



cobra cut®

The coated wire electrode series COBRA CUT® was developed with AGIE for EDM machines. They are suitable for a number of different machine models and for practical applications.

The series includes six types of high-quality wire electrodes:

COBRA CUT® COBRA CUT® Type A COBRA CUT® Type G
 COBRA CUT® Type B COBRA CUT® Type D COBRA CUT® Type S

COBRA CUT®

These zinc-coated wire electrodes were initially produced for AGIE for their first AC machines. Due to its high elongation, it is particularly suitable for high tapering. It has a limited suitability for machine models with automatic water-jet threading.

	base material	coating material	tensile strength	elongation	colour	
cobra cut®	CuZn37	Zn treated	500 N/mm ²	15%	light grey	
Ø (mm) spools	0,10	0,15	0,20	0,25	0,30	
bedra® 4	• ¹	•	•	•	•	
bedra® 8		•	•	•	•	
bedra® 16			•	•	•	
K 100	•	•	•	•	•	
K 125		•	•	•	•	
K 160		•	•	•	•	
K 200			•	•	•	
K 250			•	•	•	

¹ Filling weight 2,0 kg

Zn treated

CuZn37

COBRA CUT® Type A

This hard, zinc-coated wire electrode is especially suitable for machines with automatic threaders. Due to excellent straightness and precision, it guarantees very good surface qualities and allows precision cuts and fine detail with the highest reliability in automatic operations.

	base material	coating material	tensile strength	elongation	colour	
cobra cut® type a	CuZn37	Zn	900 N/mm ²	1%	bright-silver	
Ø (mm) spools	0,07	0,10	0,15	0,20	0,25	0,30
bedra® 4	• ¹	• ²	• ³	• ³	• ³	• ³
bedra® 8			•	•	• ³	• ³
bedra® 16				•	•	•
K 100	•	•	• ³	• ³	• ³	• ³
K 125			• ³	• ³	• ³	• ³
K 160			•	• ³	• ³	• ³
K 200				•	•	•
K 250				•	•	•
K 355					•	•

¹ Filling weight 2,0 kg

² Filling weight 2,0 kg or 4,0 kg

³ NO AUTOMATIC threading (AWF)

Zn

CuZn37



cobra cut®

COBRA CUT® Type G

The modified surface of this wire electrode represents the difference to the COBRA CUT® Type A. It is therefore recommended for conical cuts (tapering) on AGIE EDMs with toroid guides.

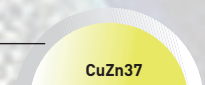
	base material	coating material	tensile strength	elongation	colour	
cobra cut® type g	CuZn37	Zn treated	900 N/mm ²	1%	light grey	
Ø (mm) spools	0,07	0,10	0,15	0,20	0,25	0,30
bedra® 4	• ¹	• ²	• ³	• ³	• ³	• ³
bedra® 8			•	•	• ³	• ³
bedra® 16				•	•	•
K 100	•	•	• ³	• ³	• ³	• ³
K 125			• ³	• ³	• ³	• ³
K 160			•	• ³	• ³	• ³
K 200				•	•	•
K 250				•	•	•

¹ Filling weight 2,0 kg

² Filling weight 2,0 kg or 4,0 kg

³ NO AUTOMATIC threading (AWF)

Zn treated

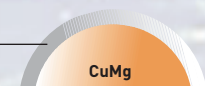


COBRA CUT® Type B

The special CuMg core of this electrode provides high electrical conductivity. Its rougher, oxidized surface benefits flushing conditions and is advantageous for the cutting of tall work pieces (>100 mm). Recommended for fast cutting of graphite and aluminum alloys. This wire is suitable for tapering to 20° but has limited capability for skim cutting and automatic wire threading.

	base material	coating material	tensile strength	elongation	colour	
cobra cut® type b	CuMg	Zn treated	600 N/mm ²	3%	grey	
Ø (mm) spools	0,20	0,25	0,30			
bedra® 4	•	•	•			
bedra® 8	•	•	•			
bedra® 16	•	•				
K 125	•	•	•			
K 160	•	•	•			
K 200	•	•	•			
K 355		•	•			

