# Meticulous     Intricate     Precise

**Your Outsourcing Services Provider of Wire EDM**
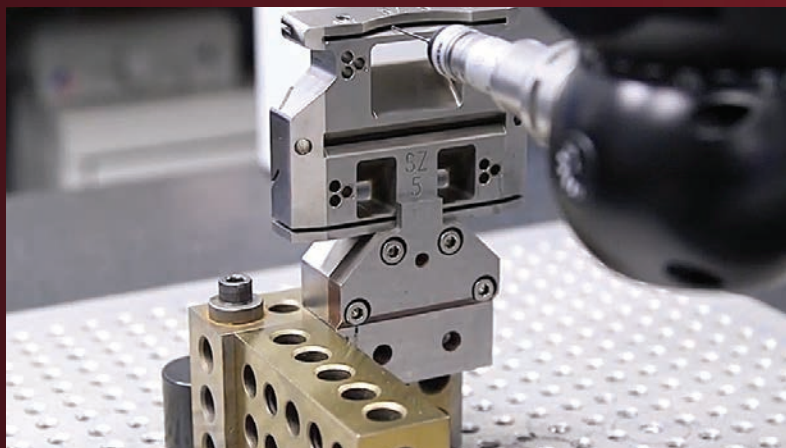
## XACT
**Wire EDM Corporation**

# XACT

## Wire EDM Corporation

*Xact is dedicated to being a premier provider of wire EDM services. Our team stays current with the latest innovations and technologies available in the industry.*

Since our inception in 1984, Xact has become one of the largest wire EDM facilities in the U.S. Our experience and customer service results in benefits to our customers as their source for wire EDM services.

Our employees adhere to the highest standards of excellence and integrity. We take pride in building successful long-term relationships with the customers we serve.

Xact Wire EDM looks to work with you as your source for wire EDM services or as an extension of your machining capabilities.







## Our Capabilities

Xact is one of the largest capacity wire EDM shops in the country and can handle any size or type of project.

Our programming department has the expertise to produce your product in the most efficient manner possible. We are ISO certified to the latest standards. You can count on Xact Wire EDM for the highest quality, and the latest wire EDM technology.
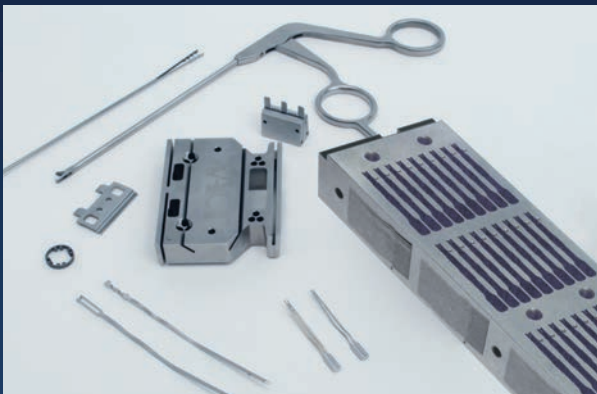
xactedm.com 800.798.9228

