

CREATOR



ELECTRIC DISCHARGE MACHINE FOR TIRE MOLD

**CREATOR**  
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AGENT :

**CJ-500S / CJ-580T**

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ENVIRONMENT. TECHNOLOGY. APPLICATION. CE

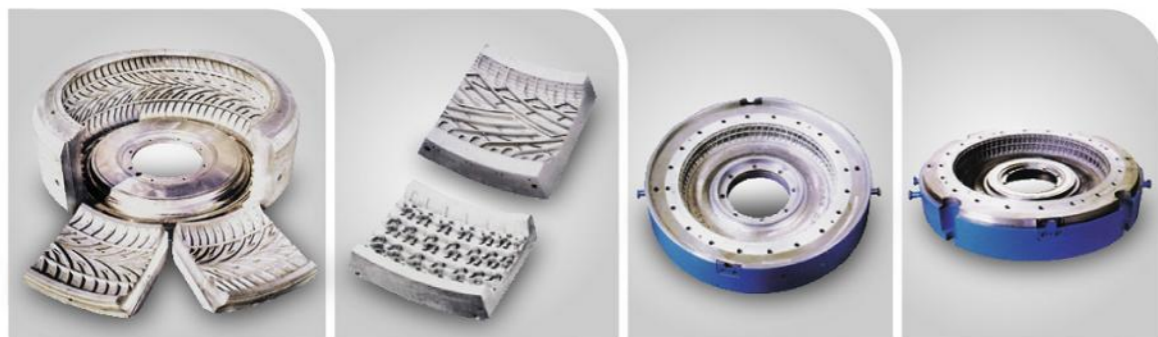


# EDM for Tire Molds

A new and Better Way to machine Tire Molds



CREATOR



Mold Samples

With CREATOR EDM for tire molds you can overcome the difficulties often encountered in tire mold machining. CREATOR engineers combine EDM with indexing table and specially designed control system to develop EDM for machining tire molds. Its benefits include greatly upgraded mold machining and efficiency, excellent surface finish and profitable production.

# FEATURES OF THE MACHINE

Widely applications tire mold diameter from 200mm upto 1200mm all you can make!



**CJ-500S**

Table travel (X axis)	mm	80 / 3.15
Table travel (Y axis)	mm	500 / 19.86
Quill travel (Z axis)	mm	220 / 8.66
Work head travell (Z2 axis)	mm	220 / 8.66
Index table diameter		320 / 12.60
Suitable for mold diameter from $\phi \sim \phi$	$\phi$	400 ~ 800 15.74 ~31.49
Index tilting angle		0° ~ 90°
Max. Capacity of dielectric fluid	litre	450 / 113
Max. Electrode weight	kg	75 / 165
Max. Workpiece weight	kg	450 / 990
Machine dimensions	mm	1840 x 1220 x 2370 88.58 x 48.0 x 93.31
Weight of machine unit	kg	2500 / 5500

• Continuing improvement will allow the maker to modify the design or specification without notice.



**CJ-580T**

Travel	mm	X=70, Y=480, Z=180, Z1=890
Rotary table diameter	mm	1150 / 1300
Z axis front and back angle		Front 30° / Back 45°
Z axis left and right angle		30°
Max. Electrode weight	kg	40
Max. Workpiece weight	kg	1200
Max. Workpiece diameter	mm	1200
Min Workpiece diameter	mm	300
Max. Workpiece thickness	mm	350
Workpiece tank size	mm	1270 x 780 x 430
Oil tank size	mm	2500 x 800 x 440
Max capacity of dielectric fluid	liters	400
Machine weight (Incl. indexing unit)	kg	4500

• Continuing improvement will allow the maker to modify the design or specification without notice.

## CJ-500S CJ-580T

- Designed for machining segmental molds, radial parting molds and various tire molds.
- The mold can be rotated 0° - 90° , facilitating mold setup. An encoder is equipped to ensure high positioning accuracy of mold.
- Y-axis can be rotated to meet the machining requirement for side patterns of radial parting mold and stamping steel plate.
- X-axis permits tilting for efficient residue exhaust, while upgrading machining stability and efficiency.
- Micrometric adjustment on X,Y-axis makes electrode adjustment with ease.
- The workhead can be adjusted to side for increased convenience for mold setup.

## Features of Indexing Mechanism

- ▶ Unlimited machining programs fully meet flexible machining requirements such as various angles and patterns of tire molds.
- ▶ Relative coordinate, absolute coordinate and constant indexing function make the machine suitable for machining any tire mold.
- ▶ Random home position function. Machining home position can be set as desired.
- ▶ Specially designed protection function to prevent electrode from bumping against the mold.
- ▶ Indexing accuracy 1.001°.
- ▶ Allows for inconsistent indexing machining.



### Features of CNC Control

- ▶ The control employs INTEL PENTIUM industrial grade master board.
- ▶ 15" TFT LCD monitor.
- ▶ Conversational operation interface.
- ▶ Automatic table type editing for 10-step machining programs creation.
- ▶ Tungsten steel, extra hard and special material eroding circuit.
- ▶ MPG handwheel for micrometric positioning adjustment.