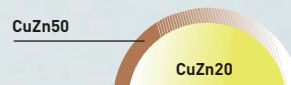
Zn treated



	base material	coating material	tensile strength	elongation	colour	
COBRA CUT® type d	CuZn20	CuZn50	800 N/mm ²	1%	yellow-brown	
Ø (mm) spools	0,15	0,20	0,25	0,30		
bedra® 8	•	•	•	•		
bedra® 16						
K 125	•	•	•	•		
K 160	•					
K 200		•	•	•		
K 250		•	•	•		
K 355			•	•		

COBRA CUT® Type D

This wire electrode has been developed for EDM machines with high-power generators. It has a high thermal and electrical conductivity due to its special coating, making it suitable for speed cutting as well as contour precision cutting. This wire electrode may also be used on machines with automatic threading.



	base material	coating material	tensile strength	elongation	colour	
COBRA CUT® type s	CuZn20	CuZn50	800 N/mm ²	1%	yellow-brown	
Ø (mm) spools	0,30	0,33				
bedra® 16	•	•				
K 200	•	•				
K 250	•	•				
K 355	•	•				

COBRA CUT® Type S

This wire electrode guarantees highest cutting rates on the latest high-power EDM machines. As an improvement of the COBRA CUT® Type D, the thicker diffusion coat provides better cutting performance. It is preferably used for mass production EDM'ing, in production as well as in tool and die making. This EDM wire is suitable for machines with automatic threading.





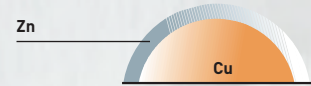
bronco cut[®]

The coated EDM wire series BRONCO CUT[®] was initially developed for the special application on Charmilles Technologies EDM machines, it also meets the particular threading requirements of this manufacturer. The manufacturer Charmilles is introducing this type series on the market with the identification "SW- ..."

BRONCO CUT[®]

This zinc-coated copper EDM wire is designed for compatibility with the annealing and calibration devices of earlier Charmilles machines.

	base material	coating material	tensile strength	elongation	colour	
bronco cut[®]	Cu	Zn	420 N/mm ²	1%	bright-silver	
Ø (mm) spools	0,25					
bedra [®] 4	•					
bedra[®] 8	•					
bedra [®] 16	•					
K 125	•					
K 160	•					
K 200	•					
VB 250/400	•					



BRONCO CUT[®] Type X

This high-performance, multipurpose EDM wire with a special zinc-rich coating, is suitable for precision cutting as well as high-speed cutting. Excellent automatic threading reliability is another

	base material	coating material	tensile strength	elongation	colour	
bronco cut[®] type x	Cu	CuZn50	520 N/mm ²	1%	brown	
Ø (mm) spools	0,20	0,25	0,30			
bedra [®] 4	•	•	•			
bedra[®] 8	•	•	•			
bedra [®] 16	•	•	•			
K 100	•	•	•			
K 125	•	•	•			
K 160	•	•	•			
K 200	•	•	•			
K 250		•	•			
K 355		•	•			
P5R	•	•	•			
P10		•	•			
P15		•	•			



	base material	coating material	tensile strength	elongation	colour	
bronco cut® type hx	CuZn30	CuZn50	800 N/mm ²	1%	yellow-brown	
Ø (mm) spools	0,15	0,20	0,25	0,30		
bedra® 4	•	•	•	•		
bedra® 8	•	•	•	•		
bedra® 16		•	•	•		
K 100	•	•	•	•		
K 125	•	•	•	•		
K 160	•	•	•	•		
K 200		•	•	•		
K 250			•	•		
K 355			•	•		
P3R		•	•	•		
P5R		•	•	•		
P10			•	•		
P15			•	•		

CuZn50

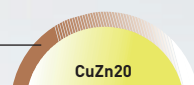


BRONCO CUT® Type HX

This electrode has a special coating and a higher tensile strength which allows higher mechanical load to provide straight, accurate parts. This is especially advantageous for tall work pieces, when straightness and contour accuracy are required.

