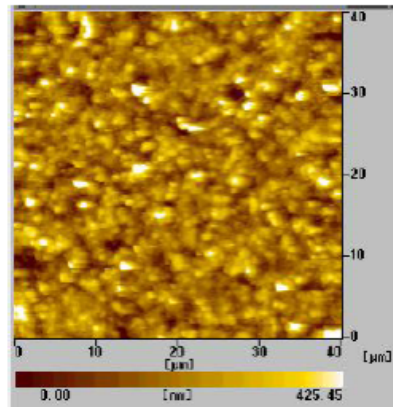
Die-sinking (R_a 43 nm)

Powder-mixed micro-EDM

Nano Powder Mixed Micro EDM



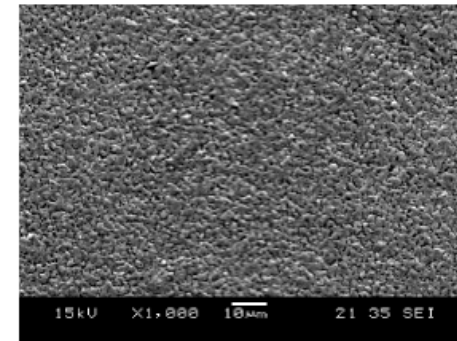
(a)



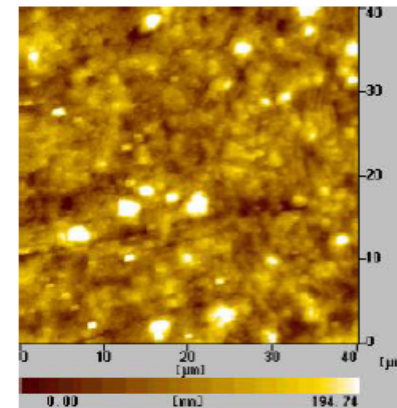
(c)

Micro EDM Milling (R_a 48 nm)

Without powder-mixed



(b)



(d)

Milling (R_a 38 nm)

Powder-mixed micro-EDM