User Guide for AccuteX EDM Power Libraries

The AccuteX power setting libraries are organized based on the units (English or Metric), then by wire diameter size. Once you are in the correct wire diameter that you are using, you then go into the subfolder for the material type you will be cutting.
Using the following information you will decide which power setting is the one you need for your application.

How the files are named:

The filenames describe the material, thickness, and the number of intended passes and are broken down into 3 parts for English and 4 parts for metric.

Example: SKD_0197_1.POWER

English method:

1> The first part is for material type. '**SKD**'_0197_1.POWER
2> The next part is the value for material thickness. SKD_'**0197**'_1.POWER
3> The next part is the number of intended passes. SKD_0197_'**1**'.POWER

Metric method:

1> The first part is for material type. '**SKD**'_0197_1.POWER
2> The next part is a metric identifier. SKD_'**M**'_0197_1.POWER
3> The next part is the value for material thickness. SKD_'**0197**'_1.POWER
4> The next part is the number of intended passes. SKD_0197_'**1**'.POWER

1 - Material Type

The “SKD” in the above example stands for Steel.

The material abbreviations used are as follows:
SKD = Steel
ALU = Aluminum
COP = Copper
TUNG = Tungsten

2 - Metric Identifier

The metric identifier is there to help remind you if you are in inch or metric part of the library. You know that if you look at a filename and it has the 'M', it is metric values and not inch.

3 - Material Thickness

The ' 0197' is material that is .197” thick. The format is 1.3 which means
1 place before the decimal is always shown and 3 places after.

Examples: 0197 = .197

1181 = 1.181
3150 = 3.150
11810 = 11.810

NOTE: The material thickness is always in English (Inch) values.
Even the metric library is defined using inch thickness. This also applies to the wire diameter.

4 - Number of passes

The last number is for identifying how many passes you will be taking on the part. This does *not* automatically set Mastercam to take that many passes. It just holds the correct offsets and condition codes used to make that number of passes.

Wire Sizes & Material in Library

English	Metric
.004 diameter wire	**.004 diameter wire**
SKD-Steel	SKD-Steel
.006 diameter wire	**.006 diameter wire**
SKD-Steel	SKD-Steel
.008 diameter wire	**.008 diameter wire**
Copper	Copper
SKD-Steel	SKD-Steel
Tungsten	Tungsten
.010 diameter wire	**.010 diameter wire**
Aluminum	Aluminum
Copper	Copper
SKD-Steel	SKD-Steel
Tungsten	Tungsten
.012 diameter wire	**.012 diameter wire**
Aluminum	Aluminum
SKD-Steel	SKD-Steel