	base material	coating material	tensile strength	elongation	colour	
bronco cut® type w	CuZn20	CuZn50	430 N/mm ²	30%	yellow-brown	
Ø (mm) spools	0,15	0,20	0,25	0,30		
bedra® 4	•	•	•	•		
bedra® 8	•	•	•	•		
bedra® 16		•	•	•		
K 125	•	•	•	•		
K 160	•	•	•	•		
K 200		•	•	•		
K 250			•	•		
K 355			•	•		

CuZn50



BRONCO CUT® Type W

This electrode supplements the series with a type particularly developed for high tapering. It has high elongation for accurate tapering – up to 45° and its special coating helps overcome poor flushing conditions.

This electrode type MEGACUT® was especially developed for Japanese EDM machines. The series includes five different types:



MEGACUT® Type A
MEGACUT® Type HS

MEGACUT® Type T
MEGACUT® Type W

MEGACUT® Type D

MEGACUT®

MEGACUT® Type A

This zinc-coated precision wire is used when fine surfaces are required. This wire is also recommended when cutting carbides and poly-crystalline diamond.

	base material	coating material	tensile strength	elongation	colour	
MEGACut® type a	CuZn37	Zn treated	900 N/mm ²	1%	light grey	
Ø (mm) spools	0,07	0,10	0,15	0,20	0,25	0,30
bedra® 4	• ¹	• ²	•	•	•	•
bedra® 8			•	•	•	•
bedra® 16				•	•	•
P3R	• ³	• ⁴	•			
P5R			•	•	•	•
P10				•	•	•
P15				•	•	•

¹ Filling weight 2,0 kg

² Filling weight 2,0 kg or 4,0 kg

³ Filling weight 1,5 kg

⁴ Filling weight 1,5 kg or 3,0 kg

Zn treated

CuZn37

MEGACUT® Type T

This wire electrode is similar to MEGACUT® Type A but has reduced hardness, making it perfectly suitable for high tapering requirements. Because of this increased tapering capability, this wire will have limited automatic threading capability.

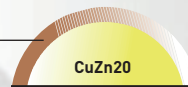
	base material	coating material	tensile strength	elongation	colour	
MEGACut® type t	CuZn37	Zn treated	500 N/mm ²	15%	light grey	
Ø (mm) spools	0,15	0,20	0,25	0,30		
bedra® 4	•	•	•	•		
bedra® 8	•	•	•	•		
bedra® 16		•	•	•		
P3R	•	•	•	•		
P5R	•	•	•	•		
P10		•	•	•		
P15		•	•	•		

Zn treated

CuZn37

	base material	coating material	tensile strength	elongation	colour	
MEGACUT® type d	CuZn20	CuZn50	800 N/mm ²	1%	yellow-brown	
Ø (mm) spools	0,15	0,20	0,25	0,30		
bedra® 4	•					
bedra® 8	•	•	•	•		
bedra® 16		•	•	•		
K 355			•	•		
P3R	•					
P5R	•	•	•	•		
P10		•	•	•		
P15		•	•	•		

CuZn50

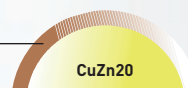


MEGACUT® Type D

Due to its special coating, this electrode is ideal for speed cutting, providing the highest performance. This wire is also recommended for tall workpieces, interrupted cuts and poor flushing conditions.

	base material	coating material	tensile strength	elongation	colour	
MEGACUT® type hs	CuZn20	CuZn50	800 N/mm ²	1%	yellow-brown	
Ø (mm) spools	0,30	0,33				
bedra® 8	•	•				
bedra® 16	•	•				
K 355	•	•				
P5R	•	•				
P10	•	•				
P15	•	•				

CuZn50



MEGACUT® Type HS

This electrode is suited for the high-power generators of the latest machines and offers maximum cutting rates, making it ideal for high-speed production. Type HS has a thicker coating than Type D in order to compensate for the increased consumption of the electrode during high speed cutting.