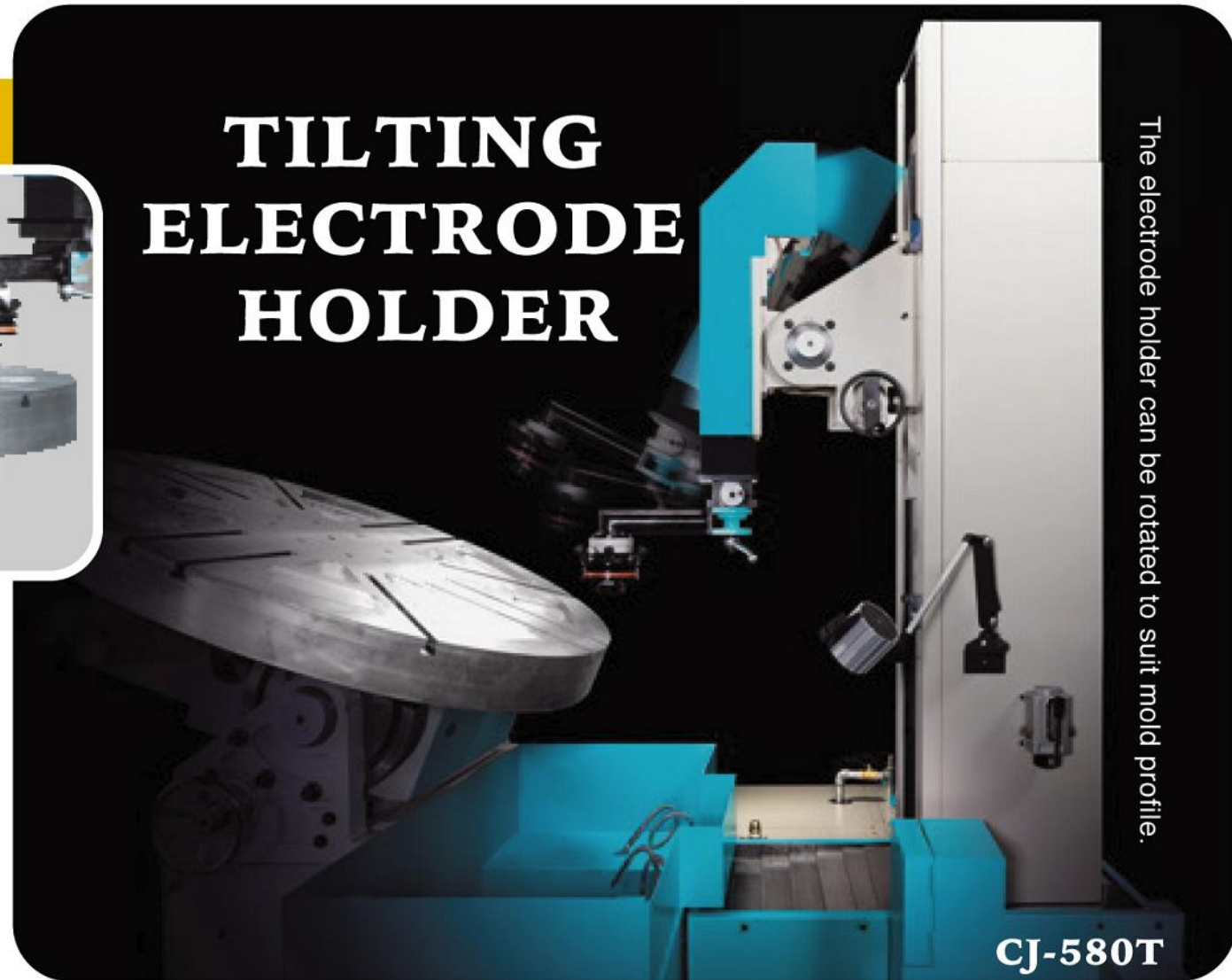
## CR-6C

### Specifications of Power Supply Unit

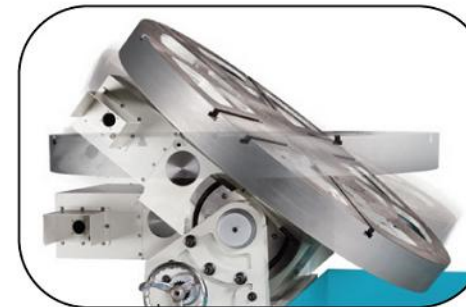
Model		75A	100A
Input voltage	3ø V	220.415 380.440	220.415 380.440
Input power	KVA	8	10
Working voltage (No load)	V	100	100
High voltage	V	150 or 270	150 or 270
Min. ON TIME	μS	1	1
Min. OFF TIME	μS	1	1
Max. Cutting speed	mm <sup>3</sup> / min	720	1050
Best surface finish	μmRa.	0.2	0.2
Min. Electrode wear rate	%	0.3	0.3
Weight	kg / lbs	180 / 396	205 / 452

• One extra power unit. Continuing improvement will allow the maker to modify the design or specification without notice.

## TILTING ELECTRODE HOLDER



CJ-580T

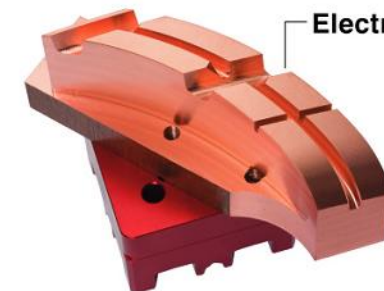


#### Encoder

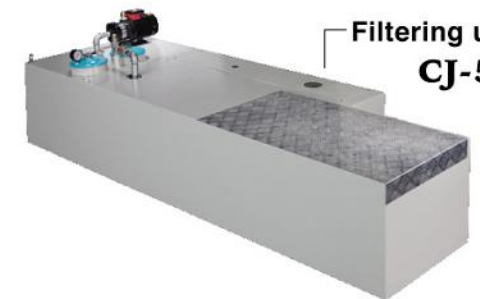
The table tilting mechanism is equipped with an encoder, ensuring high positioning accuracy of mold.

#### Tilting Table

The table can be tilted 0°-90°, allowing for convenient mold setup.



Electrode



Filtering unit  
CJ-580T