



OKI PZNF



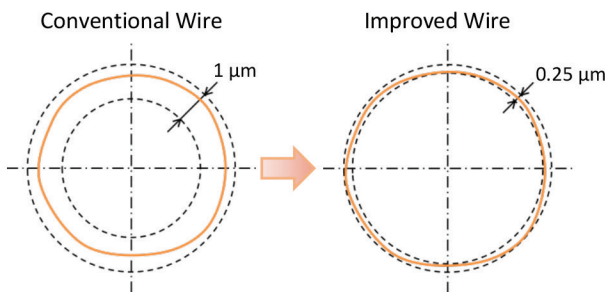
FINE Hi-Tensile Non-Paraffin Brass Wire

Exclusively through Belmont... To meet the increasing demand for high accuracy cutting, OKI has developed a new high quality brass EDM wire. OKI PZNF FINE Hi-Tensile Zinc Enriched, Non-Paraffin Brass Wire has improved the usability and convenience to support higher-quality machining.

4x Better Roundness!

OKI has made advances in their drawing process that improve the roundness of their wires to 0.25 microns or less. This is a 4x improvement over conventional wires. Reducing the variations in roundness also reduces the variations in discharge machining. This greatly improves the machines surface quality.

Roundness Tolerance

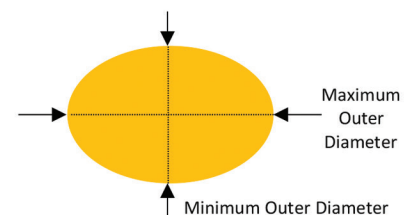
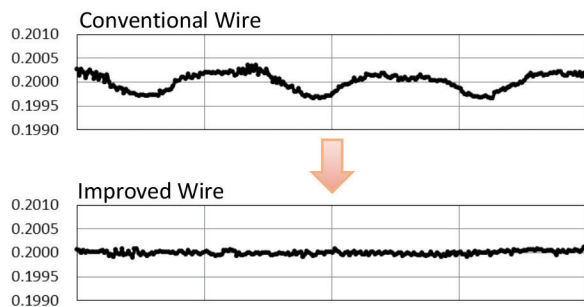


Small Variation

Roundness is the difference between the maximum and minimum radii of the same cross section of an electrode wire.

$$\text{Roundness} = (\text{Maximum outer diameter} - \text{Minimum outer diameter}) / 2$$

Changes in outer diameter during 180° rotation



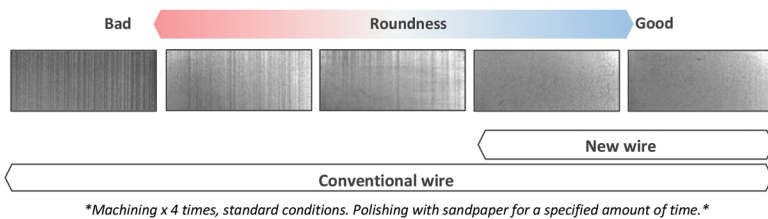
OKI "PZNF" FINE Hi-Tensile Non-Paraffin Brass Wire



Improved Roundness Provides Results...

Reduction of "Streaks" on the Machining Surface

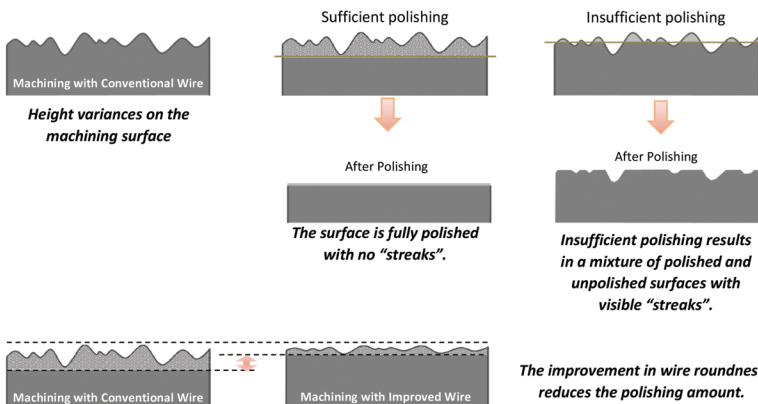
There is a potential "streaks" factor on the machining surface after discharge, even if it cannot be confirmed visually. "Streaks" can become more visible by additional processing, such as polishing. There are numerous factors that can cause "streaks" in wire EDM; including the machine, materials, and electrode wires that are used. However, it's possible to reduce the "streaks" caused by EDM wire by improving the roundness of the wire. The following shows the surface depending on the roundness after EDM processing and a specified amount of polishing:



Fact: Improved roundness reduces "streaks" on the machining surface.

What are "Streaks"?

"Waves" are existing on the surfaces after the wire EDM process; and only the peaks of the waves are scraped off. If the surfaces are not polished enough, the troughs of the waves will remain resulting in visible streaks.



Features

- Increased percentage of zinc for faster cutting and superior surface finishes
- The field proven technology of OKI brass wire guarantees excellent straightness and high tensile strength which are key factors for automatic auto threading and the EDM process.
- Reduction in polishing time
- Dependable wire threading

Specifications

Core Material:	60/40 Composition
Tensile Strength:	130,000 PSI
Diameter Tolerance:	+/- 1 Micron (.001mm or .000039 inches)

Spool Sizes Available

Diameter		Spool Weight		Spool Type	Quantity	OKI PZNF
mm	in	kg	#	Case	Part Number	
0.15	0.006	5	11	P-5R	4	815-061-PZNF
0.20	0.008	6	13.2	TP-5R	4	816-081-PZNF
0.20	0.008	10	22	P-10RA	2	8110-081-PZNF
0.20	0.008	20	44	P-15RA	1	8120-081-PZNF
0.25	0.010	6	13.2	TP-5R	4	816-101-PZNF
0.25	0.010	10	22	P-10RA	2	8110-101-PZNF
0.25	0.010	16	35.2	K200	1	8116-101-PZNF
0.25	0.010	20	44	P-15RA	1	8120-101-PZNF
0.30	0.012	6	13.2	TP-5R	4	816-121-PZNF
0.30	0.012	10	22	P-10RA	2	8110-121-PZNF
0.30	0.012	16	35.2	K200	1	8116-121-PZNF
0.30	0.012	20	44	P-15RA	1	8120-121-PZNF



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