MEGACUT®

MEGACUT® Type W

This type has the highest elongation of the MEGACUT®-series. The “soft” electrode allows steep tapering. The special coating can resist thermal loads arising from poor flushing conditions.

	base material	coating material	tensile strength	elongation	colour	
MEGACUT® type w	CuZn20	CuZn50	430 N/mm ²	30%	yellow-brown	
Ø (mm) spools	0,15	0,20	0,25	0,30		
bedra® 4	•	•	•	•		
bedra® 8	•	•	•	•		
bedra® 16		•	•	•		
K 355			•	•		
P3R	•	•	•	•		
P5R	•	•	•	•		
P10		•	•	•		
P15		•	•	•		



MosWIRE®

MOSWIRE®

This EDM wire was developed especially for modern EDM machines in cooperation with Mitsubishi. Besides the zinc-rich coat, providing excellent cutting rates and surface finishes, MOSWIRE® has a highly conductive, oxide-free silver coating for precise squaring and edge finding. The excellent straightness guarantees trouble-free automatic threading.

	base material	coating material	tensile strength	elongation	colour	
MosWIRE®	CuZn37	CuZn50	800 N/mm ²	1%	silver	
Ø (mm) spools	0,15	0,20	0,25	0,30		
bedra® 4	•					
bedra® 8	•	•	•	•		
bedra® 16		•	•	•		
K 160	•	•	•	•		
K 200		•	•	•		
K 355			•	•		
P3R	•	•	•	•		
P5R	•	•	•	•		
P10		•	•	•		
P15		•	•	•		

CuZn50



With the intention of meeting the wire-cutting challenges in all fields of wire EDM applications, we have extended our broad spectrum of solutions with steel-cored composite electrodes. MICROCUT® is the fine-wire choice for high-precision applications.

MACROCUT is the right choice when working with tall work pieces and extreme flushing conditions.

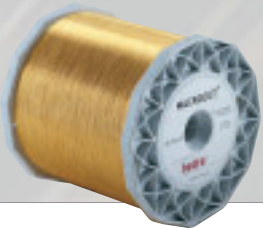
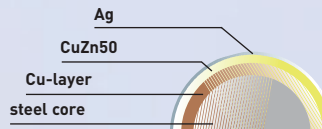


MICROCUT®

	base material	coating material	tensile strength	elongation		
MICROCUT®	steel, copper-coated	CuZn50	2000 N/mm ²	1%		
Ø (mm) spools	0,02	0,03	0,05	0,07	0,10	Non-standard sizes are available
bedra® 4	•	•	•	•	•	
BK 100	•	•	•	•	•	
spool lengths 5000 m or 10000 m	•	•	•	•	•	

MICROCUT®

This EDM wire, especially developed for fine- and micro EDMing is available in diameters down to 0,02 mm. With a special zinc-rich brass coating over its high-strength steel core, it provides optimum process stability, the highest dimensional accuracy and superior surface finishes.

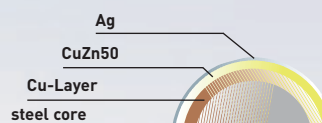


MACROCUT

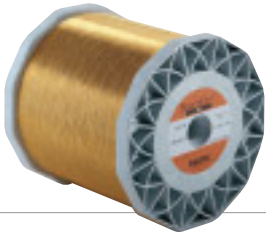
	base material	coating material	tensile strength	elongation	colour	
MACROCUT	steel, copper-coated	CuZn50	1000 N/mm ²	1%	gold	
Ø (mm) spools	0,15	0,20	0,25	0,30		
bedra® 4	•	•	•	•		
bedra® 8	•	•	•	•		
bedra® 16	•	•	•	•		
K 160	•	•	•	•		
K 200	•	•	•	•		
P3R	•	•	•	•		
P5R	•	•	•	•		
P10	•	•	•	•		
P15	•	•	•	•		

MACROCUT

This EDM wire has a steel core and a tried-and-tested diffusion annealed, zinc-rich brass coating. Its properties are designed to withstand extreme applications, such as very tall work pieces, interrupted cuts and poor flushing conditions.



