

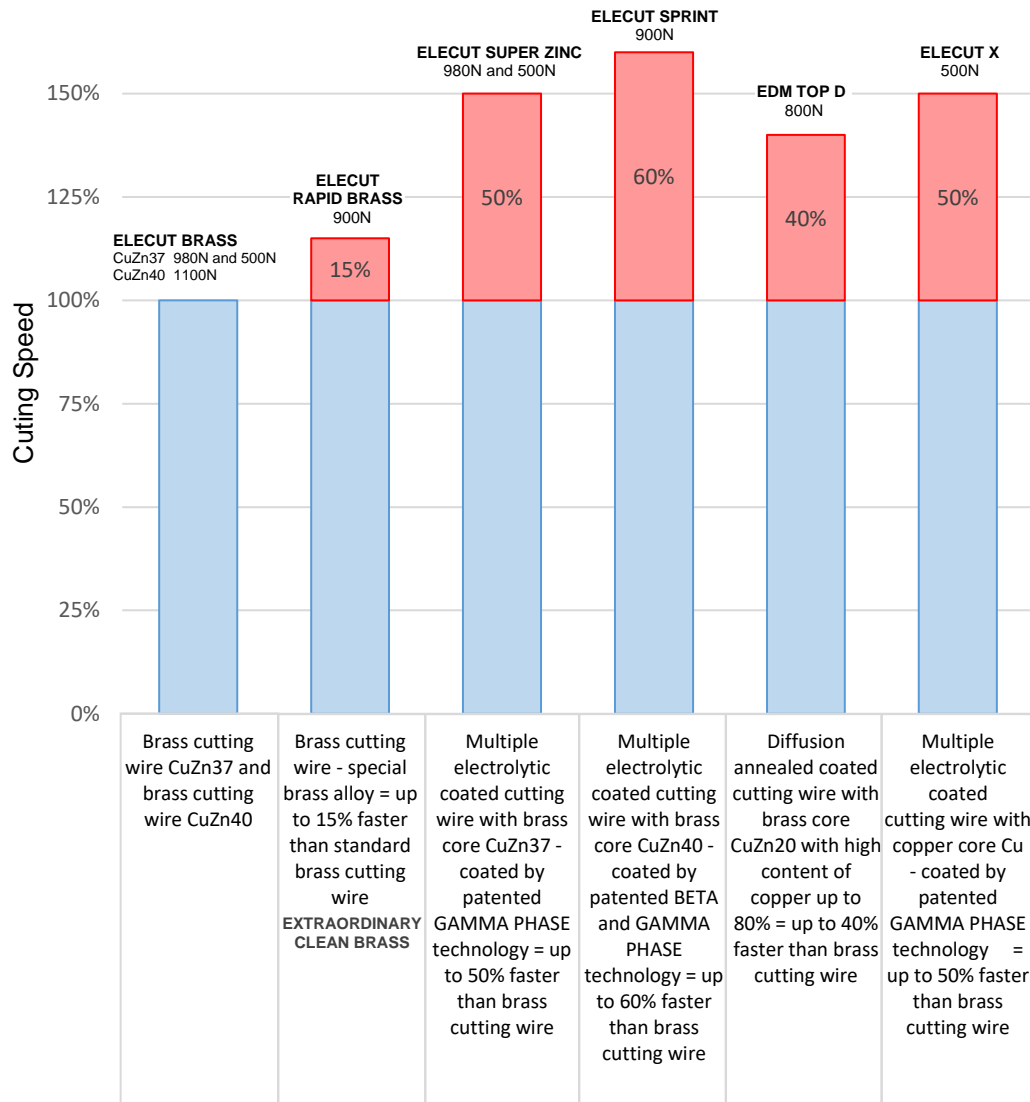
CUTTING WIRES



When quality isn't costly

Cutting wires

Wire comparison



Note: Coated cutting wires can achieve the same surface quality after cutting as uncoated cutting wires. Thanks to the coatings, the coated wires can withstand higher current loads, they can cut at higher generator parameters and thus they are faster.

