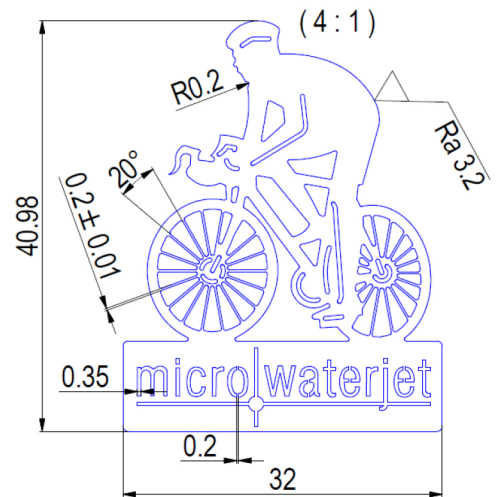


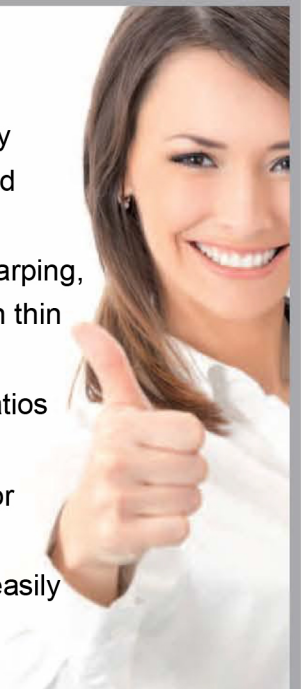
## Facts & Figures

- Name: Thin bike spoke
- Material: Brass, non-ferrous
- Material thickness: 1 mm
- Kerf: 0.2 mm
- Water pressure: 55,000 psi (3,800 bar)
- Quality grade: Q7
- Feed rate: 92.3 mm/min.
- Machining time: 16 minutes 36 seconds



## Benefits

- Efficient production, no starting holes necessary
- Finest, reproducible land widths
- No thermal loads, no warping, even production also on thin components (< 1 mm)
- Extreme width/height ratios
- No tension
- No structural changes or micro-cracks
- Sharp, small lettering, easily legible
- Minimal burr formation



## Alternative

- Alternative cutting procedures only possible with compromises
- YAG Laser generates thermal loads and material deformations (warping, stress)
- With YAG Laser, wall thicknesses of 0.2 mm are not able to be cut
- Wire-cut EDM not efficient due to the large number of starting drill holes

microwaterjet

**MICRO WATERJET LLC**

13420 Reese Blvd, West - Huntersville, NC 28078

Phone: 704-948-1223 - Fax: 704-875-0781

Email: [info@microwaterjet.com](mailto:info@microwaterjet.com)

[www.microwaterjet.com](http://www.microwaterjet.com)