## The Advantages of Wire EDM Machining

Wire EDM is a process which cuts conductive materials with a thin wire electrode that follows a programed path. The hardness of the work piece has no detrimental effect on the cutting speed. The wire EDM machine can independently move the four machine axes to generate taper cuts. Wire EDM can be accurate to +/- .0001" (.0025mm). Virtually no burrs are generated. Also, since no cutting forces are present, wire EDM is ideal for delicate parts. No tooling is required so delivery times are short. Components are machined after heat treatment so dimensional accuracy is not affected by heat treat distortion.
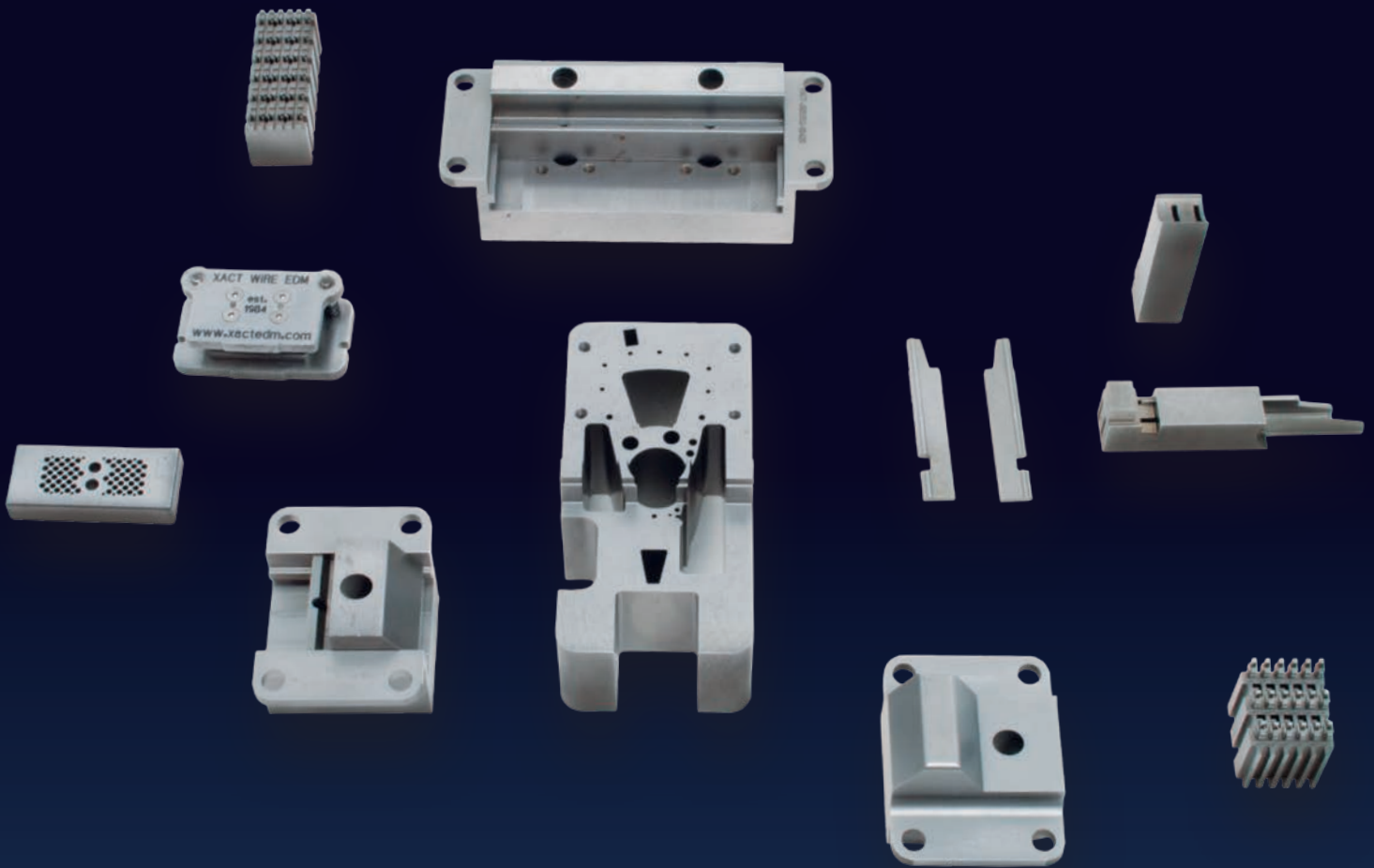
## Industries

- Aerospace
- Automation/Robotics
- Automotive
- Communications
- Cutting Tools
- Defense
- Electronics
- Energy

- Food
- Machining
- Medical
- Molds, Dies & Tooling
- Packaging
- Paper Processing
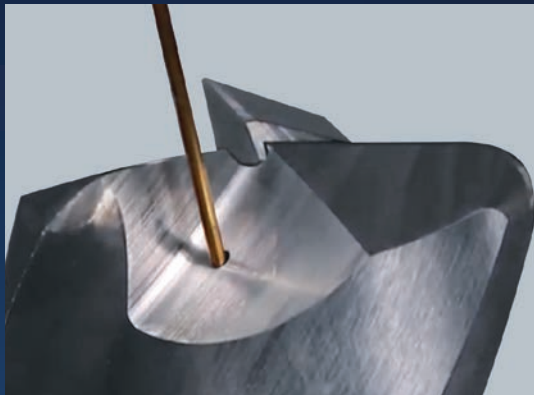- R & D / Prototypes
- Stamping



