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Legacy Wire EDM Tutorials



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WIRE EDM TUTORIALS

The Tutorials section of the manual is designed to introduce you to actually working with the GibbsCAM Wire EDM package. There are three tutorials, one covering 2-axis parts, another covering 4-axis parts and the last covering open profile parts. All of the tutorials start with a part file that came with your Wire EDM package. For more information on topics brought up in the tutorial, refer to the EDM User guide, "Use and Reference" chapter.

- Tutorial #1 Wire EDM 2-Axis
- Tutorial #2 Wire EDM 4-Axis
- Tutorial #3 Wire EDM Open Profile

TUTORIAL #1 - WIRE EDM 2-AXIS

In this tutorial you will become familiar with working with the GibbsCAM Wire EDM interface and creating a simple 2-axis EDM part. You will need to have GibbsCAM and the Wire EDM package installed and licensed.

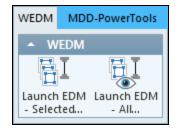
- 1. Launch GibbsCAM.
- 2. Open the file die block.vnc. The file should be located in a folder that was installed along with your Wire EDM package.

Public Documents Gibbs Journal of the Parts	Documents library				
			Arrange by:	Folder *	
Advanced 3D	Name	Date modified	Туре	Size	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
Advanced CS	ie blockvnc	6/21/2012 2:21 PM	GibbsCAM 2012+	56 KB	1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1 1
Machine Sim	🖉 four asis.vnc	6/21/2012 2:21 PM	GibbsCAM 2012+	45 KB	
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🛛 🎥 Plug-Ins					
PlungeRough					+X: 3.0000 +Z: 1.00
Production					× 1000
Radial Milling					-T 1500
Solids					*T: 1,5000 -Y: -1,5000
Tombstone Management Sys					
VoluMill					Version: 10.3
4 🎍 Wire EDM					
Semple Parts					
🕌 Tutorial Parts 🔹	1				
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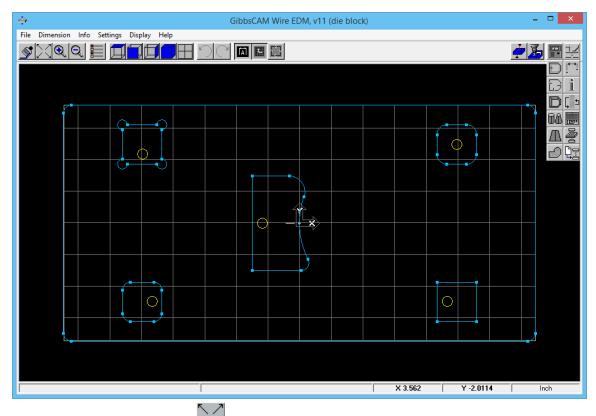
In top view (Ctrl+H), the part looks like the following image.

		\odot
0	• • •	•

- 3. Select all of the geometry on the screen (Ctrl+A).
- 4. Select Launch EDM Selected Geometry from the Wire EDM menu.



Your Wire EDM screen will look as shown below.



5. Click on the Zoom Full button in the top Toolbar, to fit the geometry to the screen.

The first thing we need to do is to set the wire configuration and strategy.

6. Click on the Wire Configuration button. It is in the Top Level palette going down the right side of the screen.

Clicking on the Wire Configuration button will activate the dialog shown below. This dialog is where you will specify the type of wire machine you have, wire display, the Z top of the part, part thickness, part orientation and the output for Z planes.

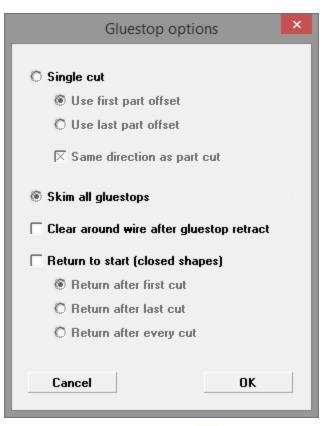
7. Enter the values as shown.

Machine configu	ration M	achine strategy	Y Displa	ay settings
Machine			Wire diameter	
Configure	fanuc	•	Dia 0	0.010 🔹
Datums	Technology	settings	Hard Brass	•
Wire guides			Material	
Z height of upper	wire guide	1.0	Z top of material	1.0
Z height of lower	wire guide	0.0	Part thickness	1.0
Output Z planes			Aluminum	•
Use actual ge	ometry sizes		Part orientation	
Z height for UV d	lata	1.0	Standard (Land on top of	(1)
Z height for XY d	ata	0.0	Upside down	rpartj
Same as	top and bottom of m	aterial	C (Land on botto	m)
	nits when creating c		Advanced	

8. Click on the Machine strategy tab. Enter the values shown below. This sets the preferences for how we are going to machine this part.