For angle cutting over 12° - 15° it is necessary to use a soft wire with a tensile strength of 500N/mm2.








We supply also molybdenum cutting wires for extra fast EDM cutting.

Designed for less-precision Chinese non-toolmaker wire cutting machines with reverse travel of cutting wire.

We look forward to specifying the most appropriate cutting wires for your needs.

Cutting wires

Wire selection for using in specific brands of wire cutting EDM

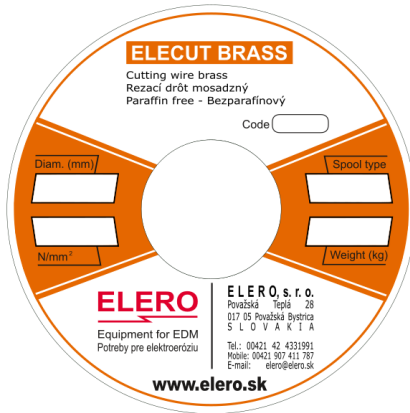
WEDM		Using	+GF+ Agie Charmilles	FANUC	MITSUBISHI	Sedick	MAKINO	HITACHI	JAPAX brother Seibu	OWA	AccuteX EXCETEK	SPM CHMER
ELECUT BRASS CuZn37		Standard speed + high precision	*	*	*	*	*	*	*	*	*	*
ELECUT BRASS CuZn40		Standard speed + high precision	*	*	*	*	*	*	*	*	*	*
ELECUT RAPID BRASS		15% higher speed + high precision EXTRAORDINARY CLEAN BRASS	*	*	*	*	*	*	*	*	*	*
ELECUT SUPER ZINC		50% higher speed + high precision	*	*	*	*	*	*	*	*	*	*
ELECUT SPRINT		60% higher speed + high precision	*	*	*	*	*	*	*	*	*	*
EDM TOP D		40% higher speed + high precision	*							*		
ELECUT X		50% higher speed + high precision	*							*		

Explanatory notes: * ... recommended * ... also suitable

For angle cutting over 12° - 15° it is necessary to use a soft wire with a tensile strength of 500N/mm².

Cutting wires

ELECUT BRASS – brass cutting wire



Hard version - for straight cutting and angle cutting up to 12°- 15°

Material: **CuZn37**
Tensile strength: **980N/mm²**
Elongation: **2%**
Conductibility: **22% IACS**



Soft version – mostly for angle cutting over 12°-15°

Material: **CuZn37**
Tensile strength: **500N/mm²**
Elongation: **15%**
Conductibility: **25% IACS**



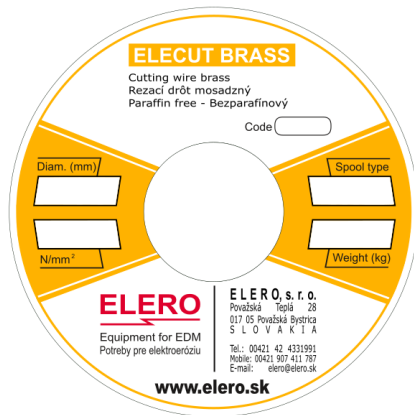
ELECUT BRASS CuZn37 tensile strength 980 N/mm ²					
Item Number	Diameter (mm)	Tensile strength (N/mm ²)	Spool type	Amount of wire on the spool (kg)	Number of spools in package
291210	0,10	980	K125	4	1
291215	0,15	980	K125	4	1
291615	0,15	980	K160	8	2
291220	0,20	980	K125	4	4
291620	0,20	980	K160	8	2
292020	0,20	980	K200	16	1
290520	0,20	980	P5	5	4
291225	0,25	980	K125	4	4
291625	0,25	980	K160	8	2
292025	0,25	980	K200	16	1
290525	0,25	980	P5	5	4
291025	0,25	980	P10	10	2
291525	0,25	980	P15	20	1
292525	0,25	980	K250	25	1
293525	0,25	980	K355	45	1
291230	0,30	980	K125	4	4
291630	0,30	980	K160	8	2
292030	0,30	980	K200	16	1
290530	0,30	980	P5	5	4