The Berkenhoff program of high performance EDM wires is supplemented by the brass wire series BERCO CUT® and SOMSAL®. The BERCO CUT® EDM wires are available as:



BERCO CUT® 400
BERCO CUT® grip

BERCO CUT® 500
BERCO CUT® special

BERCO CUT®

BERCO CUT®

Like the coated products, the brass EDM wires of Berkenhoff are subject to strict production standards and therefore guarantee reliable cutting performance.

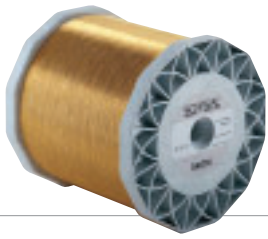
Besides the BERCO CUT® - types 400, 500 and special, the paraffin-free type BERCO CUT® grip is available. The BERCO CUT® program covers the full spectrum of EDM machines.

	material	tensile strength	elongation	colour
BERCO CUT® 400	CuZn37	400 N/mm ²	25%	gold
BERCO CUT® 500	CuZn37	500 N/mm ²	15%	gold
BERCO CUT® grip	CuZn37	900 N/mm ²	1%	gold
BERCO CUT® special	CuZn37	900 N/mm ²	1%	gold

	BERCO CUT® 400	BERCO CUT® 500	BERCO CUT® grip	BERCO CUT® special
bedra® 4	0,20 0,25 0,30	0,15 0,20 0,25 0,30	0,15	0,10 0,15
bedra® 8	0,20 0,25 0,30	0,15 0,20 0,25 0,30	0,15 0,20 0,25 0,30	0,15 0,20 0,25 0,30
bedra® 16		0,20 0,25 0,30	0,20 0,25 0,30	0,20 0,25 0,30
K 100				0,10
K 250		0,20 0,25 0,30	0,20 0,25 0,30	0,20 0,25 0,30
K 355		0,25 0,30	0,25 0,30	0,25 0,30
P10		0,20 0,25 0,30	0,20 0,25 0,30	0,20 0,25 0,30
P15		0,20 0,25 0,30	0,20 0,25 0,30	0,20 0,25 0,30

CuZn37

Alloyed with aluminum, these brass wires provide a higher tensile strength. They are suitable for cutting with fine wires in diameters of 0,05 to 0,10 mm under high wire tension.

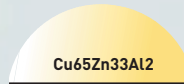


SOMSAL®

	material	tensile strength	elongation	colour
SOMSAL® 600	Cu65Zn33Al2	600 N/mm ²	20%	gold
Ø (mm) spools	0,15	0,20	0,25	0,30
bedra® 4	•	•	•	•
bedra® 8	•	•	•	•
bedra® 16		•	•	•
K 355			•	•

SOMSAL® 600

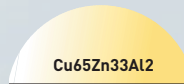
Due to its high elongation, this variant is especially suitable for tapering. Compared to the softer BERCO CUT® series, it provides a higher tensile strength.



	material	tensile strength	elongation	colour
SOMSAL® 900	Cu65Zn33Al2	900 N/mm ²	1%	gold
Ø (mm) spools	0,15	0,20	0,25	0,30
bedra® 4	•	•	•	•
bedra® 8	•	•	•	•
bedra® 16		•	•	•
K 355			•	•

SOMSAL® 900

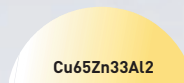
This version, with higher tensile strength than the 600 series, has been tried and tested on machines manufactured by Fanuc and Seibu.

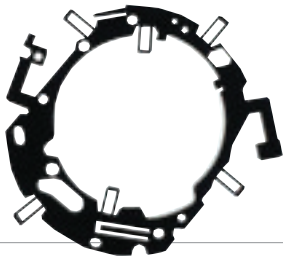


	material	tensile strength	elongation	colour
SOMSAL® 1200	Cu65Zn33Al2	1200 N/mm ²	1%	gold
Ø (mm) spools	0,05	0,07	0,10	
bedra® 4			•	
K 100	•	•	•	

SOMSAL® 1200

This electrode, with the extremely high tensile strength of 1200 N/mm², is a preferred choice for precision applications in smaller diameters.