Machine configuration	Machine stra	egy Display setting	8
Skim cut direction © All cuts in same direc ® Reverse alternate cut Matrice distance		Skim cut transition None Line off/on Arc off/on Retract distance 0.01	
Gluestop removal		Arc radius 0.01	
 Manually remove glue Cut gluestops after ro 	ugh cut	Arc angle 90 Reverse alternate cuts	
Cut gluestops after al Extend gluestop Arc off	Distance 0.01 Radius 0.01	Multiple parts © Complete each part © 2 stage, rough first	
Line off Gluestop options	Angle 90 Distance 0.01	○ 2 stage, rough-skim first ○ 3 stage, rough-skim-gluest □ Custom strategy Sel	ops ect
Parts with land © Rough land before tag © Rough taper before la © Rough taper only □ Skim the taper		Corner loop Corner re Add loops to external corn Minimum angle 0 Min overlap - 0.1	

 Click on the Gluestop options tab. Make sure the Skim all gluestops option is checked and click OK.

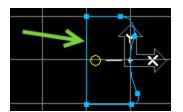


- 10. When you have finished, click OK. Now that we have set up the machine, we can begin to put toolpath on our geometry.
- 11. Click on the Create or edit a wire part button in the Toolbar.

Looking at the bottom of the screen, we can see that we are being asked to pick the profile to be cut.



12. Select the area of the middle profile as shown.



You now get the Create Wire Part dialog.

Create Wire Part (closed pr	ofile)			x
Cut type Parallel cut Full height taper Taper with land Number of cuts 1 3 2 4		☐ 4 axis	X Modify glue	Y estop/lead in lart element
Number of cuts	Sel	ected cuts	⊠ Initial cut di □ Create multi	
02 04	<u>о</u> б	õ 8	Close	OK

This dialog allows you to set Cut type, Start position and the number of skim cuts.

We now need to select a start point for the cut.

13. In the current dialog click on Select start point.



The bottom of the screen is asking us to select a start point.

14. Select the point in the middle profile as shown.

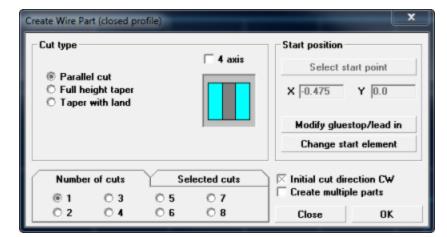


You will now see a dialog, as shown below, displaying the coordinates of the start point. We need to set the width of the gluestop.

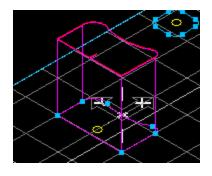
15. Enter the value shown here and click OK.

Gluestop lead in/out		x
Start point	-0.475	0.0
Start hole diameter	0.125	
Approach distance	0.0	
Gluestop width	0.01	Cancel
		OK

You will be sent back to the Create Wire Part dialog.



- 16. Click OK.
- 17. Click the ISO View button in the top Toolbar.
- 18. Click the Zoom Full button in the top Toolbar.



This will put the part into isometric view and fit the geometry and the toolpath to the screen. The results of your toolpath will look like the image on the left.

This is a simple example of how to create a wire path. Now we will go back and modify the toolpath.

19. Right-click anywhere on the profile to open the Right-click menu.

Wire part: Die
Line: info
Num cuts =1
Cut len =3.7
Rev prof dir
Delete machining
Pattern repeat
User data
Properties

20. Select Properties.

Clicking on Properties opens the Modify Wire Part dialog. This dialog looks similar to the Create Wire Part dialog that we used to generate the toolpath. We will use this dialog to modify the toolpath in order to set a taper and the number of skim cuts.

Parallel cut Full height taper Taper with land Modify	
	on ct start point Y pluestop/lead in e start element
Number of cuts Selected cuts ⊠ Initial cu	t direction CW ultiple parts OK

21. Click the Full height taper radio button.

This modifies the dialog to include a Taper angle text box and a different graphic.