ELECUT BRASS CuZn37 tensile strength 500 N/mm ²					
Item Number	Diameter (mm)	Tensile strength (N/mm ²)	Spool type	Amount of wire on the spool (kg)	Number of spools in package
251220	0,20	500	K125	4	4
251620	0,20	500	K160	8	2
252020	0,20	500	K200	16	1
250520	0,20	500	P5	5	4
251225	0,25	500	K125	4	4
251625	0,25	500	K160	8	2
252025	0,25	500	K200	16	1
250525	0,25	500	P5	5	4
251025	0,25	500	P10	10	2
251525	0,25	500	P15	20	1
251230	0,30	500	K125	4	4
251630	0,30	500	K160	8	2
252030	0,30	500	K200	16	1
250530	0,30	500	P5	5	4

Information about delivery of other wire diameters, spool types, tensile strength, amount of wire on the spool and different composition of wire are available on request.

Cutting wires

ELECUT BRASS – brass cutting wire



Especially suitable for Japanese EDM wire cutters

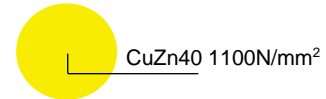
Hard version - for straight cutting and angle cutting up to 12° - 15°

Material: **CuZn40**

Tensile strength: **1100N/mm²**

Elongation: **2%**

Conductibility: **22% IACS**



ELECUT BRASS CuZn40 tensile strength 1100 N/mm ²					
Item Number	Diameter (mm)	Tensile strength (N/mm ²)	Spool type	Amount of wire on the spool (kg)	Number of spools in package
391210	0,10	1100	K125	4	1
391215	0,15	1100	K125	4	1
391625	0,15	1100	K160	8	2
391220	0,20	1100	K125	4	4
391620	0,20	1100	K160	8	2
392020	0,20	1100	K200	16	1
390520	0,20	1100	P5	5	4
391225	0,25	1100	K125	4	4
391625	0,25	1100	K160	8	2
392025	0,25	1100	K200	16	1
390525	0,25	1100	P5	5	4
391025	0,25	1100	P10	10	2
391525	0,25	1100	P15	20	1
392525	0,25	1100	K250	25	1
393525	0,25	1100	K355	45	1
391230	0,30	1100	K125	4	4
391630	0,30	1100	K160	8	2
392030	0,30	1100	K200	16	1
390530	0,30	1100	P5	5	4

Information about delivery of other wire diameters, spool types, tensile strength, amount of wire on the spool and different composition of wire are available on request.

Cutting wires

ELECUT RAPID BRASS – brass cutting wire, special alloy = up to **15% faster** than standard brass cutting wire



EXTRAORDINARY CLEAN brass wire

Suitable for all brands of EDM wire cutters

Hard version – for straight cutting and angle cutting up to 12°-15°
Equivalent: BETTERBRASS, HITACHI HBZ-U, TURBO BRASS

Material: **Special brass alloy**

Tensile strength: **900N/mm²**

Elongation: **2%**

Conductibility: **20% IACS**



Special brass alloy 900N/mm²

ELECUT RAPID BRASS tensile strength 900 N/mm²

Item Number	Diameter (mm)	Tensile strength (N/mm ²)	Spool type	Amount of wire on the spool (kg)	Number of spools in package
491210	0,10	900	K125	4	1
491215	0,15	900	K125	4	1
491615	0,15	900	K160	8	2
491220	0,20	900	K125	4	4
491620	0,20	900	K160	8	2
492020	0,20	900	K200	16	1
490520	0,20	900	P5	5	4
491225	0,25	900	K125	4	4
491625	0,25	900	K160	8	2
492025	0,25	900	K200	16	1
490525	0,25	900	P5	5	4
491025	0,25	900	P10	10	2
491525	0,25	900	P15	20	1
492525	0,25	900	K250	25	1
493525	0,25	900	K355	45	1
491230	0,30	900	K125	4	4
491630	0,30	900	K160	8	2
492030	0,30	900	K200	16	1
490530	0,30	900	P5	5	4

Information about delivery of other wire diameters, spool types, tensile strength, amount of wire on the spool and different composition of wire are available on request.