Berkenhoff takes into account the advancements of new EDM systems and the growing market of micro-technology and offers a varied program of fine EDM wires from 0,10 mm down to diameters of 0,02 mm. This program includes:

MICROCUT®
 COBRA CUT® Type G
 BERCO CUT® special

COBRA CUT®
 MEGACUT® Type A

COBRA CUT® Type A
 SOMSAL® 1200

fine wires

Ø (mm)	0,02	0,03	0,05	0,07	0,10
MICROCUT®					
BK 100	●	●	●	●	●
bedra® 4	●	●	●	●	●
COBRA CUT®					
K 100					●
bedra® 4					●
type a und type g					
K 100				●	●
bedra® 4				● ¹	●
MEGACUT® type a					
bedra® 4			●	●	
P3R				● ²	● ³
SOMSAL® 1200					
K 100		●	●	●	
bedra® 4		●	●	●	
BERCO CUT® special					
K 100				●	
bedra® 4				●	

¹ Filling weight 2,0 kg

² Filling weight 1,5 kg

³ Filling weight 1,5 kg or 3,0 kg



wire electrodes | packaging units

Spool type		bedra® 4	bedra® 8	bedra® 16	K 100	K 125	K 160	K 200	K 250	K 355	P3R	P5R	P10	P15
packaging	nominal-weight	4	8	16	1,6	3,5	6 ¹	15,7	25	45	3	5	10	20 ²
	number of spools	4	2	1	8	4	2	1	1	1	4	4	2	1
	nominal-weight	16	16	16	12,8	14	12 ¹	15,7	25	45	12	20	20	20 ²
pallet a	number of spools	24	12	9	72	24	12	9	6	3	24	16	12	8
	number of boxes	6	6	9	9	6	6	9	6	3	6	4	6	8
	nominal-weight	96	96	144	115,2	84	72 ¹	141,3	150	135	72	80	120	160 ²
pallet b	number of spools	48	24	18	-	48	24	18	12	-	48	32	24	16
	number of boxes	12	12	18	-	12	12	18	12	-	12	8	12	16
	nominal-weight	192	192	288	-	168	144 ¹	282,6	300	-	144	160	240	320 ²
pallet c	number of spools	72	36	-	-	72	36	-	-	-	72	48	-	-
	number of boxes	18	18	-	-	18	18	-	-	-	18	12	-	-
	nominal-weight	288	288	-	-	252	216 ¹	-	-	-	216	240	-	-
pallet d	number of spools	96	48	27	240	96	48	27	18	-	96	64	36	24
	number of boxes	24	24	27	30	24	24	27	18	-	24	16	18	24
	nominal-weight	384	384	432	384	336	288 ¹	423,9	450	-	288	320	360	480 ²

¹ For the types BRONCO CUT® and BRONCO CUT® - type X, the following values apply: 8 / 16 / 96 / 192 / 288 / 384

² For the types BRONCO CUT® and BRONCO CUT® - type X, the following values apply: 25 / 25 / 200 / 400 / 600



