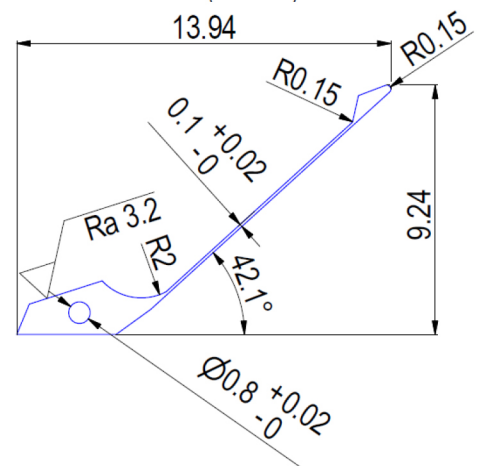


Facts & Figures

- Name: Watch spring
- Material: Spring steel, 1.4310
- Material thickness: 0.5 mm
- Kerf: 0.3 mm
- Water pressure: 55,000 psi (3,800 bar)
- Quality grade: 5 (surface quality Ra 3.2 µm)
- Feed rate: 742 mm/min.
- Machining time: 50 seconds



Benefits

- Material properties and spring tension remain unchanged
- High reproducibility
- Virtually burr-free
- Very good land width/height ratio (1:5)
- Long, thin-walled land width
- Original material structure remains
- Precise holes and radii



Alternative

- When using a hot-cutting procedure such as wire-cut EDM or fine-laser cutting, the heat has a negative effect on thin land widths (0.5 mm). The material becomes brittle and loses its properties, with a risk of micro-cracks. With wire-cut EDM, a starting hole has to be drilled in advance. With etching, the perpendicularity of the land width is affected.