

## AJAX EDM BROKEN TAP REMOVERS



Model

4000B

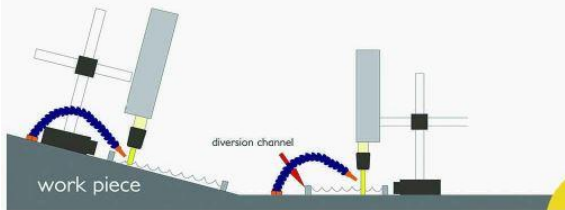
800C

Basic Function		
Stepper Current	✓	✓
Depth setting, auto retract and alarm	✓	✓
Accessories storage	One-in-Box	Toolkit
Technical Parameter		
Input Power ( w )	300~3000	800
Electrode Holder Diameter ( mm )	2-13	0.8-10
Working liquid	Tap water ( Pure water/distilled water is better. )	
Max Process Depth of spindle servo ( mm )	70	70
Short Hole Processing Speed ( mm/min )	≈2	≈1
Processed Material: Quenched Steel	ElectrodeΦ5 ElectrodeΦ12	ElectrodeΦ4
Power Box Size(mm):	420*220*370	380*160*300
Model and size of working head ( mm )	ZK8 300*50*50	ZK8 300*50*50
Package Size ( mm )	528*325*460	498*308*392
Net Weight ( kg )	22	16

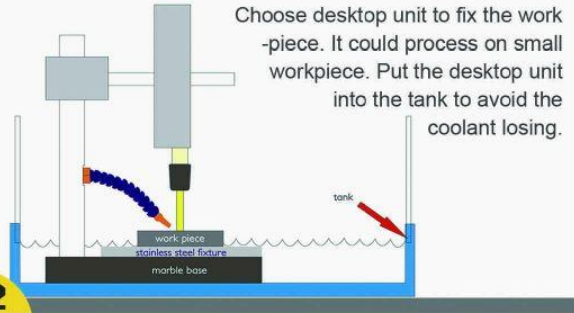
## 2

## Operation Skills

Vertical processing on big workpiece, Adsorb the stand directly on the workpiece, and build a diversion channel under the head to make coolant flow outside.

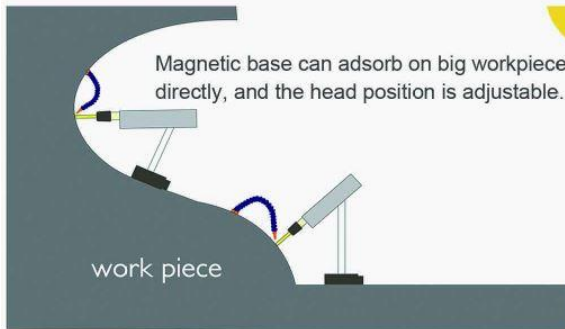


Choose desktop unit to fix the work-piece. It could process on small workpiece. Put the desktop unit into the tank to avoid the coolant losing.

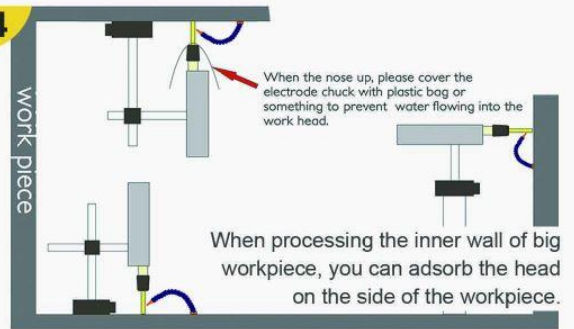


1 2

Magnetic base can adsorb on big workpiece directly, and the head position is adjustable.



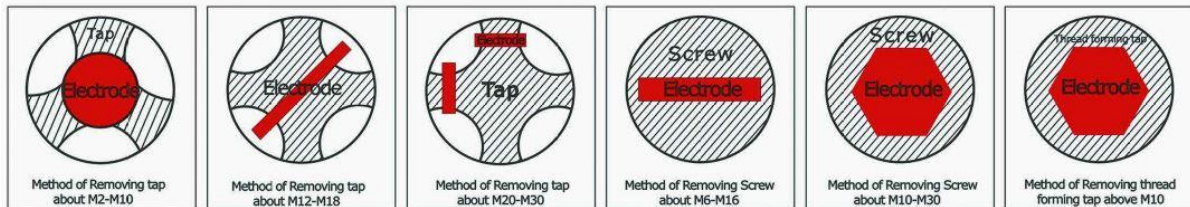
When the nose up, please cover the electrode chuck with plastic bag or something to prevent water flowing into the work head.



3 4

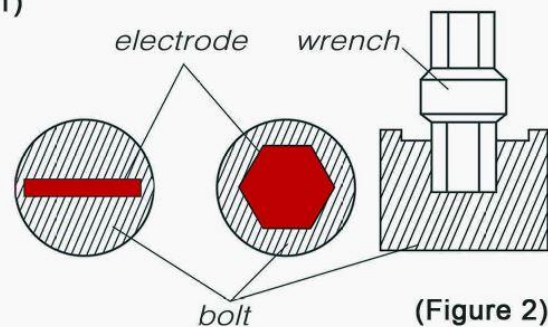
## How to remove broken tap, drill, screw etc. out

The central part for tap, drill is solid. We could remove tap or drill by smashing the central part with the brass rod. When removing tap with bigger size central part, cut the central part into two pieces with sheet electrode, or cut the four corners of the tap. In actual operation, when processing in a specific depth, turn back the work-head, rap the debris with chisel and use tweezer or magnet to remove the debris. By doing this, will decrease the discharge area and improve the working efficiency. (Figure 1)



(Figure 1)

When the diameter of the screw is too big or its strength grade is over 8.8, general processing method is unsuitable. You can process a groove of 2-3mm depth with a sheet electrode. Then unscrew it with a screwdriver or hexagon spanner. If the processing position is too deep for general screw extractor, the hexagon spanner would help. (Figure 2)



(Figure 2)