22. Enter a taper angle of 5 degrees.

Modify Wire Part (closed p	rofile)			x
Cut type Cut type Full height taper Taper with land Taper angle	5	- 4 axis	Start position	Y 0.0
Number of cuts		elected cuts	⊠ Initial cut dire □ Create multip	
01 03	05 06	0 7 © 8	Cancel	Update

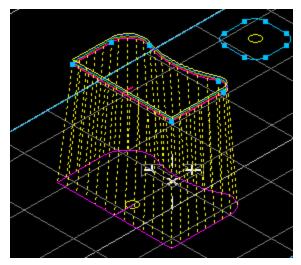
Next we will add some skim cuts.

23. In the Number of cuts section, click the 4 radio button to set four skim cuts.

Your dialog will look like the image above.

24. Click Update.

The dialog will close and the result is an updated toolpath as shown in the image below.



The actual height between each displayed skim cut and the number as well as the color of the dashed 4-axis lines will vary depending on your Display settings found in the Wire strategy/configuration settings dialog.

There is geometry on this part that was not covered in this tutorial. You can use this geometry for continued practice with different machine settings, tapers etc.

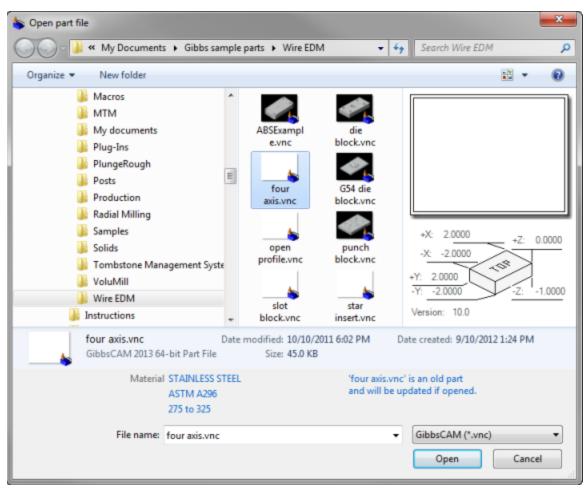
Save GibbsCAM EDM		Sample Parts 🕨	Wire EDM WEE	OM Parts 👻	€9 Search WEDM I	Parts P
Organize 🔻 New	folder)II • 🕡
Advance Machine MTM	ed CS 🔺	Documer WEDM Parts	nts library		Arrange	by: Folder 🔻
Plug-Ins	s	Name	*	Date modified	Туре	Size
 Solids Tombst VoluMil Wire ED Sampi Tutori 	tion Milling ≡ tone Ma			No items match your sear	rch.	
File name:	die block.gw	rx				•
Save as type:	GibbsCAM E	DM Parts (*.gwx)				•
Hide Folders					Save	Cancel

25. Save this file in case you would like to go back and work with it at a later date.

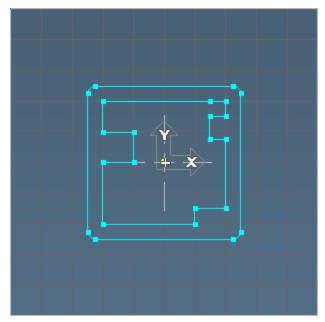
TUTORIAL #2 - WIRE EDM 4-AXIS

In this tutorial you will learn how to create a 4-axis Wire EDM part. Additionally, the lessons learned in the first tutorial will be reinforced through practice.

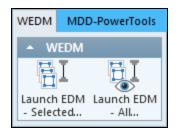
- 1. Launch GibbsCAM.
- 2. Open the file Four Axis.vnc. The file should be located in a folder that was installed along with your Wire EDM package.



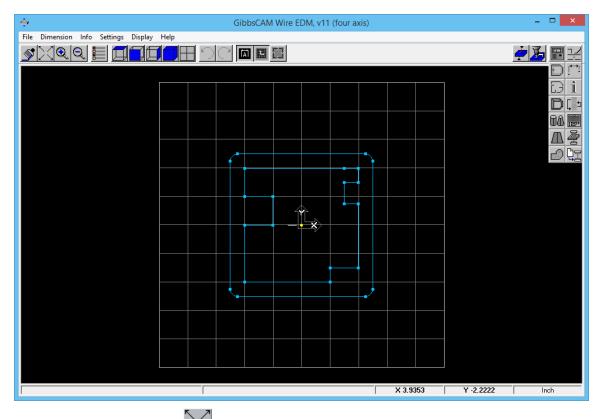
The part will look as shown below.



- 3. Select all of the geometry on the screen (Ctrl-A).
- 4. Select Launch EDM Selected Geometry from the Wire EDM menu.



