

## KRISHA ADVANCED MOLY WIRE EDM

**Best in segment features**



- Full 5 Axis CNC & Servo Motors
- Advanced WEDM Software
- Unique Design
- Strong Construction
- Best Surface Finish Ra0.4



Size available up to 2500X1600X1000

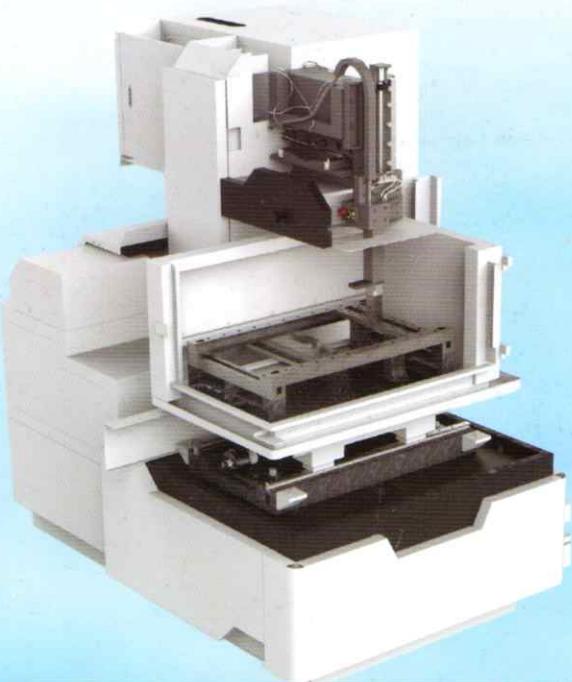
Reach us  
@  
**9500087276**



Easy Finance Option  
Available



## Advanced WEDM Software



## Unique & Strong Design

Model	KM530	KM640	KM850
Workbench Size (mm)	750x500	880x560	1000x700
Axis Travel (X&Y) (mm)	500x350	600x400	800x500
Maximum Cutting Thickness (mm)	300	500	500
Z axis travel (mm)	300	500	500
Maximum load (Kg)	600	900	1500
UV axis travel		70x70	
Max.taper angle (°/mm)		±10°/100	
Wire diameter (mm)		φ0.1~φ0.2	
Position Accuracy (mm)	≤ ± 0. 003	≤ ± 0. 003	≤ ± 0. 005
Repeatability (mm)	≤ ± 0. 002	≤ ± 0. 002	≤ ± 0. 003
Optimum Surface Roughness		R <sub>a</sub> ≤0.8 (Optional 0.4)	
Processing Speed (mm <sup>2</sup> /min)		100~220	
Electrical Power Consumption (kVA)		3	
Water tank capacity (L)		120	
Dimension (L*W*H) (mm)	1781x1660x2030	1920x1750x2100	2190x2100x2780
Weight (Kg)	2050	2500	3260

**Regd. Office:** First Floor, Plot No.278, Royal Town, Mathigiri, Hosur – 635110, Tamilnadu.

**Branches:** Bengaluru, Chennai, Coimbatore, Hyderabad.



Quality | Reliability | Sustainability

# Krishna Mechatronics

*Be inspired*

## KRISHA CNC & ZNC DRILL EDM



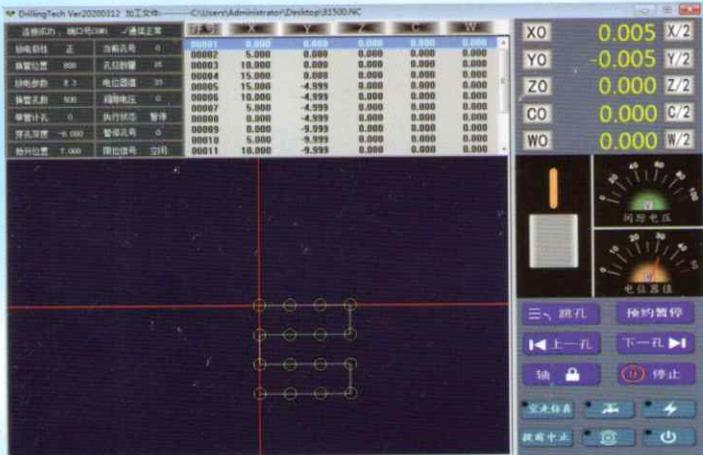
### Best in segment features

- All 3 Axis Servo Motors & Drives
- User friendly touch screen display
- Eco friendly reusable water filtration unit
- Granite Worktable
- Easy programming function
- Spark detection camera



