



cobracut[®] Type A

Wire EDM of highest precision

bedra® - Qualified for the Highest Demands



When cutting electrically conductive workpieces using wire EDM, the type and quality of the wire electrode has a decisive influence on the performance and results. Anyone depending upon the best possible results while making the highest demands on the cutting speed, accuracy and finish, will need a precision electrode in which the physical, electrical and mechanical properties are matched exactly to the conditions in the spark gap.

Motor of Progress

bedra®, the world-leading non-ferrous fine-wire specialist has the necessary know-how at its disposal in non-ferrous metallurgy and processing technology. Like no other manufacturer, bedra® has pushed ahead with the development of coated wire electrodes to produce a precision tool capable of quality and high performance, thus contributing to the worldwide success of EDM wire cutting. With the functional coatings for wire electrodes developed by bedra, an enormous increase in removal performance – and hence in productivity – can be achieved. Moreover, a reproducible high precision and surface quality is attained.

All From A Single Source

The entire manufacturing process for the wire electrodes takes place within the bedra® facilities. Consistent, high quality is assured by company's use of virgin metals within its own specialized foundry, the company's own galvanic coating and annealing equipment and its own precision drawing facilities. This single source of knowledge, experience and manufacturing control makes bedra®'s quality certification of ISO 9001 possible.



cobracut® type A - Coordinated technology

The zinc-coated **cobracut®** type A electrode was developed in close collaboration with AGIE® and has provided outstanding results on AGIE® machines for years. It's proven performance is due to its good cutting performance and high accuracy. In scientific studies it has been shown that the thermophysical properties of zinc (low vaporization temperature means less gap contamination, a high affinity for oxygen and good environmental compatibility) in particular have an advantageous effect on efficient wire cutting. Zinc makes a constant discharge rate possible. Discharge peaks are avoided. The use of **cobracut®** type A is especially recommended for cutting carbides and PCDs in order to minimize microcracks and produce the finest finishes.

Coated is not the same as galvanized

All wires are not created equal. There are several ways to coat or plate EDM wire. bedra's choice is electro-galvanizing. This of course is not the least expensive method but the ability to precisely manage electro-plating provides better control over the purity, evenness and cleanliness of the layers. For years our process has been proven very successful in the manufacture of precision wire electrodes.

Great straightness and accuracy

Due to its great straightness qualities, **cobracut®** type A is especially suited for machines with automatic wire threaders. In addition, with the diameter accuracy of the wire electrode of $\pm 1\mu\text{m}$ per spool and $1.5\mu\text{m}$ from spool to spool, makes it possible to achieve uniform part accuracy and repeatability.



cobracut® –
the original by bedra



cobracut® Type A

| | core material | coating material | tensile strength | elongation | colour |
|-------------------------|----------------|------------------|--------------------------------------|----------------|---------------|
| cobracut® type A | CuZn36 | Zn | 130,000 PSI 900 N/mm ² | 1% | bright silver |
| Ø [inch] | 0.006 | 0.008 | 0.010 | 0.012 | |
| Ø [mm] | 0.15 | 0.20 | 0.25 | 0.30 | |
| spools | | | | | |
| bedra 4 | • ¹ | • ¹ | • ¹ | • ¹ | |
| bedra 8 | • | • | • ¹ | • ¹ | |
| bedra 16 | | • | • | • | |
| spools | | | | | |
| K100 | • ¹ | • ¹ | • ¹ | | |
| K250 | | • | • | • | |
| K355 | | | • | • | |

¹ automatic threading not guaranteed

- hard galvanized zinc-coated wire electrode
- for highest demands on reproducible precision and surface quality
- high straightness for proper automatic threading

bedra high-performance wire electrodes are available through authorized dealers and the original equipment manufacturers. We will gladly recommend a distributor close to you.

授权代理商



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