### Technical data

**Travels**

<table>
<thead>
<tr>
<th></th>
<th>AC Progress VP2</th>
<th>AC Progress VP3</th>
<th>AC Progress VP4</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>X/Y/Z axes</strong></td>
<td>mm</td>
<td>in</td>
<td>in</td>
</tr>
<tr>
<td></td>
<td>350 x 250 x 256</td>
<td>12.77 x 9.84 x 10</td>
<td>19.7 x 13.77 x 16.8</td>
</tr>
<tr>
<td>Max. speed X/Y</td>
<td>m/min.</td>
<td>ft/min.</td>
<td>ft/min.</td>
</tr>
<tr>
<td></td>
<td>3</td>
<td>9.84</td>
<td>3</td>
</tr>
<tr>
<td>U/V axes</td>
<td>mm (in)</td>
<td>±70 (± 2.7)</td>
<td>±70 (± 2.7)</td>
</tr>
<tr>
<td>Max. taper angle &lt;°/height</td>
<td>mm (in)</td>
<td>30°/100 (30°/3.93)</td>
<td>30°/100 (30°/3.93)</td>
</tr>
<tr>
<td>Dual measuring System for X/Y axes</td>
<td>Standard</td>
<td>Standard</td>
<td>Standard</td>
</tr>
</tbody>
</table>

**Work area**

<table>
<thead>
<tr>
<th>Max. workpiece dimensions *</th>
<th>mm</th>
<th>in</th>
<th>in</th>
</tr>
</thead>
<tbody>
<tr>
<td>750 x 550 x 250</td>
<td>29.5 x 21.6 x 9.8</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1050 x 650 x 420</td>
<td>41.3 x 25.6 x 16.5</td>
<td></td>
<td></td>
</tr>
<tr>
<td>1300 x 1000 x 510</td>
<td>51.9 x 39.3 x 20</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Max. workpiece weight:</th>
<th>kg</th>
<th>lbs</th>
<th>lb</th>
</tr>
</thead>
<tbody>
<tr>
<td>With bath</td>
<td>200/450</td>
<td>440/992.08</td>
<td></td>
</tr>
<tr>
<td>Without bath</td>
<td>400/800</td>
<td>880/1763.70</td>
<td></td>
</tr>
<tr>
<td>3000</td>
<td>6613.86</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Accessibility</th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
</table>

| Universal clamping frame for best utilisation of the work zone | Standard | Standard | Standard |

| Machining in bath     | mm (in) | 250 (9.84) | 420 (16.54) | 525 (20.67) |

**Wire threading system**

<table>
<thead>
<tr>
<th>Agiejet threadable height</th>
<th>mm (in)</th>
<th>Up to 250 (9.84)</th>
<th>Up to 420 (16.5)</th>
<th>Up to 525 (20.67)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Threading nozzle</td>
<td>2 (0.07)</td>
<td>0.0059-0.0129</td>
<td>0.0059-0.0129</td>
<td>0.0059-0.0129</td>
</tr>
<tr>
<td></td>
<td>1.0 (0.039)</td>
<td>Option</td>
<td>1.0 (0.039)</td>
<td>Option</td>
</tr>
<tr>
<td></td>
<td>0.6 (0.0234)</td>
<td>Option</td>
<td>0.6 (0.0234)</td>
<td>Option</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Wire threading in small holes and start hole search function ≤ 0.10 mm</th>
<th>mm (in)</th>
<th>Option</th>
<th>Option</th>
<th>Option</th>
</tr>
</thead>
<tbody>
<tr>
<td>Wire guides: standard equipment</td>
<td>mm (in)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td>0.15-0.33</td>
<td>Option</td>
<td>Option</td>
<td>Option</td>
</tr>
<tr>
<td></td>
<td>0.0059-0.0129</td>
<td>Option</td>
<td>Option</td>
<td>Option</td>
</tr>
</tbody>
</table>

| Kit 70: extension kit        | mm (in) | 0.07-0.10 | 0.07-0.10 | 0.07-0.10 |
| Kit 50: extension kit        | mm (in) | 0.05-0.10 | 0.05-0.10 | 0.05-0.10 |

| Combination wire guide system | mm (in) | Option | Option | Option |
| "V" guide                    | 0.15-0.33 | Option | Option | Option |
| Toroid guide                 | 0.0059-0.0129 | Option | Option | Option |
| Cylindrical up to 2°         | Option | Option | Option | Option |
| up to 30°                    | Option | Option | Option | Option |

| Increased accuracy in tapered cut AGIECONIC PLUS | mm (in) | Option | Option | Option |
| Wire drive, wire spool        | kg      | Up to 25 | Up to 25 | Up to 25 |
| Wire disposal                 |         | Chopper  | Chopper  | Chopper  |