Your Wire EDM screen will look like following image.



5. Click the Zoom Full button in the top Toolbar to fit the geometry to the screen.

The first thing we need to do is to set the wire configuration and strategy.

- 6. Click the Wire Configuration button III. It is the top left button in the Top Level palette.
- 7. Enter the values shown in the dialog below.

Machine configuration Y Machine strategy	Y Display settings
Machine	Wire diameter
Configure fanuc -	Dia 0.010 -
Datums Technology settings	Hard Brass 💽
Wire guides	Material
Z height of upper wire guide 0.0	Z top of material 0.0
Z height of lower wire guide -1.0	Part thickness 1.0
Output Z planes	Aluminum
Use actual geometry sizes	Part orientation
Z height for UV data 1.0	Standard
Z height for XY data 0.0	(Land on top of part)
Same as top and bottom of material	© (Land on bottom)
Check travel limits when creating code	Advanced settings

8. Click the Machine strategy tab and enter the settings shown below.

Machine configuration	Machine strat	tegy Display settings
Skim cut direction		Skim cut transition
All cuts in same direct	ion	O None
Reverse alternate cut:		C Line off/on
🖂 Retract distance	0.01	Arc off/on
		Retract distance 0.01
Gluestop removal		Arc radius 0.01
Manually remove glue:	stops	Arc angle 90
Cut gluestops after rou	ugh cut	Reverse alternate cuts
Cut gluestops after all	skim cuts	M. K. L
Extend gluestop	Distance 0.01	Multiple parts Omplete each part
Arc off	Radius 0.01	© 2 stage, rough first
	Angle 90	© 2 stage, rough-skim first
🖂 Line off	Distance 0.01	O 3 stage, rough-skim-gluestops
Gluestop options		Custom strategy Select
Parts with land		
O Rough land before tap	er	Corner loop Corner relief
Rough taper before la		Add loops to external corners
C Rough taper only		Minimum angle 0
Skim the taper		Min overlap + 0.1

9. Click the Gluestop options tab and select the Single cut radio button.

Gluestop optior	าร	×		
Single cut				
		- 1		
W Use first part offset				
🛇 Use last part offset				
Same direction as part c	ut			
🛇 Skim all gluestops				
🗌 Clear around wire after glues	stop retract			
🗖 Return to start (closed shape	es)			
Return after first cut				
🛇 Return after last cut				
🛇 Return after every cut				
Cancel	OK			

10. When you have finished, click OK.

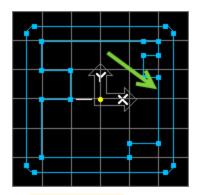
Now that we have set up the machine, we can begin to put a toolpath on our geometry.

11. Click the Machining button in the Top Level palette.

Looking at the bottom of the screen, we can see that we are being asked to pick the profile to be cut.



12. Select the area of the middle profile as shown.

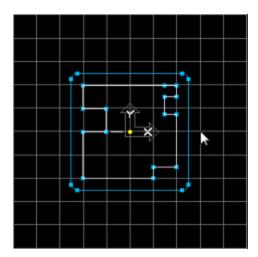


The Create Wire Part dialog opens, ready for us to select the type of cut we want to make.

We now need to select a start point for the cut.

Create Wire Part (closed profile)		×
© Cut type © Parallel cut © Full height taper © Taper with land	☐ 4 axis	Start position Select start point X Y Modify gluestop/lead in Change start element
Number of cuts		Close OK

- 13. Click the Select start point button.
- 14. The bottom of the screen is asking for a start point. Select the approximate point shown below. It is a point outside of the profiles.



You will now see a dialog displaying the coordinates of the start point. We need to set the width of the gluestop.

15. Enter the values shown below and click OK.

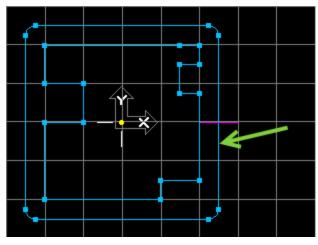
Gluestop lead in/out		×
Start point	1.2	0.0
Start hole diameter	0.0	
Approach distance	0.0	
Gluestop width	.01	Cancel
		OK

We have been sent back to the Create Wire Part dialog to select the lower profile and the number of cuts to take.

