

Influence of generator parameters on cutting width during WEDM process

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The aim of the paper is to analyse the influence of selected parameters on the cutting width in Wire Electric Discharge Machining. Parameters with variable values were pulse width, servo reference mean voltage, time between two pulses, frequency and wire feed speed. The response was measured on a Zoller Genius 3s and Alicona InfiniteFocusSL. The most influential variable input parameter is the mean reference voltage. With a big lead with a percentage share of up to 82.4%, it is almost 15 times more influential as the second most influential factor (pulse width). At its first level, the width of the cut reaches a record low value. On the other hand, at the third level, it is again the highest value of the width of the cut.

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