

HYDAX[®]

HYDRAULICS | MACHINES | DROIDS | ENERGY

Technical Document – Edge Radiusing
machine

For Burrigon 25

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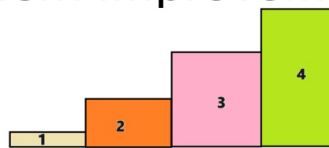
Introduction

Electro chemical deburring (ECM) has evolved. It is no longer about using corrosive solutions of salt and water.

Burrigon series of electrolyte uses Sterling 1/Surfa Electrolyte which is less corrosive and evaporative. It also has a stable PH which does not need to be maintained. It is used to generate a radius of 0.2 and above.

Iona series uses Iona/Surfa electrolyte which is less corrosive and evaporative. It also has a stable PH, which does not need to be maintained. It is used to generate a radius of 0.05mm and above.

ECM Improvements

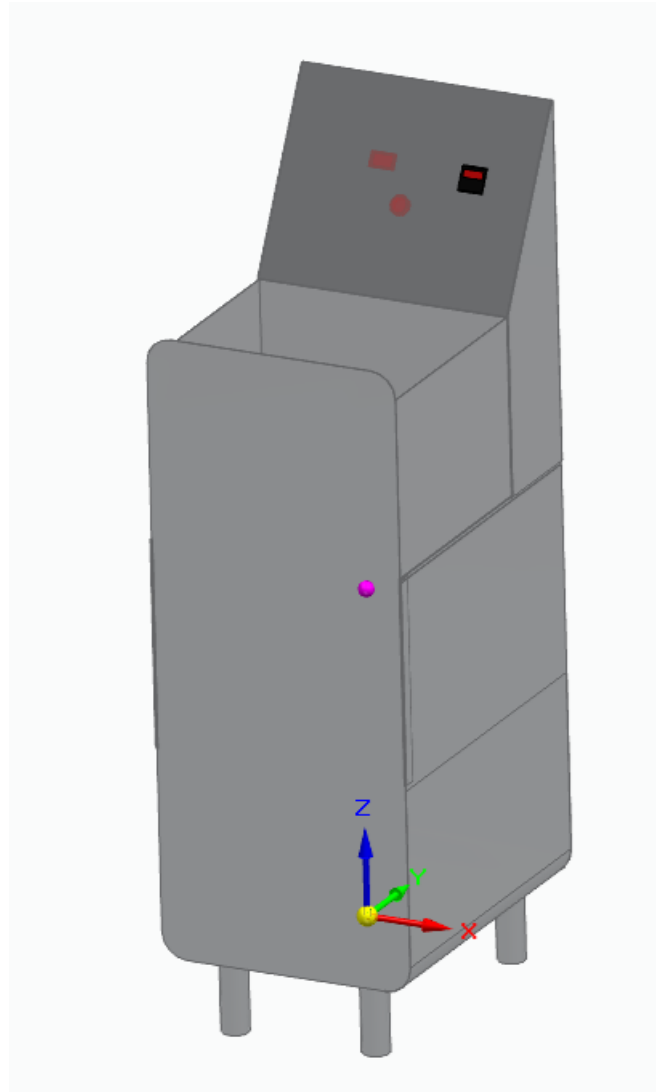


NAME	Non Evaporative & Anti Corrosive	Small Spread of ECM	Auto PH and Conductivity	No blackening
1. Sodium Nitrate				
2. NEXT GEN 75	✓	✓		
3. STERLING 1	✓	✓	✓	
4. IONA 75	✓	✓	✓	✓

