

EXERON EDM 310 s.n.2575 year 2008



Machine parameters:

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Generator EroForm – 60A with APF

Rotation tool changer wit 20 positions

C-box

Heat exchanger for external cooling water

Pneumatic Chuck Erowa(installed) or Hirschmann

Working hours before general reparation: 48 200 hours

Machine mechanics:

Complete cleaning of the machine body and CNC cabinet.

Cleaning of all covers, protective elements and other parts of the machine.

Painting with powder paint of all machine covers.

Spraying machine mechanics.

Complete replacement of all cables except for motors and encoders cables.

Replacement of ball screws with bearings on all X, Y and Z axes

Dielectric system:

Sludge suction and complete cleaning of the dielectric tank also under the mechanical body.

Cleaning of all hoses and individual valves and fittings.

Cleaning of filtration containers and replacement of filters.

Replacing the dielectric pump.

Membrane replacement of the air-operated valve for quick filling tank.

Replacement of quick-connect connectors for connecting additional flushing.

Replacement of hoses.

Complete painting of tank and filtration containers.

Installation of new heat changer for cooling by water with new Dunfos valve

Air system:

Complete replacement of all air hoses in the machine.

Replacement of air pressure regulators with strainers and installation of digital pressure gauges to check air pressure and check the presence of the electrode in the pneumatic chuck.

Replacement of the inlet pressure regulator together with 5 microns Air filter.

Lifting Tank and table:

Completely cleaned system for tank up and down operation.

Grinding of the clamping table.

Replacement of work tank seals.

Setting the sensors and limit switches of the work tank.

Generator:

Cleaning of the generator cabinet, repair of the generator and replacement of power relays for polarity switching.

Replacement of 4x UZ relays.

Replacement of generator fans and outlet and inlet grids. For inlet also air filters exchange.

Tool changer (rotating) 20 positions:

Cleaning and setting the geometry of the exchanger.

Cover painting.

Replacement of all segments of the forks of the exchanger.

C-axis:

C-axis exchange.

New Erowa clamping chuck installed.

Reference point setting o C axis and delta setting for C0.

C axis centering for rotation in 0,004 mm in 0 and 0,006 in 100mm position of caliber.

Protective covers:

Cleaning of protective covers and adjustment.

Replacement of plexiglass of the protective lifting cover.

Renovation of the X, Y and Z axis protective bellows and blinds.

Control cabinet:

Cleaning the cabinet from dust.

Replacement of the cabinet fan with inlet grid and filter element.

Cleaning of X, Y, Z, C axis servo amplifiers (replacement of internal fans)

Inspection of electrical elements, contactors, and safety elements.

Cable exchange, poti, and EMG of the remote-control box and painting of box.

CNC system (APC620):

Replacement of HDD for SSD disk type + installation of operating system and control system MF20

PC backup battery replacement

Replacing the keyboard.

Machine geometry:

Laser compensation of X, Y, Z axis travel accuracy

Setting the geometry of the perpendicularity of the XY, XZ, YZ axis

Leveling the plane of the table and adjusting the parallelism of the T slots with the X axis