* Width x depth x height
<table>
<thead>
<tr>
<th>Feature</th>
<th>AC Progress VP2</th>
<th>AC Progress VP3</th>
<th>AC Progress VP4</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>Generator</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>High power generator IPG-VPC integrated</td>
<td>~ A</td>
<td>60</td>
<td>60</td>
</tr>
<tr>
<td>Wide range of tested technologies for</td>
<td>Standard</td>
<td>Standard</td>
<td>Standard</td>
</tr>
<tr>
<td>commonly used workpiece materials</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Max. cutting rate with CCS Ø 0.33 mm wire</td>
<td>mm²/min.</td>
<td>&gt; 500</td>
<td>&gt; 500</td>
</tr>
<tr>
<td></td>
<td>in/h</td>
<td>&gt; 47</td>
<td>&gt; 47</td>
</tr>
<tr>
<td>Finishing quality, best roughness</td>
<td>µm Ra</td>
<td>0.2</td>
<td>0.2</td>
</tr>
<tr>
<td></td>
<td>µin</td>
<td>8</td>
<td>8</td>
</tr>
<tr>
<td>Best Ra with SF modul, finishing</td>
<td>µm Ra</td>
<td>0.1</td>
<td>0.1</td>
</tr>
<tr>
<td>power module (option)</td>
<td>µin</td>
<td>4</td>
<td>4</td>
</tr>
<tr>
<td>Duotec, technology for the use of two wires</td>
<td>Standard</td>
<td>Standard</td>
<td>Standard</td>
</tr>
<tr>
<td>type in a single contour</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>PCD Module, machining of PCD disks or cutting tools</td>
<td>Option</td>
<td>Option</td>
<td>Option</td>
</tr>
<tr>
<td>Smoothsurf, best surface homogeneity,</td>
<td>Standard</td>
<td>Standard</td>
<td>Standard</td>
</tr>
<tr>
<td>uniformity of the eroded surfaces</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Correction of the cylindrical residual error,</td>
<td>Standard</td>
<td>Standard</td>
<td>Standard</td>
</tr>
<tr>
<td>AWO (Advanced Wire Offset)</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Dynamic path optimisation and process</td>
<td>Standard</td>
<td>Standard</td>
<td>Standard</td>
</tr>
<tr>
<td>adaptation in the radii DCC</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Real time detection and correction of</td>
<td>Standard</td>
<td>Standard</td>
<td>Standard</td>
</tr>
<tr>
<td>the wire bending WBC</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Automatic power optimisation Variocut</td>
<td>Standard</td>
<td>Standard</td>
<td>Standard</td>
</tr>
<tr>
<td>Prodec: technology for highest productivity</td>
<td>Standard</td>
<td>Standard</td>
<td>Standard</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Dielectric conditioning unit</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Dielectric conditioning unit integrated</td>
<td>l (us gal)</td>
<td>750 (200)</td>
<td>1000 (264)</td>
</tr>
<tr>
<td>Filter cartridges 4 canisters</td>
<td>Standard</td>
<td>Standard</td>
<td>Standard</td>
</tr>
<tr>
<td>with 8 cartridge filters</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Filtrate quality</td>
<td>µm (µin)</td>
<td>5 (197)</td>
<td>5 (197)</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Deionizing</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Deionizing bottle charge volume</td>
<td>l (us gal)</td>
<td>10 (2.64)</td>
<td>10 (2.64)</td>
</tr>
<tr>
<td></td>
<td></td>
<td>30 (7.92) Option</td>
<td>30 (7.92) Option</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>Cooling</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Generator and control unit</td>
<td>Standard</td>
<td>Standard</td>
<td>Standard</td>
</tr>
<tr>
<td>with air / water, and dielectric with</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>water / water heat exchanger</td>
<td></td>
<td></td>
<td></td>
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<tr>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td><strong>System</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>System dimensions *</td>
<td>mm</td>
<td>1640 x 2040 x 2220</td>
<td>1940 x 2300 x 2600</td>
</tr>
<tr>
<td></td>
<td>in</td>
<td>64.5 x 80.3 x 87.4</td>
<td>76.4 x 90.5 x 87.4</td>
</tr>
<tr>
<td>Net weight</td>
<td>kg (lbs)</td>
<td>2580 (5688)</td>
<td>3460 (7628)</td>
</tr>
<tr>
<td>Weight ready-to-run</td>
<td>kg (lbs)</td>
<td>ca. 3350 (7385)</td>
<td>ca. 4200 (9260)</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>* Width x depth x height</td>
<td></td>
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<td></td>
</tr>
</tbody>
</table>

**Interface for automation**

(only AC Progress VP2)

<table>
<thead>
<tr>
<th>Feature</th>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Basic equipment for handling devices</td>
<td>Automation</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Communication interface for handling devices</td>
<td>Robotcommand</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Communication interface for cell computer connection</td>
<td>Hostcontrol</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

