



BELMONT
EQUIPMENT & TECHNOLOGIES
Divisions of Cleary Developments, Inc.



Astec 2Z400/P2 High Speed EDM Drilling Attachment

The **2Z400/P2** Fast Hole EDM Drill Attachment provides fast and accurate machined holes in any electrically conductive material. This component system allows for small-hole EDM drilling capability to be adapted onto existing machine tools such as standard type knee mills or custom build bases for special production applications or as a replacement to rejuvenate your old drill. The drill head can be mounted in a vertical or angular position to accommodate different drilling requirements.

The **Astec 2Z400/P2** is compact, and easy to operate with simple keypad data entry. The enhanced microprocessor and quick response DC Servo motors, along with the standard triplex pump, drills smaller, faster, and deeper holes using brass or copper tube electrodes. Built in soft start logic assures that by approaching the work piece with low electrode power, gradually increasing to full power, a clean entrance hole is obtained, eliminating burrs and scarred work surfaces caused by molten splatter.

An **Auto-Z** feature is built into the control for automatic cycles and interfaces with ancillary equipment such as indexers and positioning devices, optimizing the machine for production applications. This feature holds zero on the Z-axis until first spark, thus compensating for electrode wear. Programming the depth of cut, retract stroke and machine settings are all accomplished from the keypad.

The **P2 Power Supply** can store up to **16** parameter sets, which can be recalled as necessary. The drill sequence can contain up to three parameter sets which are called up based on the depth of penetration of the electrode during the cut, this allows even more control over the cut, customizing it for special applications.



P2 Power Supply

Max. Machining Amperage, Mean/Peak	30/50 amp
Peak Amperage Selection (IP)	1 through 15
On and Off-time Pulse/Pause Selection	1 - 999 Microsecond
Servo and Sensitivity Controls	Programmable
Internal Capacitor Box	0-1.7 Microfarads
Voltage and Ampere Meters	Analog
Red All Stop Emergency Button	
Sealed Push Button Control Panel designed for shop use.	
Interface capability via M code or contact closure signal.	

Z-Axis Servo Head

The head unit is made for easy attachment to any flat surface. The head incorporates a DC servo feed motor, an AC spindle rotation motor, and guide for locating the electrode. Z-axis positioning is via rotary encoder, direct to shaft feedback. This unit features a 400mm Z-axis EDM stroke as standard.



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