### Best in segment features

- Z Axis Programmable
- All 3 Axis LM Guides & Ball screws
- Motorized W Axis
- Granite Worktable
- Compact in size
- 7 inch LCD Display



## User Friendly CNC Software

## Eco Friendly Filtration Unit

Model	Unit	KM43Z	KM43C
Table travel (X,Y)	mm	400x300	400x300
Work tray size	mm	720x420	720x420
Z axis travel	mm	380	380
W axis travel	mm	280	280
Max workpiece height	mm	300	300
Max workpiece weight	Kg	300	300
Processing current	Amp	30	36
Power capacity	kW	4.2	4.5
Electrode Diameter	mm	0.3 ~ 3.0	0.3 ~ 3.0
Machine net weight	Kg	750	800
Dimension(L*W*H)	mm	850x850x1800	850x850x1800

Reach us @ **9500087276**

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Branches: Chennai, Bengaluru, Coimbatore.

**STANDY** 商鼎®

# 拥有火花机的自主核心技术 专注于火花机的研发和制造

Possess independent and core technologies of EDM  
Be dedicated to the R&D and manufacturing of Electrical Processing



MITSUBISHI ELECTRIC



HIWIN  
※ PMI



Rexroth  
Bosch Group



大理石工作台结构  
提供长时间使用的  
精度稳定性。

The work table is  
made of marble. The  
precision stability is  
improved under  
constant running.

全系机型采用进口激光干涉仪  
调试,确保每一台机器出厂前的  
最佳精度。

All models are commissioned  
with imported laser interferometer  
to ensure best precision for each  
machine tool before delivery.

专注放电技术 20 年,

国内首家拥有高性能火花机智能算法系统软件著作权

Focus on discharge technology more than 20 years, the first enterprise possessed with high performance EDM intelligent algorithm system software copyright in China

# 产品展示



项目 Item	单位 unit	CNC-450C	CNC-400	CNC-430	CNC-540	CNC-850	CNC-1260
工作槽 (长*宽*高) Working slot (L*W*H)	mm	1000x600x380	930x710x300	1000x600x390	1370x800x450	1800x1100x600	2000x1300x700
工作台面规格 Work table size	mm	700x400	600x500	700x400	850x500	1050x600	1250x800
XYZ轴工作行程 (单头) XYZ axis working travel (single head)	mm	450x350x300	400x300x300	450x350x300	500x400x300	800x500x400	1200x600x450
YZ轴工作行程 (双头) YZ axis working travel (double head)	mm						
主轴至台面最低、高点 Lowest and highest points from main axis to the work surface	mm	400-700	250-550	400-700	450-750	500-900	550-1000
最大电极重量 Max weight of electrode	kg	50	50	50	150	200	300
最大工作物载量 Max load for working object	kg	500	600	500	1800	3000	3500
机床规格 (长*宽*高) Dimension of machine tool(L*W*H)	mm	2050x2030x2250	1780x2300x2600	2500x2030x2250	2500x2400x2800	2900x2900x3000	3530x3400x3370
机床总重量 Total weight of machine tool	kg	2500	3500	3000	3500	5000	6000
重复定位精度 Repeat positioning precision				±0.005mm 检测标准 GB/T5291.1-2001		±0.005mm test standard GB/T5291.1-2001	

## 机械安装

考虑安装环境以充分发挥机械的性能

温度：20℃~25℃

湿度：50%左右

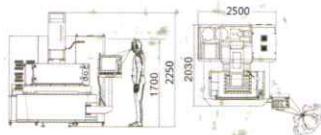
振动：最大瞬态振动<0.5G

## 电气条件

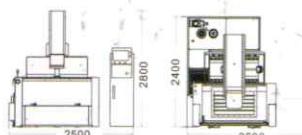
1. 输入电源：三相AC-380 V / 50HZ.当电压波动超过±10%时，建议采用稳压器。