**Connections**

<table>
<thead>
<tr>
<th>Feature</th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>Line power</td>
<td>12.1 kW</td>
<td></td>
</tr>
<tr>
<td>Line voltage</td>
<td>3 x 400 V</td>
<td></td>
</tr>
<tr>
<td>Compressed air</td>
<td>6 bar, 5 m³/h (85 psi, 6.54 yd³/h)</td>
<td></td>
</tr>
<tr>
<td>Cooling capacity required</td>
<td>9-11 kW</td>
<td></td>
</tr>
<tr>
<td>AC Progress VP2</td>
<td>AC Progress VP3</td>
<td>AC Progress VP4</td>
</tr>
<tr>
<td>-----------------</td>
<td>-----------------</td>
<td>-----------------</td>
</tr>
<tr>
<td><strong>Control unit integrated, modules and functions</strong></td>
<td><strong>Remote control with all setup functions</strong></td>
<td>Agiejogger with electronic handwheel and LCD display</td>
</tr>
<tr>
<td></td>
<td><strong>Operator interface system</strong></td>
<td>15”-LCD-display, Keyboard and mouse</td>
</tr>
<tr>
<td></td>
<td><strong>Control unit integrated</strong></td>
<td>Agievision object oriented man-machine interface</td>
</tr>
<tr>
<td></td>
<td><strong>Operating system</strong></td>
<td>Multitasking Windows XP</td>
</tr>
<tr>
<td></td>
<td><strong>Operating mode</strong></td>
<td>Multiprocessor</td>
</tr>
<tr>
<td></td>
<td><strong>CPU’s</strong></td>
<td>Pentium for CNC and operator interface</td>
</tr>
<tr>
<td></td>
<td><strong>Servocontrolled axes</strong></td>
<td>X/Y/Z/U/V</td>
</tr>
<tr>
<td></td>
<td><strong>Supplementary servocontrolled axis</strong></td>
<td>A axis</td>
</tr>
<tr>
<td></td>
<td><strong>Smallest programmable step</strong></td>
<td>0.0001 mm (0.000004 in)</td>
</tr>
<tr>
<td></td>
<td><strong>Easy preparation of machining programs</strong></td>
<td>Easywork</td>
</tr>
<tr>
<td></td>
<td><strong>Automatic pickup cycles</strong></td>
<td>Agiesetup 3D, for automatic determination of workpiece plane and position</td>
</tr>
<tr>
<td></td>
<td><strong>Automatic technology selection based on machining objectives</strong></td>
<td>Teccut</td>
</tr>
<tr>
<td></td>
<td><strong>Import of job-specific data from CAD/CAM systems</strong></td>
<td>Camlink</td>
</tr>
<tr>
<td></td>
<td><strong>Predefined machining strategies</strong></td>
<td>Autosquence</td>
</tr>
<tr>
<td></td>
<td><strong>Predefined and user defined machining strategies</strong></td>
<td>Usersequence</td>
</tr>
<tr>
<td></td>
<td><strong>Simple 2D on-board geometry programming</strong></td>
<td>IGES files Agiegeo with import of DXF and IGES files</td>
</tr>
<tr>
<td></td>
<td><strong>Import in Agiegeo of third party ISO codes</strong></td>
<td>Agiegeo Isoconverter</td>
</tr>
<tr>
<td></td>
<td><strong>Quickly insert rush orders without effort</strong></td>
<td>Piecinsert</td>
</tr>
<tr>
<td></td>
<td><strong>DNC port with Xon/Xoff and LSV2 protocols</strong></td>
<td>DNC</td>
</tr>
<tr>
<td></td>
<td><strong>Help functions, explanations with text and graphics</strong></td>
<td>Help and online manual</td>
</tr>
<tr>
<td></td>
<td><strong>Machining simulation 2D and 3D view</strong></td>
<td>Graficheck</td>
</tr>
<tr>
<td></td>
<td><strong>Automatic instructions and commands execution</strong></td>
<td>Easyrun</td>
</tr>
<tr>
<td></td>
<td><strong>Automatic machining sequence definition</strong></td>
<td>Lotto for multiple workpieces clamping</td>
</tr>
<tr>
<td></td>
<td><strong>Rethreading on wire break/on «no-thread» detection restart after power failure Rescue strategies</strong></td>
<td></td>
</tr>
<tr>
<td></td>
<td><strong>Languages</strong></td>
<td>English, CN, CZ, DE, DK, ES, FR, HU, IT, JP, NL, PL, RU, US, SE</td>
</tr>
<tr>
<td></td>
<td><strong>Storage capacity</strong></td>
<td>&gt; 40 GB HD, 1 GB Ram</td>
</tr>
<tr>
<td></td>
<td><strong>Interfaces</strong></td>
<td>2 x RS232C, 1 x parallel, 1 LAN (Local Area Network), 1 USB</td>
</tr>
<tr>
<td></td>
<td><strong>Data storage media</strong></td>
<td>CD/DVD-ROM for updates and on line manual, floppy-disk, USB</td>
</tr>
</tbody>
</table>