

# Wire electrodes for wire electric discharge machining

# CT-Wire

## SH Series Wire electrodes for high speed machining

The SH series for high-speed machining was created to satisfy the demand of short delivery time. Special composition brass wire significantly speeds up the machining. We offer it with confidence as a product that will satisfy your needs.

### SH series wire characteristics

- 1 Improved conductivity due to unique brass wire composition.
- 2 Improved conductivity provides higher discharge energy compared to generic brass wire.
- 3 Lower powder generation compared to zinc coated wire.



### Machining speed

The discharge gap increases with the increase of the machining speed. Therefore, it is necessary to make the offset several microns larger than for general brass wire. In addition, it is recommended to make a test cut to ensure the machining speed.

### Automatic wire connection rate

The wire connection can be done in the completely same condition as when setting the brass wire machining.

### Positioning accuracy

The same positioning accuracy as for brass wire can be ensured.

## Product specifications

| Material                            | Nominal wire diameter [mm] | Tensile strength [N/mm <sup>2</sup> ] | Elongation [%] | Conductivity [%IACS*] | Wire diameter tolerance [mm] | Roundness [mm] |
|-------------------------------------|----------------------------|---------------------------------------|----------------|-----------------------|------------------------------|----------------|
| Bronze wire with unique composition | 0.20, 0.25, 0.30           | Min. 700                              | Min. 0.4       | 25≤                   | ±0.001                       | Within 0.001   |

\*[%IACS] indicates the international standard for annealed copper wire.

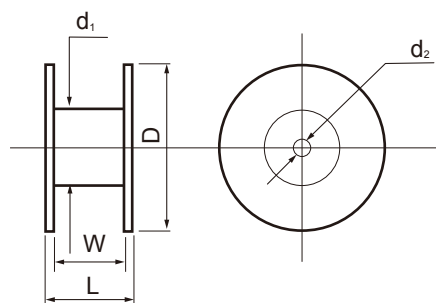
## Line-up

| Wire diameter | Bobbin (net weight) |            |            |             |
|---------------|---------------------|------------|------------|-------------|
|               | P5 (5kg)            | P10 (10kg) | P20 (20kg) | DP30 (30kg) |
| 0.20          | ○                   | ○          | ○          | ○           |
| 0.25          | ○                   | ○          | ○          | ○           |
| 0.30          | ○                   | ○          | ○          | ○           |

## Bobbin shape (unit: mm)

| Product name | D<br>Flange diameter | d <sub>1</sub><br>Barrel diameter | L<br>Outer width | W<br>Inner width | d <sub>2</sub><br>Shaft hole diameter |
|--------------|----------------------|-----------------------------------|------------------|------------------|---------------------------------------|
| P5           | 160                  | 90                                | 114              | 90               | 20                                    |
| P10          | 200                  | 90                                | 134              | 110              | 25                                    |
| P20          | 250                  | 110                               | 140              | 110              | 34                                    |
| DP30         | 280                  | 200                               | 220              | 180              | 73                                    |

\*Please contact the distributor for bobbin shapes not mentioned in this table.



## Product list

| Wire diameter | Non-paraffin products |               | Weight (quantity)  |
|---------------|-----------------------|---------------|--------------------|
|               | Product code          | Product name  |                    |
| Φ0.20         | 1023233               | CTW-20SH-P5   | 5kg reel (4 pcs.)  |
| Φ0.25         | 1023234               | CTW-25SH-P5   |                    |
| Φ0.30         | 1023235               | CTW-30SH-P5   |                    |
| Φ0.20         | 1023323               | CTW-20SH-P10  | 10kg reel (2 pcs.) |
| Φ0.25         | 1023324               | CTW-25SH-P10  |                    |
| Φ0.30         | 1023325               | CTW-30SH-P10  |                    |
| Φ0.20         | 1023463               | CTW-20SH-P20  | 20kg reel (1 pc.)  |
| Φ0.25         | 1023464               | CTW-25SH-P20  |                    |
| Φ0.30         | 1023465               | CTW-30SH-P20  |                    |
| Φ0.20         | 1023683               | CTW-20SH-DP30 | 30kg reel (1 pc.)  |
| Φ0.25         | 1023684               | CTW-25SH-DP30 |                    |
| Φ0.30         | 1023685               | CTW-30SH-DP30 |                    |

\*Please contact the distributor for wire diameters, weights and bobbin sizes not mentioned in this table.



**Chiba Techno Co.,Ltd.**

■ **Head office** Klingelberg bldg 2F, Shin-Yokohama 1-13-12,  
Kouhoku-ku, Yokohama-shi, Kanagawa, 222-0033  
TEL : +81-45-473-9933 FAX : +81-45-473-9729

■ **Yuzawa Factory** Nakakawara 116-7,  
Fukabori, Yuzawa-shi, Akita, 012-0051  
TEL : +81-183-73-0106 FAX : +81-183-73-0199

<https://chb.co.jp/en/>

Distributor