16. Click the 4 axis checkbox. Also set the dialog to take four cuts, as shown below.

Create Wire Part (closed profile)			×
Cut type Full 4 axis 4 axis with land Select lower profile	∝ 4 axis	Start position Select st X 1.2 Modify glues Change upper Change lower	Y 0.0 top/lead in start element
Number of cuts S © 1 © 3 © 5 © 2 © 4 © 6	ielected cuts © 7 © 8	⊠ Initial cut dire □ Create multipl Close	

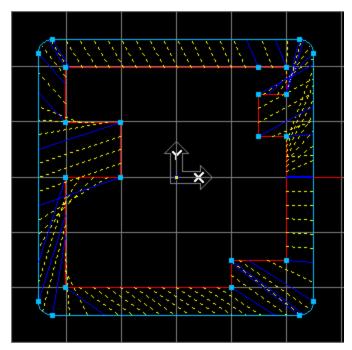
- 17. Click the Select lower profile button.
- 18. Select the profile as shown to designate the lower profile.



When you select the lower profile, we are sent back to the Create Wire Part dialog to finish setting up the toolpath.

19. Click OK.

The results of our work will look like the image below.



Looking at the toolpath, we probably have some more work to do, as is often the case with 4axis parts. We need to synchronize the wire path.

In order to sync this toolpath, we need to break some of the elements. To make this easier, we are first going to turn on the Command repeat option.

- 20. Click the Configuration button in the top Toolbar to open the Configuration dialog.
- 21. Activate the Command repeat function and close the dialog



The Command repeat function allows us to perform the same action multiple times without having to repeatedly open a dialog and select a command.

- 22. Click the Edit /Modify geometry button ____ in the Top Level palette.
- 23. Click the Split Element button in the Edit Geometry palette.

The Split element dialog provides several ways to break geometry.

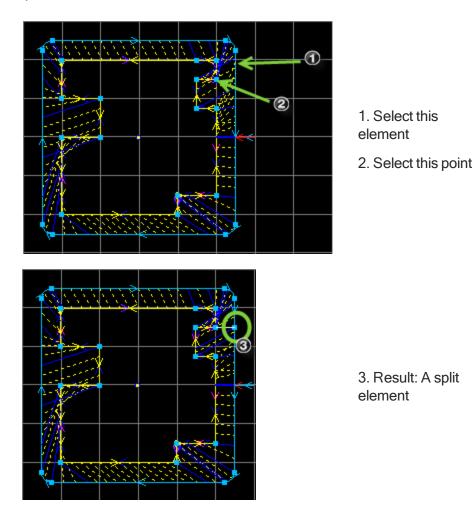
24. Select the first method–Normal to element, through a point.

Split method	
Normal to element, through a provide the second	point
O Parallel to line	
Tangent to arc end	
O Actual distance along element	t
Percentage distance along ele	ement

25. Click Select line/arc.

To use the Normal to element, through a point function, we must first select the element we want to split, then we select the point normal to the element. The element will then be split at this point.

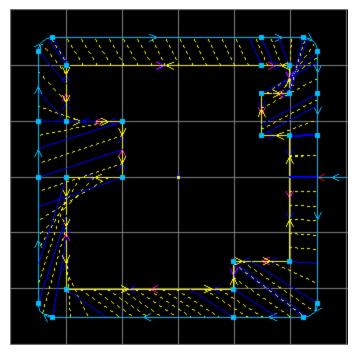
26. Split the element as shown here.



Go through the part and split the elements in the places shown below.

6		
0		
	-><	
<u> </u>		

After splitting the elements, your screen will look like the following image.



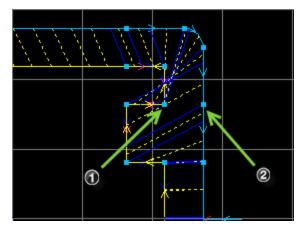
While the results do look better, the part still needs some work. We need to manually sync some points.

27. Click the Sync button in the Top Level palette.

Notice the bottom of the screen is prompting us to pick an element in the top profile that needs a sync point.

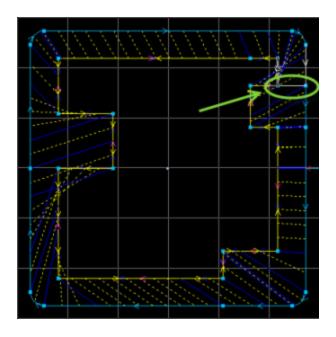


28. Select the points as shown in the following image.

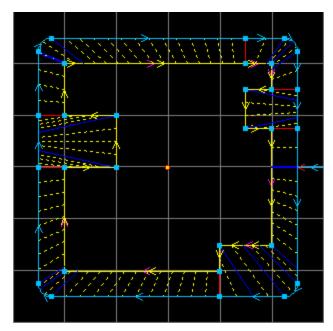


After the point on the top profile is selected, the bottom of the screen prompts you to pick the sync point on the bottom profile. A line attaches your cursor to the top profile and will remain that way until the bottom sync is selected or a right-click is performed.