准备好符合CNC电源装置及各种选配件等总电气量的保险开关。接地要10Ω以下的三重施工。

2. 需安装缺相保护器。



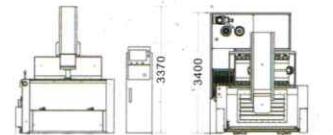
CNC430



CNC540



CNC850



CNC1260

# PRODUCT



CNC-1250 双(double)	CNC-1470 单/双(Single/double)	CNC-1880 单/双(Single/double)	CNC-2110 单/双(Single/double)	CNC-2510 单/双(Single/double)	CNC-3010 单/双(Single/double)	ZNC-430	ZNC-540
2200x1200x590	2500x1300x700	3500x1600x700	3500x1800x850	3800x1800x850	4500x1800x800	1200x650x450	1250x750x480
1200x700	1500x900	2000x1000	2500x1200	2700x1200	3200x1200	700x400	800x500
1200x500x400	1400x700x500	1800x700x600	2300x900x600	2500x900x600	3000x900x600	400x300x200	500x400x200
600x500x400	850x700x500	1050x700x600	1450x900x600	1750x900x600	2400x900x600		
500-900	600-1100	500-1100	650-1250	650-1250	700-1300	400-600	400-700
150	400	400	450	450	450	150	150
3500	6000	8000	8000	10000	15000	1000	1300
3800x3100x3000	4300x3650x3430	5150x3800x3480	5500x4900x3600	5800x5200x3690	6500x5900x3760	2750x1730x2400	3080x1910x2450
单(Single)6000 双(double)7000	单(Single)8800 双(double)9500	单(Single)15000 双(double)17000	单(Single)15500 双(double)17500	单(Single)17000 双(double)19500	单(Single)23000 双(double)25000	1800	2200
± 0.005mm检测标准GB/T5291.1-2001 +0.005mm test standard GB/T5291.1-2001							

## Mechanical installation

The installation environment should be taken into consideration to make the full performance of the machine tool

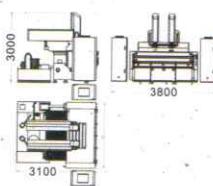
Temperature: 20°C~25°C

Humidity: About 50%

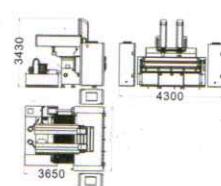
Vibration: Max transient vibration is <0.5G

## Electric conditions

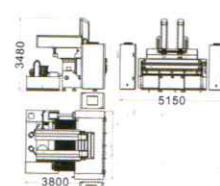
- Power input: 3-phase AC-380V/50HZ. When the voltage fluctuation is over ± 10%, it is suggested to adopt voltage stabilizer. Prepare the fuse switch with total electric capacity meeting the requirements of CNC power device and various options. The grounding shall be lower than 10Ω with triple constructions.
- Open-phase protection is required.



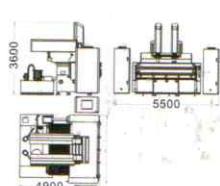
CNC1250



CNC1470



CNC1880



CNC2110

# 专家控制系统 Expertized control system

全集操控采用智能算法软件，使操作更方便

The operation and control of the whole machine adopts intelligent algorithm software, and features more convenient operation.

## 镜面加工

模具工作室高端机型，采用专用的镜面加工回路，无粉镜面加工。超镜面、高镜面、超精边、超清角；高效加工，主轴抬刀速度最大可达10m/min，高速抬刀能有效排除杂质，实现高效的稳定放电和表面的高质量。

## Mirror Series

As the high-end model for mould workshops, it adopts special mirror machining circuit with powderless mirror machining, and features ultra-precise surface, high mirror, ultra-precise edge, super clear angle and effective machining. The cutter lifting speed of the main axis reaches 10m/min, and the high speed cutter lifting is capable of effectively removing impurity, achieving effective and stable discharge as well as high quality surface.