**Medical**



**Dies & Tooling**

Machine Components


Coolant holes in Cutting Tools


Laser Part Marking

# XACT
## Wire EDM Corporation

**2 central locations providing nationwide coverage**

**WISCONSIN**
N8 W22399 Johnson Dr.
Waukesha, WI 53186
**Phone: 262-549-9005**
**Email: xactwire@xactedm.com**

**ILLINOIS**
720 Industrial Dr. Unit 126
Cary, IL 60013
**Phone: 847-516-0903**
**Email: xact-il@xactedm.com**

CERTIFIED ISO 9001:2015 COMPANY

# Welcome to Xact Wire Corporation

**Xact Wire EDM is your Outsourcing Services Provider of Wire EDM.**

We take pride in the fact that we've been providing these services to companies nationally since 1984. Whether the project is large or small we have the capabilities to meet your needs. We are one of the largest wire EDM facilities in the country, operating in 30,000 square feet of space. Xact works a 24/5 work week proudly providing the highest quality and level of service in the industry. Both Xact locations, Waukesha, WI and Cary, IL are ISO 9001: 2015 Certified. Our CMM systems, Keyence and OGP Vision Inspection systems allow us to accurately inspect your components with the utmost precision. We offer the best quality control in the industry. Xact also offers laser part marking for any parts that need identification. Other graphics can also be produced.

Our goal is to work with you as a strategic vendor for your wire EDM needs, and to serve as an extension of your own in-house capabilities.

Feel free to contact us with any questions on an application or about our services. You can also visit our website www.xactedm.com for more information, and to check out the latest news.

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# Inspection Equipment

2 OGP Flash 302 with Touch Probe and TTL laser

2 OGP Avant ZIP 300 Video Inspection System (multi-sensor) 12" x 12" travel

1 OGP Smartscope ZIP 250 Video Inspection System 6" x 10" travel

1 OGP Flash 200 Video Inspection System 8" x 8" Travel

1 OGP Bench Top Comparator 20X

1 OGP Flash 500 Video Inspection System (multi-sensor) 18" x 20" travel

1 Optodyne MCV-500 Laser Doppler Displacement Meter

3 Brown & Sharpe Global 575 CMM with PH10M indexable head and PCDMIS CAD++

4 Keyence IM Instant Measurement Vision Systems

1 12" Optical comparator with 10x 20x and 50x lenses, and linear digital scales

1 Mahr Millimar C1200 Digital Dial Indicator with 5 millionths accuracy

3 Mitutoyo Height Masters with .00005" graduations and digital readout

2 Trimos Height Masters

10 Mitutoyo Shop Height Masters


Smart Profile 3D Fitting Software and Minitab statistical software package


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# Contact Our Team

## CORPORATE HEADQUARTERS

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# Current Small Hole EDM Capabilities

| Electrode Diameter | Finished Hole Size | Maximum Thickness |
|---|---|---|
| .010" (.25mm) | .012-.015 (.34 mm) | 1/4 inch (6mm) |
| .012" (.30mm) | .014-.017 (.39mm) | 1/2 inch (13mm) |
| .016" (.40mm) | .017-.021 (.48mm) | 1 inch (25mm) |
| .020" (.50mm) | .022-.027 (.62mm) | 2 inches (50mm) |
| .024" (.60mm) | .027-.032 (.75mm) | 2 inches (50mm) |
| .028" (.70mm) | .029-.034 (.80mm) | 3 inches (75mm) |
| .031" (.80mm) | .034-.039 (.93mm) | 4 inches (100mm) |
| .035" (.90 mm) | .039-.043 (1.04mm) | 5 inches (100mm) |
| .039" (1.0mm) | .042-.047 (1.13mm) | 5 inches (125mm) |
| .043" (1.1mm) | .046-.051 (1.23mm) | 6 inches (150mm) |
| .047" (1.2mm) | .050-.055 (1.33mm) | 6 inches (150mm) |
| .051" (1.3mm) | .053-.058 (1.41mm) | 6 inches (150mm) |
| .055" (1.4mm) | .058-.064 (1.55mm) | up to 9 inches* (225mm) |
| .063" (1.6mm) | .066-.069 (1.71mm) | up to 9 inches* (225mm) |
| .067" (1.7mm) | .070-.076 (1.85mm) | up to 9 inches* (225mm) |
| .075" (1.9mm) | .078-.083 (2.05mm) | up to 9 inches* (225mm) |
| .083" (2.1mm) | .088-.092 (2.30mm) | up to 9 inches* (225mm) |
| .090" (2.3mm) | .093-.101 (2.46mm) | up to 9 inches* (225mm) |
| .098" (2.5mm) | .102-.106 (2.64mm) | up to 9 inches* (225mm) |
| .118" (3.0mm) | .121-.126 (3.14mm) | up to 9 inches* (225mm) |

* Up to 14" part height possible depending on part configuration

**EDM Small Hole Drilling in Carbide** Xact Wire EDM has machines that are ideal for it. These machines use an oil based coolant which provides better edge control, surface finish and machining speed.

