

Astec A22M and A33M High Speed EDM Drill

Features

Onboard Storage of EDM Parameters

Allows the storage of up to 16 different sets of EDM conditions

Automatic Electrode Management

At the start of a hole the electrode is checked for sufficient length to complete the hole

One Button Cycle Start

Automatically the electrode will detect the surface, set zero, start the pump, ramp up cutting power, cut to depth, and retract

3 Step Control

Use up to three EDM parameter settings per hole to improve quality on difficult entrance and exits

Soft Spark

Gradually increases amperage to improve stability and hole quality

Auxiliary I/O

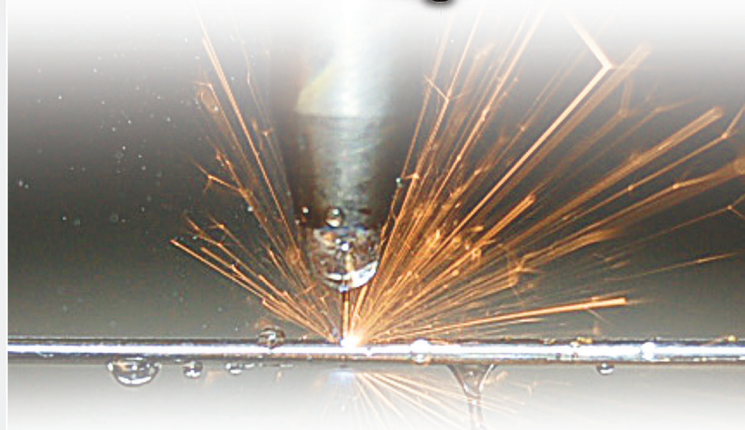
Ability to integrate ancillary devices such as rotary tables and indexers

Linear Glass Scales with 5 Micron Resolution

Provides true, closed loop, position feedback for precise part positioning accuracy

Break Through Detection (optional)

Ensures a complete hole or helps to eliminate back wall strikes



Serving All of North America
ISO 9001 : 2015 Registered



Astec A22M and A33M High Speed EDM Drill Specifications

		A22M MANUAL	A33M MANUAL
TRAVEL	X AXIS	7.8" (200 mm)	11.8" (300 mm)
	Y AXIS	7.8" (200 mm)	11.8" (300 mm)
	W AXIS	9.6" (245 mm)	11.8" (300 mm)
	Z AXIS	15.7" (400 mm)	15.7" (400 mm)
OPEN HEIGHT *	MINIMUM	0.0" (0 mm)	0.0" (0 mm)
	MAXIMUM	8.2" (210 mm)	11.8" (300 mm)
WORK TABLE	WIDTH	10.0" (255 mm)	15.7" (400 mm)
	DEPTH	12.2" (310 mm)	15.7" (400 mm)
WORK PAN	WIDTH	14.5" (370 mm)	21.6" (550 mm)
	DEPTH	18.1" (460 mm)	25.0" (635 mm)
WEIGHT CAPACITY	ON WORK TABLE	220 lb. (100 kg.)	660 lb. (300 kg.)
GENERATOR	MAXIMUM AVERAGE CURRENT	30 A (optional 40 A)	40 A
	ON AND OFF TIME	1 to 999 μ s	1 to 999 μ s
	CAPACITORS	0 to 1.7 μ F	0 to 1.7 μ F
FLOOR SPACE	WIDTH	42" (110 cm)	52" (135 cm)
	DEPTH	38" (100 cm)	48" (125 cm)
	HEIGHT	74" (190 cm)	74" (190 cm)
ENVIRONMENTAL	ROOM TEMPERATURE	68 to 77°F (20 to 25°C)	68 to 77°F (20 to 25°C)
	RELATIVE HUMIDITY	40% to 55%	40% to 55%
UTILITIES	ELECTRICAL	220VAC \pm 10%, 60 Hz, 3.5 KVA (4.5KVA with 40 A generator)	220VAC \pm 10%, 60 Hz, 4.5 KVA
	AIR	-	-

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