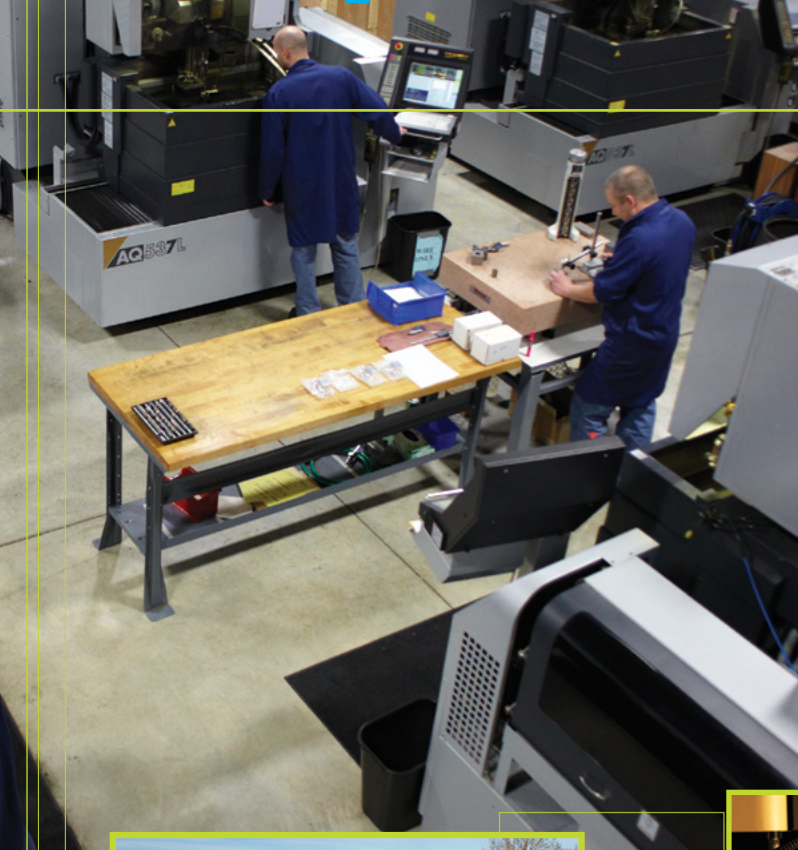


**XACT**  
Wire EDM Corporation

People and Technology Providing Precision Wire EDM

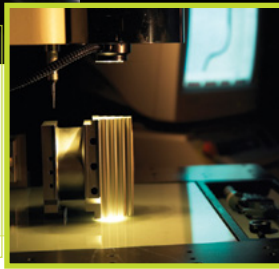


## XACT Wire EDM Corporation

*An extension of your capabilities completely devoted to wire EDM.*

*Xact is a specialized company dedicated to being the premier provider of wire EDM services. Our exclusive focus on wire EDM results in benefits to you. Since 1984, this dedication means that we have kept current with technological changes and have improved our skills in one field, wire EDM.*

*Our people continuously adhere to the highest standards of excellence and integrity. Our goal is to build successful long-term partnerships between Xact and the customers we serve.*



### The Advantages of Wire EDM Machining

Wire EDM is a method to cut conductive materials with a thin wire electrode that follows a programmed path. The hardness of the work piece material has no detrimental effect on the cutting speed. The CNC machine can independently move the four machine axes to generate taper cuts. Wire EDM can be accurate to  $\pm 0.0001$ " ( $.0025\text{mm}$ ). Virtually no burrs are generated. Also since no cutting forces are present, wire EDM is ideal for delicate parts. No tooling is required so delivery times are short. Components are machined after heat treatment so dimensional accuracy is not affected by heat treat distortion.

### Our Capabilities

Xact is one of the largest capacity EDM shops in the country and can handle any size or type of project. Our programming department has broad expertise and our quality system is ISO certified. Using our services will enhance your business by giving you access to the latest in wire EDM technology.

- Aerospace
- Automation
- Automotive
- Communications
- Cutting Tools
- Defense
- Electronics
- Energy
- Food
- Medical
- Packaging
- Paper Processing
- R & D / Prototypes



## Welcome



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Waukesha, WI 53186  
262.549.9005  
Fax: 262.549.9115  
www.xactedm.com

720 Industrial Dr. Unit 126  
Cary, IL 60013  
847.516.0903  
Fax: 847.516.1287  
xact-il@xactedm.com

We would like to welcome you to Xact Wire EDM Corporation. Xact Wire EDM has been providing high quality, cost effective wire EDM services to companies worldwide since 1984. With **45 wire EDM machines and 8 CNC high-speed small hole machines**, we can provide deliveries of large or small projects to meet your needs. Both of our locations in Waukesha, WI & Cary, IL are **ISO 9001:2015 certified**. Our state of the art inspection equipment allows us to accurately inspect your projects. We also offer **laser part marking** on your parts if required. Both locations run **around the clock 5 days a week** to serve your needs! Our goal is to work with you as your strategic vendor on your wire EDM needs and/or as an extension of your own in house machining.

Feel free to contact us with any questions you may have on an application or about our services. You can also visit and bookmark our website [www.xactedm.com](http://www.xactedm.com) for more information, and to see our latest videos and testimonials.