Cutting wires

ELECUT SUPER ZINC - multiple electrolytic coated cutting wire
with brass core CuZn37 – coated by patented GAMMA PHASE technology
= up to **50% faster** than brass cutting wire



Suitable for all brands of EDM wire cutters

Hard version – for straight cutting and angle cutting up to 12°-15°

Core material: **CuZn37**

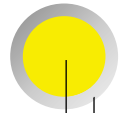
Coating: **multiple – special alloy GAMMA γ Cu₅Zn₈**

Tensile strength: **980N/mm²**

Elongation: **1%**

Conductibility: **22% IACS**

core: brass wire CuZn37 980N/mm²
coating: multiple – special alloy GAMMA γ Cu₅Zn₈



Soft version – mostly for angle cutting over 12°-15°

Core material: **CuZn37**

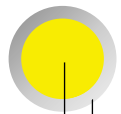
Coating: **multiple – special alloy GAMMA γ Cu₅Zn₈**

Tensile strength: **500N/mm²**

Elongation: **15%**

Conductibility: **25% IACS**

core: brass wire CuZn37 500N/mm²
coating: multiple – special alloy GAMMA γ Cu₅Zn₈



ELECUT SUPER ZINC tensile strength 980 N/mm²

Item Number	Diameter (mm)	Tensile strength (N/mm ²)	Spool type	Amount of wire on the spool (kg)	Number of spools in package
1891210	0,10	980	K125	4	1
1891215	0,15	980	K125	4	1
1891615	0,15	980	K160	8	2
1891220	0,20	980	K125	4	4
1891620	0,20	980	K160	8	2
1892020	0,20	980	K200	16	1
1890520	0,20	980	P5	5	4
1891225	0,25	980	K125	4	4
1891625	0,25	980	K160	8	2
1892025	0,25	980	K200	16	1
1890525	0,25	980	P5	5	4
1891025	0,25	980	P10	10	2
1891525	0,25	980	P15	20	1
1892525	0,25	980	K250	25	1
1893525	0,25	980	K355	45	1
1891230	0,30	980	K125	4	4
1891630	0,30	980	K160	8	2
1892030	0,30	980	K200	16	1
1890530	0,30	980	P5	5	4

ELECUT SUPER ZINC tensile strength 500 N/mm²

Item Number	Diameter (mm)	Tensile strength (N/mm ²)	Spool type	Amount of wire on the spool (kg)	Number of spools in package
1851220	0,20	500	K125	4	4
1851620	0,20	500	K160	8	2
1852020	0,20	500	K200	16	1
1850520	0,20	500	P5	5	4
1851225	0,25	500	K125	4	4
1851625	0,25	500	K160	8	2
1852025	0,25	500	K200	16	1
1850525	0,25	500	P5	5	4
1851025	0,25	500	P10	10	2
1851525	0,25	500	P15	20	1
1851230	0,30	500	K125	4	4
1851630	0,30	500	K160	8	2
1852030	0,30	500	K200	16	1
1850530	0,30	500	P5	5	4

Information about delivery of other wire diameters, spool types, tensile strength, amount of wire on the spool are available on request.