## 石墨加工

模具工作室高效机型，采用专用的石墨加工回路，高速粗加工较铜快3倍，高速精加工较铜快5倍，可加工性好，能实现复杂的几何造型，重量轻，密度不足铜的1/4，电极容易夹持，可减少单个电极的数量，可捆绑做成组合电极。

## Graphite Series

As the effective model for mould workshops, it adopts special graphite machining circuit with the high speed coarse machining 3 times faster than copper, and high speed finish machining 5 times faster than copper. The product features machinability, and is capable of achieving complicated geometric shape with light weight, its density is less than 1/4 of copper, which is easy for clamping with electrode, and can reduce the amount of single electrode since they can be bundled as the combined electrode.

## 硬质合金加工

模具工作室高端机型，采用专用的硬质合金加工回路，无裂痕超硬加工，超精加工低电极消耗；单一结构的底部采用高级铸铁，无变形，适合高密度的模具加工。

## Hard Alloy Series

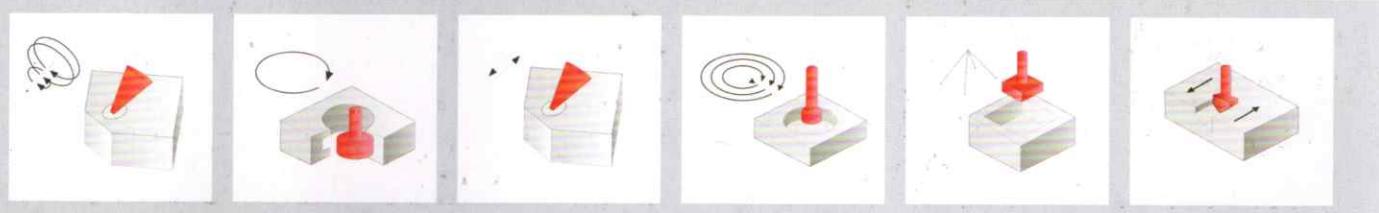
As the high-end model for mould workshops, it adopts special hard alloy machining circuit with crackless and ultra-hard machining, and feature ultra-precise machining and low electrode consumption, the bottom of single structure is made of high grade casting iron without deformation, and is suitable for machining moulds of high precision.



- ① 手动分中功能  
Manual centered function
- ② 自动编程功能  
Automatic programming function
- ③ 自动分中功能  
Automatic centered function
- ④ 标准参数修改功能  
Standard parameters modifying function
- ⑤ 放电分中功能  
Discharge centered function
- ⑥ 文件保存功能  
Files saving function
- ⑦ 步距功能  
Pitch function



## 加工模式 Machining Mode



# 加工实例 Machining Case



工艺 Technology	圆形深腔镜面加工 Round Deep Cavity Mirror Machining	方形深腔镜面加工 Square Deep Cavity Mirror Machining	深腔镜面加工 Deep Cavity Mirror Machining
电极 Electrode	铜 copper	铜 copper	铜 copper
工件 Workpiece	S136H	S136H	S136H
尺寸 Size	Ø40 S=1256MM	40*40*8	80*10*6
加工时间 Machining Time	4h45min	6h	4h
表面粗糙度 Surface Roughness	VDI=RA0.1	VDI=RA0.1	VDI=RA0.1



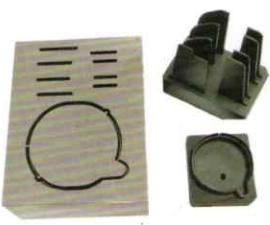
眼镜前后框镜面加工 Spectacle Frame Front and Rear Film Mirror Machining	
使用机型 Applicable Model	CNC 430
电极 Electrode	铜 copper
工件 Workpiece	S136H
尺寸 Size	130*40
加工时间 Machining Time	10h/12h
表面粗糙度 Surface Roughness	VDI=Ra0.1



石墨电极 Graphite Electrode	
直径 Diameter	290x195mm
加工时间 Machining Time	24h
表面粗糙度 Surface Roughness	VDI22号纹 VDI#22 texture

石墨电极 Graphite Electrode	
直径 Diameter	398mm
加工时间 Machining Time	39h
表面粗糙度 Surface Roughness	VDI25号纹 VDI#25 texture



