

SEG 1500

Precision Honeycomb Finishing System



setcoTM
Spindles & Slides

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For over 20 years the Spark Erosion Grinding (SEG) system has been used to machine honeycomb seals and rings for jet engines. These are expensive components that have been remanufactured to like-new condition at a fraction of the cost of new replacement parts. The SEG process is efficient and superior to the mill-type remanufacturing process— typically reducing machine time by 30 to 50%. The process is simple. For cylindrical parts, a lathe or turning center is used to secure the honeycomb part and provide part rotation. The SEG spindle is mounted to the cross slide and fed into the part for stock removal. AC electrical current is fed through the spindle arbor to form a controlled arc between the electrode wheel and the metallic honeycomb. As the SEG spindle is fed into the part the electric arc erodes away the honeycomb to machine the part to finished diameter.

SEG Processing Features

- Burr free honeycomb finishing (min. clean-up)
- Finish machine to manufacturer's specs with minimal mechanical preparation
- Up to .020" stock removal per pass (alternate methods remove .005" per pass)
- Machine contour shapes with tracer control or by using shaping electrodes
- No contact "electrical machining" process reduces cutting force strain on the part
- Machine honeycomb down to 1/50" cell size
- Machine foil down to 0.002" thickness
- Machine with coolant to flush away particles, and help cool the wheel and part
- Low maintenance-- requires only periodic coolant replacement
- Electrode wheels can be economically manufactured from cold rolled steel
- Easily integrates with existing equipment.

General SEG 1500 Specification

Input Power	3 ph, 60hz, 230V or 460 single voltage. Specify connection voltage on order. Special voltages available upon request.
SEG AC Output Power	0 to 24 VAC Up to 125 amps, Continuous 170-200 amps, peak (3 sec max.)
Spindle	SETCO Model 2701.5-36GTY Motorized Grinding Spindle 1-1/2 hp, 3600 rpm 12.1" Nose Barrel Length Tapered Arbor. Style 1 ANB Wheel Holder. SEG 1500 includes standard aluminum spindle mouting bracket.
General Application Limits	Honeycomb Metal Structure Machines foil down to .002" thickness Machines down to 1/50" cell size Metal removal: .020" / pass approx.
Electrode Wheel	Cold Rolled Steel - 6 included: (2) 4", (2) 5", and (2) 6" dia. wheels 1.250" Bore x 1/4" Wide.
Cabling	Plug-type Connections 14' Connection Cables (std). Consult factory for special lengths.
Shipping Info	Weight: 1050 lbs with Crate (approx.) Shipping Crate: 60"L x 40"W x 50"H

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