Cutting wires

ELECUT SPRINT - multiple electrolytic coated cutting wire

with brass core CuZn40 – coated by patented BETA and GAMMA PHASE technology
= up to **60% faster** than brass cutting wire



Suitable for all brands of EDM wire cutters

Hard version – for straight cutting and angle cutting up to 12°-15°

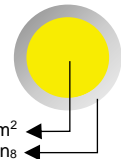
Core material: **CuZn40**

Coating: **multiple – special alloy BETA β CuZn and GAMA γ Cu₅Zn₈**

Tensile strength: **900N/mm²**

Elongation: **2%**

Conductibility: **24% IACS**



core: brass wire CuZn40 900N/mm²
coating: multiple – special alloy BETA β CuZn a GAMA γ Cu₅Zn₈

ELECUT SPRINT tensile strength 900 N/mm ²					
Item Number	Diameter (mm)	Tensile strength (N/mm ²)	Spool type	Amount of wire on the spool (kg)	Number of spools in package
1291210	0,10	900	K125	4	1
1291215	0,15	900	K125	4	1
1291615	0,15	900	K160	8	2
1291220	0,20	900	K125	4	4
1291620	0,20	900	K160	8	2
1292020	0,20	900	K200	16	1
1290520	0,20	900	P5	5	4
1291225	0,25	900	K125	4	4
1291625	0,25	900	K160	8	2
1292025	0,25	900	K200	16	1
1290525	0,25	900	P5	5	4
1291025	0,25	900	P10	10	2
1291525	0,25	900	P15	20	1
1292525	0,25	900	K250	25	1
1293525	0,25	900	K355	45	1
1291230	0,30	900	K125	4	4
1291630	0,30	900	K160	8	2
1292030	0,30	900	K200	16	1
1290530	0,30	900	P5	5	4

Information about delivery of other wire diameters, spool types, tensile strength, amount of wire on the spool are available on request.

Cutting wires

EDM TOP D - diffusion annealed coated cutting wire with brass core CuZn20 with high content of copper – up to 80%
= up to **40% faster** than brass cutting wire



Hard version – for straight cutting and angle cutting up to 12°-15°

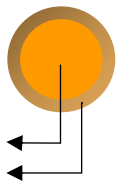
Core material: **CuZn20**

Coating: **diffusion annealed CuZn50**

Tensile strength: **800N/mm²**

Elongation: **2%**

Conductivity: **27% IACS**



core: brass wire CuZn20 with high content of wire of copper – up to 80% 800N/mm²
coating: diffusion annealed CuZn50

EDM TOP D tensile strength 800 N/mm ²					
Item Number	Diameter (mm)	Tensile strength (N/mm ²)	Spool type	Amount of wire on the spool (kg)	Number of spools in package
1481220	0,20	800	K125	4	4
1481620	0,20	800	K160	8	2
1482020	0,20	800	K200	16	1
1480520	0,20	800	P5	5	3
1481225	0,25	800	K125	4	4
1481625	0,25	800	K160	8	2
1482025	0,25	800	K200	16	1
1480525	0,25	800	P5	5	3
1481025	0,25	800	P10	10	2
1481525	0,25	800	P15	20	1
1482525	0,25	800	K250	25	1
1483525	0,25	800	K355	45	1
1481230	0,30	800	K125	4	4
1481630	0,30	800	K160	8	2
1482030	0,30	800	K200	16	1
1480530	0,30	800	P5	5	3

Information about delivery of other wire diameters, spool types, tensile strength, amount of wire on the spool are available on request.

Cutting wires

ELECUT X - multiple electrolytic coated cutting wire with copper core Cu
coated by patented GAMMA PHASE technology
= up to **50% faster** than brass cutting wire



Soft version - for straight and also for angle cutting for machines with X-technology
Especially suitable for Charmilles EDM wire cutters