Notes:
• Finished hole sizes may vary depending on the type of material, material thickness, and machining conditions. Typical tolerance held is +/- .005"
• Maximum XY travel; X - 22.25" Y - 14.25"
• Other sizes may be available with lead time and/or large quantity orders

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# Our Equipment

**EDM Machines:**

| | | |
|---|---|---|
| 4 GF | CUT P350 | 13.7" x 8.6" travel and 8.6" thick with 30 degrees of taper capability |
| 1 GF | CUT P550 | 21.6" x 13.7" travel and 15.7" thick with 30 degrees of taper capability |
| 1 Charmilles | Robofil 4020 | 12.6" x 17.7" travel and 14" thick with 30 degree taper capability |
| 6 Charmilles | Robofil 510 | 15.7" x 27.5" travel and 16" thick with 30 degree taper capability |
| 1 Charmilles | Robofil 310 | 9.8" x 15.6" travel and 16" thick with 30 degree taper capability |
| 5 Charmilles | Robofil 300 | 9.8" x 15.6" travel and 16" thick with 30 degree taper capability |
| 4 Charmilles | Robofil 290 | 9.8" x 15.6" travel and 8" thick with 30 degree taper capability |
| 1 Charmilles | Robofil 230 | 8.6" x 13.8" travel and 8" thick with 30 degree taper capability |
| 1 Sodick | AQ300L LN1 | 7.8" x 11.8" travel and 7.8" thick with 20 degree taper capability |
| 2 Sodick | AQ750L | 19.6" x 29.5" travel and 15.7" thick with high taper capability |
| 1 Sodick | AG600L | 15.7" x 23.6" travel and 13.7" thick with taper capability |
| 3 Sodick | ALN600G | 15.7" x 23.6" travel and 13.7" thick with high taper capability |
| 1 Sodick | ALN600G+SPW | 15.7" x 23.6" travel and 13.7" thick with high taper capability |
| 4 Sodick | AQ537L Premium | 14.5" x 22.4" travel and 13.7" thick with 25 degree taper capability |
| 6 Sodick | AG400L | 11" x 15.7" travel and 9.8" thick with 25 degree taper capability |
| 3 Sodick | AQ400L | 11.8" x 15.7" travel and 9.8" thick with 20 degree taper capability |
| 3 Sodick | AQ 327L | 14.5" x 10.6" travel and 9" thick with 20 degree taper capability |

**High Speed Small Hole EDM Machines:**

| | |
|---|---|
| 1 Charmilles | SH-2 Small Hole EDM Machine 7.8" x 11.8" |
| 1 Sodick | K1CN CNC EDM Drilling Machine 11.8" x 15.7" |
| 1 Sodick | K3HS CNC EDM Drilling Machine 11.8" x 15.75" w/ automatic Electrode Changer |
| 2 Current | CT300 CNC EDM Drilling Machine 12" x 8" w/ automatic Electrode Changer |
| 1 Current | CT400 CNC EDM Drilling Machine 15.7" x 12" w/ automatic Electrode Changer |
| 2 Current | CT500 CNC EDM Drilling Machine 14" x 22" w/ automatic Electrode Changer |
| 1 Belmont | SY-4050ST oil-based CNC EDM Drilling Machine 19.6" x 15.7" w/ automatic Electrode Changer |
| 1 Belmont | SY-3040ST oil-based CNC EDM Drilling Machine 15.7" x 11.8" w/ automatic Electrode Changer |

**Laser Part Marking and Graphics:**

1 Zetalase (with rotary) laser marking machine
1 Minilase XL laser marking machine
1 Keyence MD-X2500A 3-axis Hybrid Laser Marker

**Support and Miscellaneous:**

Solid Works, Key Creator, Esprit, Peps and ability to read most CAD files
NIST 800-171 secure file transfer ITAR Registered

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