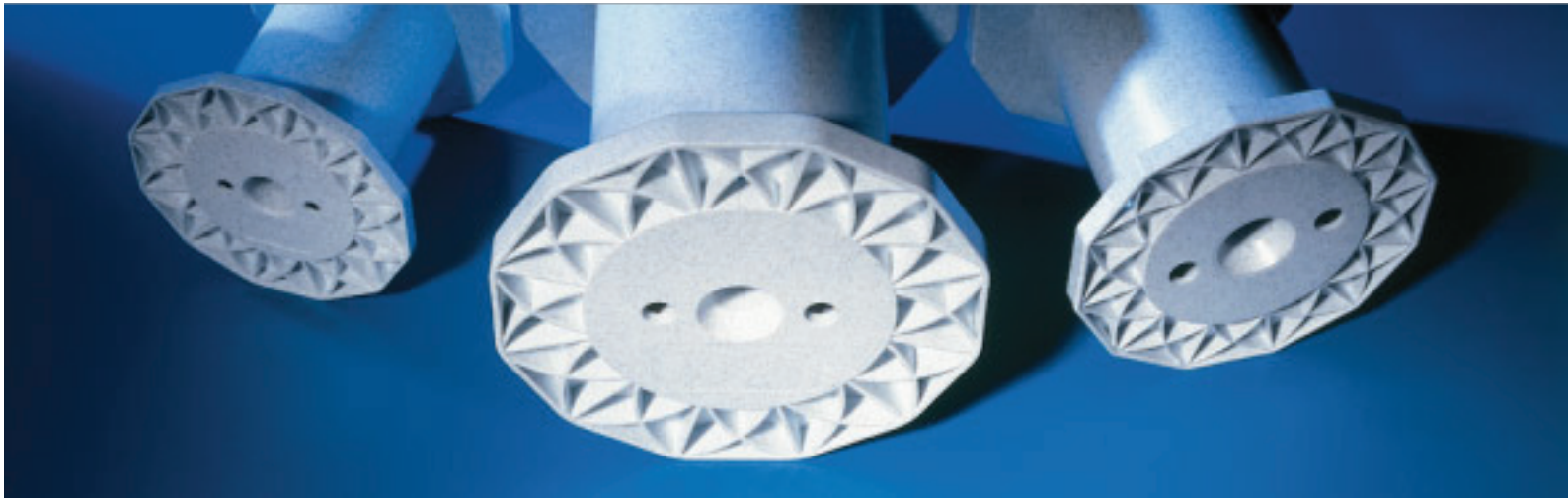
wire electrodes | run-off times

type of spool	wire-diameters mm	nominal-weight per spool ca. kg	nominal-length per spool* m	run-off times per spool at run-off speeds:			
				6 m/min h	9 m/min h	12 m/min h	15 m/min h
bedra® 4	0,10	4,0	60.000	168	108	84	64
	0,15	4,0	26.800	72	48	36	28
	0,20	4,0	15.000	40	28	20	16
	0,25	4,0	9.600	24	16	12	8
	0,30	4,0	6.600	16	12	8	4
bedra® 8	0,10	8,0	120.000	336	216	168	128
	0,15	8,0	53.600	144	96	72	56
	0,20	8,0	30.000	80	56	40	32
	0,25	8,0	19.200	48	32	24	16
	0,30	8,0	13.200	32	24	16	8
bedra® 16	0,10	16,0	240.000	672	432	336	256
	0,15	16,0	107.200	288	192	144	112
	0,20	16,0	60.000	160	112	80	64
	0,25	16,0	38.400	96	64	48	32
	0,30	16,0	26.400	64	48	32	16
K 100	0,10	1,6	23.500	65	43	32	26
	0,15	1,6	10.500	29	19	14	11
	0,20	1,6	6.000	16	11	8	6
	0,25	1,6	3.700	10	6	5	4
	0,30	1,6	2.600	7	4	2	2
K 125	0,10	3,5	51.400	142	95	71	57
	0,15	3,5	22.970	63	40	30	25
	0,20	3,5	12.500	34	23	17	13
	0,25	3,5	8.000	22	14	11	8
	0,30	3,5	5.500	15	10	7	6
K 160	0,15	6,0	39.000	108	72	54	43
	0,20	6,0	22.000	61	40	30	24
	0,25	6,0	14.000	38	25	19	15
	0,30	6,0	9.800	27	18	13	11
K 200	0,20	15,7	57.500	159	106	79	63
	0,25	15,7	37.000	102	68	51	41
	0,30	15,7	25.800	71	47	35	28