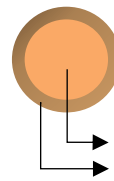
Core material: **Cu**

Coating: **multiple - special alloy GAMA γ Cu₅Zn₈**

Tensile strength: **500N/mm²**

Elongation: **2%**

Conductibility: **65% IACS**



core: copper wire Cu 500N/mm²

coating: multiple – special alloy GAMA γ Cu₅Zn₈

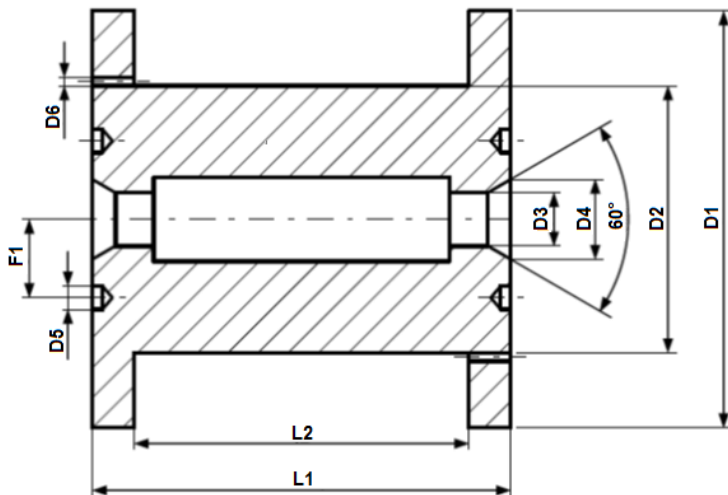
ELECUT X tensile strength 500 N/mm ²					
Item Number	Diameter (mm)	Tensile strength (N/mm ²)	Spool type	Amount of wire on the spool (kg)	Number of spools in package
1951220	0,20	500	K125	4	4
1951620	0,20	500	K160	8	2
1952020	0,20	500	K200	16	1
1950520	0,20	500	P5	5	4
1951225	0,25	500	K125	4	4
1951625	0,25	500	K160	8	2
1952025	0,25	500	K200	16	1
1950525	0,25	500	P5	5	4
1951025	0,25	500	P10	10	2
1951525	0,25	500	P15	20	1
1951230	0,30	500	K125	4	4
1951630	0,30	500	K160	8	2
1952030	0,30	500	K200	16	1
1950530	0,30	500	P5	5	4

Information about delivery of other wire diameters, spool types, tensile strength, amount of wire on the spool are available on request.

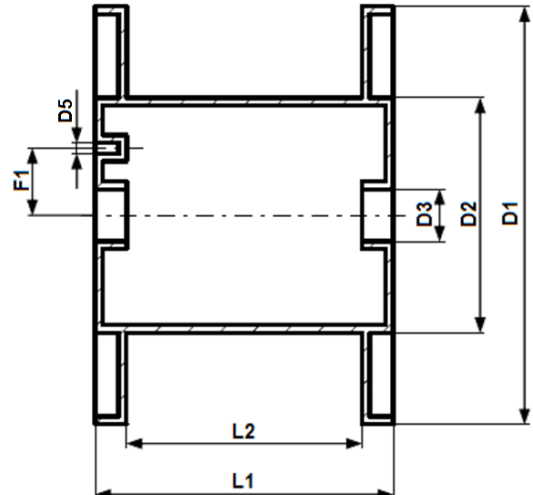
Cutting wires

Basic spools types

Spool type K (DIN)



Spool type P



Units: mm

Spool type	D1	D2	D3	D4	D5	D6	F1	L1	L2	Weight of wire
K100 (DIN100)	100	63	16	-	-	-	-	100	80	1,6 kg
K125 (DIN125)	125	80	16	24	7	3	20	125	100	4 kg
K160 (DIN160)	160	100	22	34	13	3	32	160	128	8 kg
K200 (DIN200)	200	125	22	34	13	3	32	200	160	16 kg
K250 (DIN250)	250	160	22	-	-	-	-	200	160	25 kg
K355 (DIN355)	355	224	36	-	-	-	-	200	160	45 kg
P3	130	81	20	-	-	-	-	110	90	3 kg
P5	160	90	20	-	-	-	-	115	90	5 kg
P10	200	90	25	-	-	-	-	134	110	10 kg
P15	250	110	34	-	-	-	-	140	110	20 kg

We look forward to specifying the most appropriate cutting wires for your needs.

Cutting wires

Wire tension meters

Item No.: 1003 Wire tension meter with pointer

Portable wire tension meter with pointer

- For EDM wire cutters
Measuring range: 100-3000g(cN)