石墨电极加工 Graphite Electrode Machining		
机型 Model	CNC400 (圆骨/Round Rib)	CNC400 (深骨/Deep Rib)
电极 Electrode	石墨 Graphite	石墨 Graphite
加工深度 Machining Depth	11.84	43.84
尺寸 Size	75*66*35	68*43*70
加工时间 Machining Time	3h8min(粗/Rough) 2h15min(精/Fine)	7h15min(粗/Rough) 4h(精/Fine)
表面粗糙度 Surface Roughness	Ra4.5(粗/Rough) Ra1.0(精/Fine)	Ra4.5(粗/Rough) Ra1.0(精/Fine)



石墨深腔骨位加工 Graphite Deep Cavity Rib Machining		
机型 Model	CNC540 (长骨/Long Rib)	CNC540 (短骨/Short Rib)
电极 Electrode	石墨 Graphite	石墨 Graphite
加工深度 Machining Depth	40	20
尺寸 Size	29*2*45	20*1*25
加工时间 Machining Time	5h10min	1h10min
表面粗糙度 Surface Roughness	VDI=21号纹 VDI#21 texture	



## 广东商鼎智能设备有限公司

STANDY Smart CO.,Ltd.

总部: 广东省惠州市惠东县大岭镇拓庆路广东商鼎智能设备产业园  
Headquarter: STANDY Smart Industrial Park, Tuoqing Rd., Huidong County,  
Huizhou City, Guangdong Province

### 东莞分支

长安展厅: 广东省东莞市长安镇金铭模具城3A栋6号 (商鼎)

### 中山分支

中山展厅: 广东省中山市东升镇同乐三路102号116卡商铺商鼎火花机

### 浙江宁波分支

宁波展厅: 浙江省宁波市宁波集士港工贸三路671号广东商鼎智能设备有限公司

### DongGuan Branch

Chang'an Exhibition Hall: No.6, Building 3A, Jinming Mold City, Chang'an Town,  
Dongguan City, Guangdong Province (STANDY)

### ZhongShan Branch

Exhibition Hall: Block 116, No.102 of Third Road, Tongle Street, Dongsheng  
Town, Zhongshan City, Guangdong Province (STANDY)

### NingBo Branch

Exhibition Hall: No. 671, Road 3 of Industry and Trade, Jishi Port, Ningbo  
City, Zhejiang Province (STANDY)



抖音



视频号



快手

[www.standycnc.com](http://www.standycnc.com)

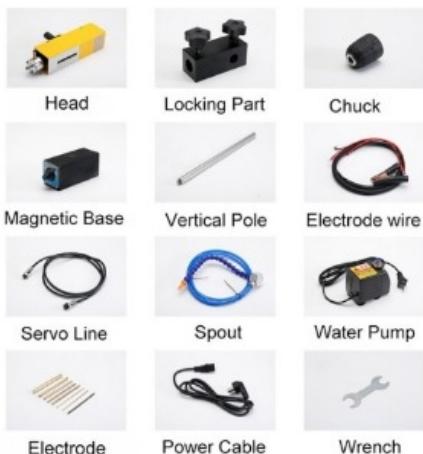
注: 由于不断的研究开发更新, 产品将随设计更改而变化, 恕不另行通知!

Note: Due to the continuous research and development, the product will be updated according to design change. Special notification will not be provided.

## EDM BROKEN TAP REMOVER



### Accessories



### APPLICATION:

- REMOVE BROKEN TAP, DRILL, REAMER, ETC
- USED IN ANY SIZE OR SHAPE OF WORK PIECE

### FEATURES:

- AUTOMATIC FEED PROCESSING
- USING WATER AS WORKING FLUID
- 220V SINGLE PHASE
- HEAD TILTING
- HANDY UNIT

Model	KM 1000W
Input	AC220V 50/60HZ
Power	1000W
Voltage	80V
Electrode range	0.5mm-10mm
Manual travel	310mm
Automatic travel	60mm
Processing speed	≥2.0mm/min
Size	380×200×320mm
Weight	18KG

**contact us for further details**

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