## Contacts



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# High Speed Small Hole EDM



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## CURRENT SIZE CAPABILITIES

Electrode Diameter	Finished Hole Size	Maximum Thickness
0.010" .25mm	.012-.015" .34mm	1/4 inch 6mm
0.012" .30mm	.014-.017" .39mm	1/2 inch 13mm
0.015" .38mm	.017-.021" .48mm	1 inch 25mm
0.019" .50mm	.022-.027" .62mm	2 inches 50mm
0.024" .60mm	.027-.032" .75mm	2 inches 50mm
0.026" .66mm	.029-.034" .80mm	3 inches 75mm
0.031" .78mm	.034-.039" .93mm	4 inches 100mm
0.039" 1.0mm	.042-.047" 1.13mm	5 inches 125mm
0.043" 1.1mm	.046-.051" 1.23mm	5 inches 125mm
0.047" 1.2mm	.050-.055" 1.33mm	6 inches 150mm
0.051" 1.3mm	.053-.058" 1.41mm	6 inches 150mm
0.055" 1.4mm	.058-.064" 1.55mm	6 inches 150mm
0.062" 1.6mm	.066-.069" 1.71mm	up to 9 inches* 225mm
0.067" 1.7mm	.070-.076" 1.85mm	up to 9 inches* 225mm
0.075" 1.9mm	.078-.083" 2.05mm	up to 9 inches* 225mm
0.090" 2.3mm	.093-.101" 2.46mm	up to 9 inches* 225mm
0.118" 3.0mm	.121-.126" 3.14mm	up to 9 inches* 225mm

\* Up to 14" part height possible depending on part configuration.

### Notes:

Finished hole sizes may vary depending on the type of material, material thickness, and machining conditions. Typical tolerance held is +/- .005"

Maximum XY travel: X - 22.25" Y - 14.25"

Other sizes may be available with lead time and/or large quantity orders

## Equipment List



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### EDM MACHINES:

3 Charmilles	Robofil CF400	12.6" x 17.7" travel and 10.5" thick
3 Charmilles	Robofil 4020	12.6" x 17.7" travel and 14" thick with 30 degree taper capability
7 Charmilles	Robofil 510	15.7" x 27.5" travel and 16" thick with 30 degree taper capability
2 Charmilles	Robofil 310	9.8" x 15.6" travel and 16" thick with 30 degree taper capability
5 Charmilles	Robofil 300	9.8" x 15.6" travel and 16" thick with 30 degree taper capability
4 Charmilles	Robofil 290	9.8" x 15.6" travel and 8" thick with 30 degree taper capability
1 Charmilles	Robofil 230	8.6" x 13.8" travel and 8" thick with 30 degree taper capability
1 Sodick	AQ 300L LN1	7.87" x 11.81 travel and 7.87" thick with 20 degree taper capability
2 Sodick	AQ750L	19.68" x 29.53" travel and 15.75" thick with high taper capability
1 Sodick	AG600L	15.75" x 23.62" travel and 13.78" thick with taper capability
4 Sodick	AQ 537L Premium	14.57" x 22.44" travel and 13.78" thick with 25 degree taper capability
6 Sodick	AG400L	11" x 15.7" travel and 9.8" thick with 25 degree taper capability
3 Sodick	AQ400L	11.81" x 15.75" travel and 9.8" thick with 25 degree taper capability
3 Sodick	AQ 327L	14.5" x 10.6" travel and 9" thick with 20 degree taper capability

### High Speed Small Hole EDM Machines

1 Charmilles	SH-2 Small Hole EDM Machine	7.8" x 11.8"
1 Sodick	K1CN CNC EDM Drilling Machine	11.8" x 15.7"
2 Current	CT300 CNC EDM Drilling Machine	12" x 8" w/ automatic electrode changer
1 Current	CT400 CNC EDM Drilling Machine	15.75" x 12" w/ automatic electrode changer
2 Current	CT500 CNC EDM Drilling Machine	14"x 22" w/ automatic electrode changer
1 Belmont	SY-4050ST Oil-based CNC EDM Drilling Machine	19.6" x 15.7" w/ automatic electrode changer

### INSPECTION EQUIPMENT:

OGP Avant ZIP 300 Video Inspection System (multi-sensor) 12" x 12" travel  
OGP Smartscope ZIP 250 Video Inspection System 6" x 10" travel  
OGP Flash 500 Video Inspection System (multi-sensor) 18" x 18" travel  
Optodyne MCV-500 Laser Doppler Displacement Meter  
2 Brown & Sharpe Global 575 CMM with PH10M indexable head and PCDMIS CAD++  
2 Brown & Sharpe Reflex 454 CMM 18"x20"x16" with reverse engineering capabilities  
1 Keyence IM7030 Instant Measurement System 7.8" x 3.9"  
2 14" Profile Projectors with 10x 20x and 50x lenses, and linear digital scales  
1 Mahr Digimar CX 1 Height Measuring Station  
1 Mitutoyo Height Master with .000005" graduations and digital readout  
Smart Profile 3D Fitting Software and Minitab statistical software package

### SUPPORT AND MISCELLANEOUS:

SolidWorks, Key Creator, Esprit, Peps and ability to read most CAD files  
NIST 800-171 secure file transfer ITAR registered FFL License  
E-mail address: [xactwire@xactedm.com](mailto:xactwire@xactedm.com) Web page: [xactedm.com](http://xactedm.com)  
2 Tykma Zetalase (with rotary) laser marking machines 1 GT Schmidt Microlase laser and pin stamping machine

**XACT**

**Wire EDM Corporation**

**Toll Free: 1.800.798.9228**

**[www.xactedm.com](http://www.xactedm.com)**

**Corporate Headquarters**

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