Process

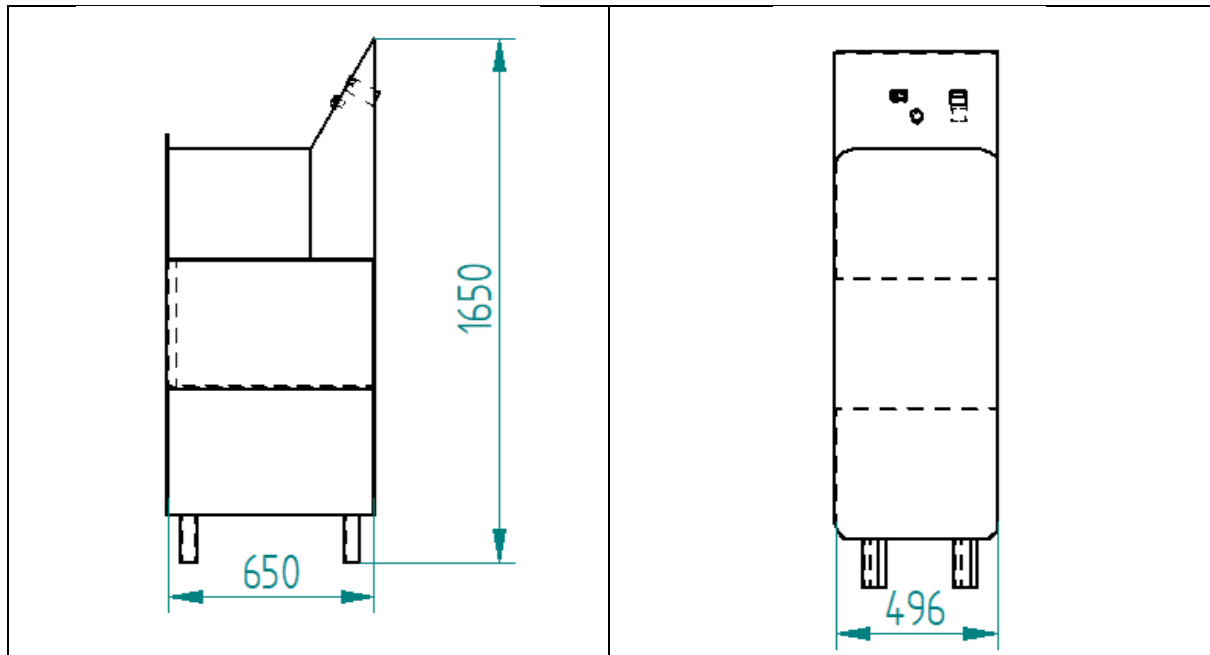
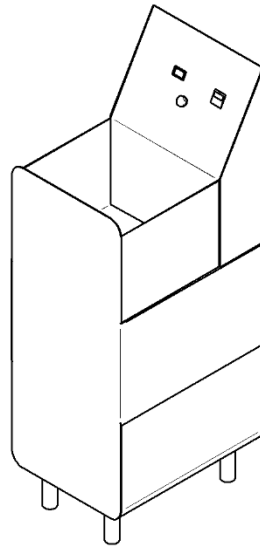
1. Manual breaking of large burrs by passing a drill undersized by 0.2mm
2. ECM radiusing. Ensure burr is not more than 0.2 mm .

Recommended Model	Burrigon 25
Loading and unloading time	10 seconds
Pre process	Component must be oil free.
Post process	To avoid corrosion oil or coolant dip is recommended
Process	Electrodes for cross holes
Location	Holes - Refer to 3 D drawing
Electrolyte Flow	The other side
Floor Space	800x 800 mm
Height	1500 mm
Approximate Dry weight	100 Kgs
Electrolyte tank capacity	100 Ltrs
Deburring power supply	25 Amps
Power connection to the machine	3 KW 1 Phase 50 Hz
Control	Digital Timmer
Electrode operation	Manual
Filtration of electrolyte	In line filters of 5 microns
Machine Construction Material	Stainless Steel 2 mm 303/304 grade



Burrigon 25

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Burrigon 100

This machine is suitable to deburr small parts such as small gears maximum diameter of 40 mm. Parts with cross holes, both ferrous and non ferrous can be done. The process is controlled with a panel timer.

Specification

Material of Construction	Stainless Steel 2mm Thick
Size (LxWxH)	1229mm x 840mm x 1229mm
Tank Capacity	200 Liters
Flow Control	Electronically
Power Connection	3 Phase 5 KW
Dry Weight	150 Kgs
Filters	Build in for filtering media
Process Control	Panel Timer



Burrigon 100

Burrigon 300/500

This machine is suitable to make larger parts. It has two workstations which can be controlled simultaneously or individually. Both ferrous and non ferrous can be done.



Burrigon 300/500

Specification

Material of Construction	Stainless Steel 2mm Thick
Size (LxWxH)	1900mm x 1600mm x 2000mm
Tank Capacity	800 Liters
Flow Control	Electronically
Power Connection	3 Phase 12/16 KW
Dry Weight	1500 Kgs
Filters	Build in for filtering media
Process Control	PLC Based with 7" Touch Screen HMI

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Burrigon 100 P

This machine is suitable to deburr small parts such as small gears maximum diameter of 40 mm. Parts with cross holes, both ferrous and non ferrous can be done. The process is controlled with a PLC with a 7" touch screen HMI.

Specification

Material of Construction	Stainless Steel 2mm Thick
Size (LxWxH)	1229mm x 1000mm x 1229mm
Tank Capacity	200 Liters
Flow Control	Electronically
Power Connection	3 Phase 5 KW
Dry Weight	150 Kgs
Filters	Build in for filtering media
Process Control	PLC Based with a 7" Touch Screen HMI



Burrigon 100 P