After clicking the two points you will see that the points are now synced. We have some more syncs to add to complete the part.

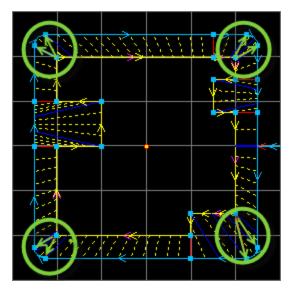


29. Add syncs at each of the elements that we split. Click Redraw . The toolpath will look like the following image.

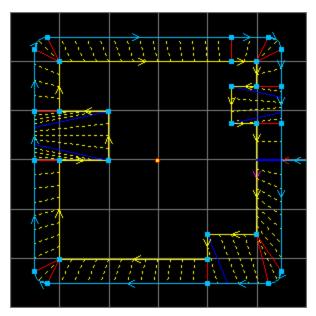


This is better, but the toolpath at the corners is still not optimal. We will not get clean, sharp corners with this toolpath. We will need to add syncs from some of the corners of the top profile to the rounded corners of the bottom profile. Remember each element may have two syncs.

30. Add a sync from the corners to the ends of the rounded corners as shown here.

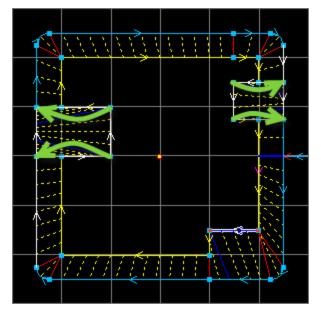


This is better.

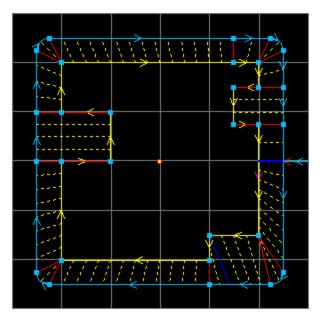


The exterior corners are controlled but the toolpath is still not optimal in the interior corners. The way to fix this is to have overlapping syncs from the interior corners.

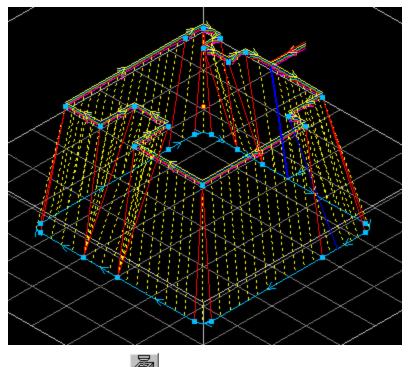
31. Create a sync from the interior corners to the split elements as shown below.



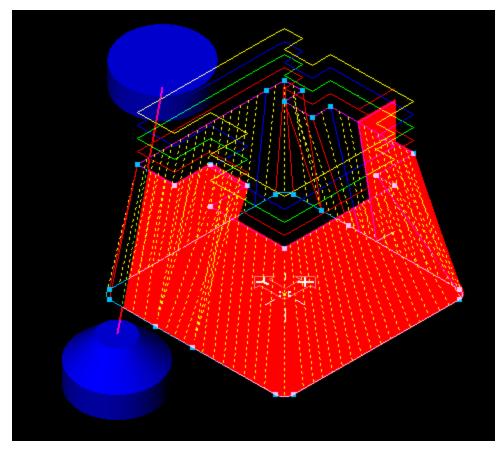
This results in good toolpath.



32. Switch to isometric view to see the part complete with all of the skim cuts.



33. Click the Simulation Button. Use the default settings, click Go to see the rendered part.

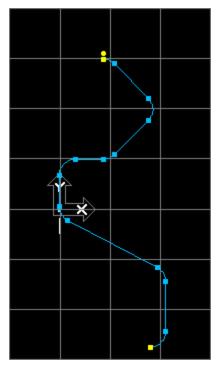


34. Be sure to save the part.

TUTORIAL #3 - WIRE EDM OPEN PROFILE

In this tutorial you will learn how to create a Wire EDM part from open profile geometry. An open profile part is really not that different than a closed profile part, but there are certain things to keep in mind.