type of spool	wire-dia- meters mm	nominal- weight per spool ca. kg	nominal- length per spool* m	run-off times per spool at run-off speeds:			
				6 m/min h	9 m/min h	12 m/min h	15 m/min h
K 250	0,20	25,0	93.750	250	175	125	100
	0,25	25,0	60.000	150	100	75	50
	0,30	25,0	41.250	100	75	50	25
K 355	0,20	45,0	165.000	458	305	229	183
	0,25	45,0	106.000	294	196	147	117
	0,30	45,0	73.500	204	136	102	81
P3R	0,10	3,0	44.000	122	81	61	48
	0,15	3,0	19.690	54	36	27	21
	0,20	3,0	11.000	29	19	14	11
	0,25	3,0	7.000	19	12	9	7
	0,30	3,0	4.900	13	8	6	5
P5R	0,15	5,0	32.600	90	60	45	36
	0,20	5,0	18.300	50	33	25	20
	0,25	5,0	11.700	32	21	16	12
	0,30	5,0	8.100	23	15	11	9
P10	0,20	10,0	36.600	100	66	50	40
	0,25	10,0	23.400	64	42	32	24
	0,30	10,0	16.200	46	30	22	18
P15	0,20	20,0	73.500	204	136	102	81
	0,25	20,0	46.800	130	87	65	52
	0,30	20,0	32.400	91	61	45	36
VB 250/400	0,25	45,0	102.000	283	188	141	113

* Valid for full spools with CuZn-alloy with a density of 8,67 kg/dm

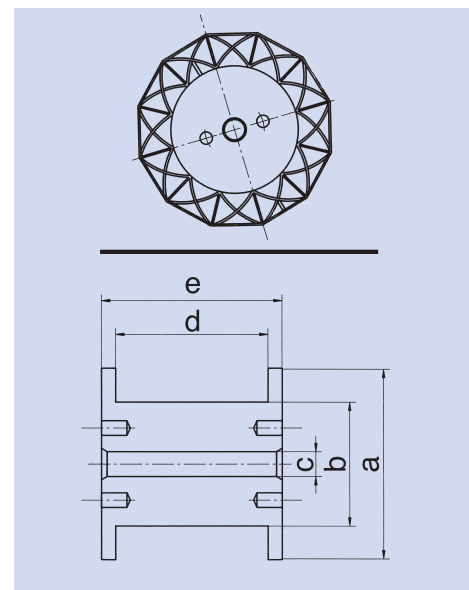
the bedra® | EDM wire spool



The first spool especially suitable for EDM wires, was developed in close cooperation between machine manufacturers and users. Its new shape not only facilitates its handling and storage, but prevents the wire from tangling and breaking due to the naturally logical, but incorrect storage of the spool on the flange, instead of the rim.

Its 12-sided dodecagon shape prevents the spool from rolling and allows proper horizontal storage of the spool. Thus stored correctly, the wire layers can no longer entangle. The spools are made of shockproof, recyclable polystyrene and provide two window openings in the spool flange, allowing viewing of the remaining wire even during operation. The bedra® wire spools are available in three sizes: 4 kg, 8 kg and 16 kg, as bedra® 4, bedra® 8 and bedra® 16. These carefully calculated sizes offers users the ability to select the most productive spool size for their requirements.

This spool is only one of the many innovations developed by the leading manufacturer of high performance EDM wires: bedra® – your source of solutions.



spools | dimensions

type of spool (DIN 46399)	spool material	dimensions of flange a mm	core b mm	bore hole c mm	inner size d mm	outer size e mm
bedra® 4	Polystyrol (PS)	130	80	22	105	125
bedra® 8	Polystyrol (PS)	160	100	22	135	160
bedra® 16	Polystyrol (PS)	200	125	22	164	200
K 100	Polystyrol (PS)	100	63	16	80	100
K 125	Polystyrol (PS)	125	80	16	100	125
K 160	Polystyrol (PS)	160	100	22	128	160
K 200	Polystyrol (PS)	200	125	22	160	200
K 250	Polystyrol (PS)	250	160	22	160	200
K 355	Acrylnitril- Butadienstyrol (ABS)	355	224	36	160	200
P3R	Polystyrol (PS)	130	81	20	90	110
P5R	Polystyrol (PS)	160	90	20	90	115
P10	Polystyrol (PS)	200	90	25	110	134
P15	Polystyrol (PS)	250	110	31	110	140

Note:

Here, all available spools are listed. If a certain spool is not listed among the types, it can be delivered upon request.