



INSTRUCTIONS

*FOR THE USE OF THE
0,1 MM SPECIAL WIRE*

Leipzig, 16.11.00

The special wire

Working with the 0.1 mm wire



To work safely, the 0.1 mm wire should be tightened up only to a length of 40 cm.

A 40 cm wire needs a tension of about 40 V. This tension can be attained with FoCuS mains power units. For cutting polystyrene the wire needs a current intensity of 0.5 amp. Then it has a cutting temperature of 300° C.

For stretching the wire, one piece of standard wire is twisted or tied to one side of the spring and to the other side of the 0.1 mm wire. The thin wire is now fixed at the right side after the wire stretcher is securely fastened. The thicker wire is fastened at the left side. The length of the thin wire should be 40 cm maximum. For larger lengths the tension of the mains power unit is not sufficient to heat the wire up. In addition, it is dangerous to work with tensions higher than 40 V. Since the best results will be obtained with the XPS-Styrodur and these plates have a maximum thickness of 10 cm, there is no problem if the wire is not tightened to its full length between the portals.

The speed has to be set between 4 and 5 mm per second. The clearance will now be about 0.7 mm. A noticeable improvement of the cutting result can be noticed especially with small objects and detailed contours.

Since the wire breaks more easily, special caution is required when positioning and removing the foam piece. However this wire is very tough despite its tiny diameter and carries a weight of 300 grams without tearing off.

Technical data:

Item number:	W-RW10S
Diameter:	01 mm
Current intensity at 300° C	0.5 A
Tension at 300°C and 0,4 m wire length:	40 V
Clearance:	0,7 mm
Price	8,00 DM/m



FoCuS Foam Cutting Systems GmbH
"Foam cutting systems"
Bergweg 7 - 0341 Leipzig