1. Launch GibbsCAM and open the part Open Profile.vnc.



2. Select all the geometry (Ctrl-A) and transfer the data to the Wire EDM package.

The first thing we need to do is to set the wire configuration and strategy.

- 3. Click the Wire Configuration button III. It is the top left button in the Top Level palette.
- 4. Enter the values shown here.

Machine configuration Machine strategy	Display settings
Machine	Wire diameter
Configure fanuc 🔹	Dia 0.010 -
Datums Technology settings	Hard Brass 🔹
Wire guides	Material
Z height of upper wire guide 0.0	Z top of material 0.0
Z height of lower wire guide -1.0	Part thickness 1.0
Output Z planes	Aluminum
Use actual geometry sizes	Part orientation
Z height for UV data 1.0	 Standard (Land on top of part)
Z height for XY data 0.0	 Upside down
Same as top and bottom of material	C (Land on bottom)
Check travel limits when creating code	Advanced settings

5. Click the Machine strategy tab and enter the settings shown.

Machine configuration	Machine stra	itegy 🍸 Displa	y settings
Skim cut direction O All cuts in same direct ® Reverse alternate cuts T Retract distance		Skim cut transition None Line off/on Arc off/on Betract distance	0.01
Gluestop removal		Arc radius	0.01
O Manually remove glue:	stops	Arc angle	90
 Cut gluestops after rou Cut gluestops after all 	ugh cut	Reverse alternate	cuts
Extend gluestops arter an Extend gluestop Arc off	Distance 0.01 Radius 0.01 Angle 90	Multiple parts © Complete each pa © 2 stage, rough firs © 2 stage, rough-ski	ŧ
🖂 Line off	Distance 0.01	 O 2 stage, rough-ski O 3 stage, rough-ski 	
Gluestop options	,	Custom strategy	Select
Parts with land C Rough land before tap Rough taper before la C Rough taper only Skim the taper		Add loops to exter Minimum angle	Corner relief nal corners 0 • 0.1

6. Click Gluestop options tab and enter the settings shown.

Gluestop options	×		
 Single cut Use first part offset Use last part offset Same direction as part cut 			
Skim all gluestops Clear around wire after gluestop retract			
Return to start (closed shapes) ® Beturn after first cut			
© Return after last cut			
🛇 Return after every cut			
Cancel OK			

7. When you have finished, click OK. (Click OK again to dismiss any warning message (which might occur if the Cutter Radius Compensation settings are not as the system desires). We have set up the machine. We can now put a toolpath on our geometry.

Check to ensure that the direction indicators are pointing from the top of the part to the bottom.

If arrows are not being drawn on your geometry, change this in the Configuration dialog from the top Toolbar.

Show-Hide	🖂 Command repeat	Redraw	
☑ Dimensions	🖂 Display Grid	L	
Axes		Colors	
Profile start	Units	Bashun	
🖂 Dir indicators	Metric Inch	Backup	
☐ Rapid moves		Undo	

- 8. Now click the Machining button in the Top Level Palette.
- 9. Click anywhere on the part.
- If the indicators are pointing in the wrong direction ie. not downwards, close the Create wire part dialog by clicking OK. The part will turn red in color. Right-click on any line. A dropdown menu will appear.

Open profile
Line: info
Num cuts =1
Cut len =7.0
Rev prof dir
Delete machining
Pattern repeat
User data
Properties

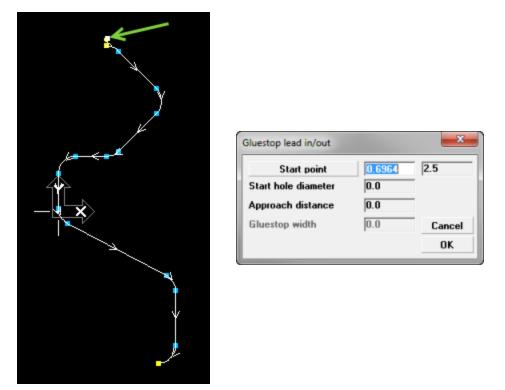
11. Choose Rev Prof Dir. Click the Machining button and then anywhere on the part again.

Open profile parts travel in one direction and have a definite starting place, so the element you click on to select a profile to cut does not matter

12. Enter information in the Create Wire Part dialog as shown here.

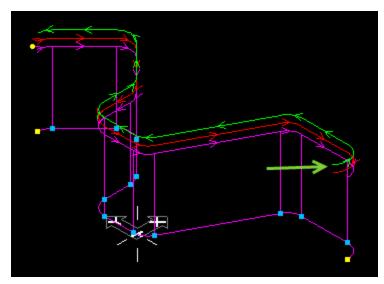
Create Wire Pa	art (open pro	ofile)		X
	el cut eight taper with land		4 axis	Start away from profile Start position Select start point X 1.45 Y Select exit point X 0.696447 Y 2.4
01	r of cuts © 3 © 4	05 06		Adjust start/end of profile Extend start Extend end Gluestop 0
Offset dire None		Left	Ô Right	Create multiple parts Close OK

- 13. When you are ready, click Select start point.
- 14. Select the point that lies above the open profile and click OK in the Gluestop lead in/out dialog.



15. Click OK in the Create Wire Part dialog to generate the wire toolpath.

There is a problem with the toolpath. We selected the Extend End option, which causes the wire to cut into the part.



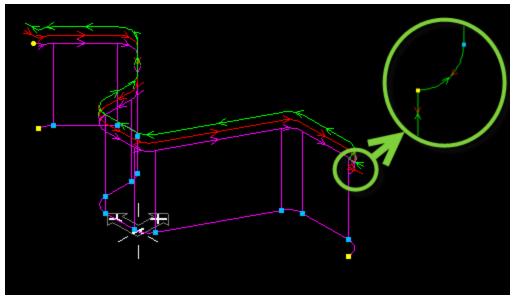
Instead of tangentially coming off the part we actually want to exit at 90 degrees when we cancel compensation.

16. Right-click anywhere on the EDM part and select Properties from the menu to modify the operation.

17. Turn off Start away from profile and Extend end. Enter a Normal Entry/Exit move of 0.25 as shown here and click on Update to change the operation.

Modify Wire Pa	art (open pro	ofile)			x	
© Cut type © Parallel cut © Full height taper © Taper with land		☐ 4 axis	Start away from profile Entry/exit moves None Tangential Normal (90 deg) Line length 0.25			
Number of cuts Se		elected cuts	Adjust start/end	0		
				Extend end	0	
01	03	© 5 © 6	07 08	Gluestop	0	
Offset direction ® None © Left © Right						

The results of the modified operation look much better with a sufficient lead-in and lead-out.

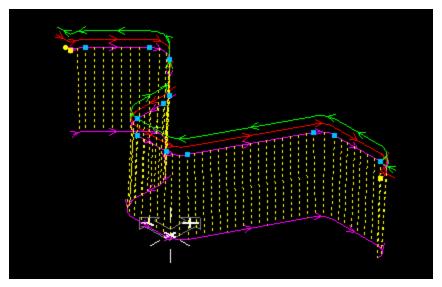


We are now going to make one last modification to this part, which is to add a taper.

18. Right-click on the profile to open the dialog and make the changes shown.

Modify Wire Part (open profile	e)		×		
Cut type Parallel cut Full height taper Taper with land Taper angle	-3	Start away from profile Entry/exit moves None Tangential Normal (90 deg) Line length 0.25			
		Adjust start/end	of profile		
Number of cuts	Selected cuts	Extend start	0		
01 03	05 07	Extend end	0		
	° 6 ° 8	Gluestop	0		
Offset direction					
	, C night	Cancel	Update		

19. Click Update to generate the following path.



We will now post process this part.

- 20. Click the Create CNC Code button.
- 21. Enter a name in the Tape filename box and click GO.

Simulation	0		×
Cut		•	
	X Y	🖂 Create	
	U V	Solid di	splay
	🖂 Display toolpath	Step	Stop
Post	fanuc •	60	Close
Tape	filename C:\DOCUMENTS AND SETTI	View code	

The rendering will run and code will be generated simultaneously.

Simulation	on		×		
Cut	Rough cut X -0.0524 Y 0.2916 U 0.0 Y 0.2916	 ✓ Create code ✓ Solid display ✓ Step 			
	🖂 Display toolpath	Step	Stop		
Post	fanuc	G0	Close		
Тар	e filename D:\Users\open	View	code		
D:\Users\open					
	N15 G02 X0.873 Y2.327 I0.0 J-0.25 N16 G01 X1.423 Y1.777 N17 G02 Y1.423 I-0.177 J-0.177 N18 G01 X0.873 Y0.873 N19 G02 X0.696 Y0.8 J0.177 N20 G01 X0.25 N21 G03 X0.0 Y0.55 I0.0 J-0.25 Close				

22. Save the part when you are done.