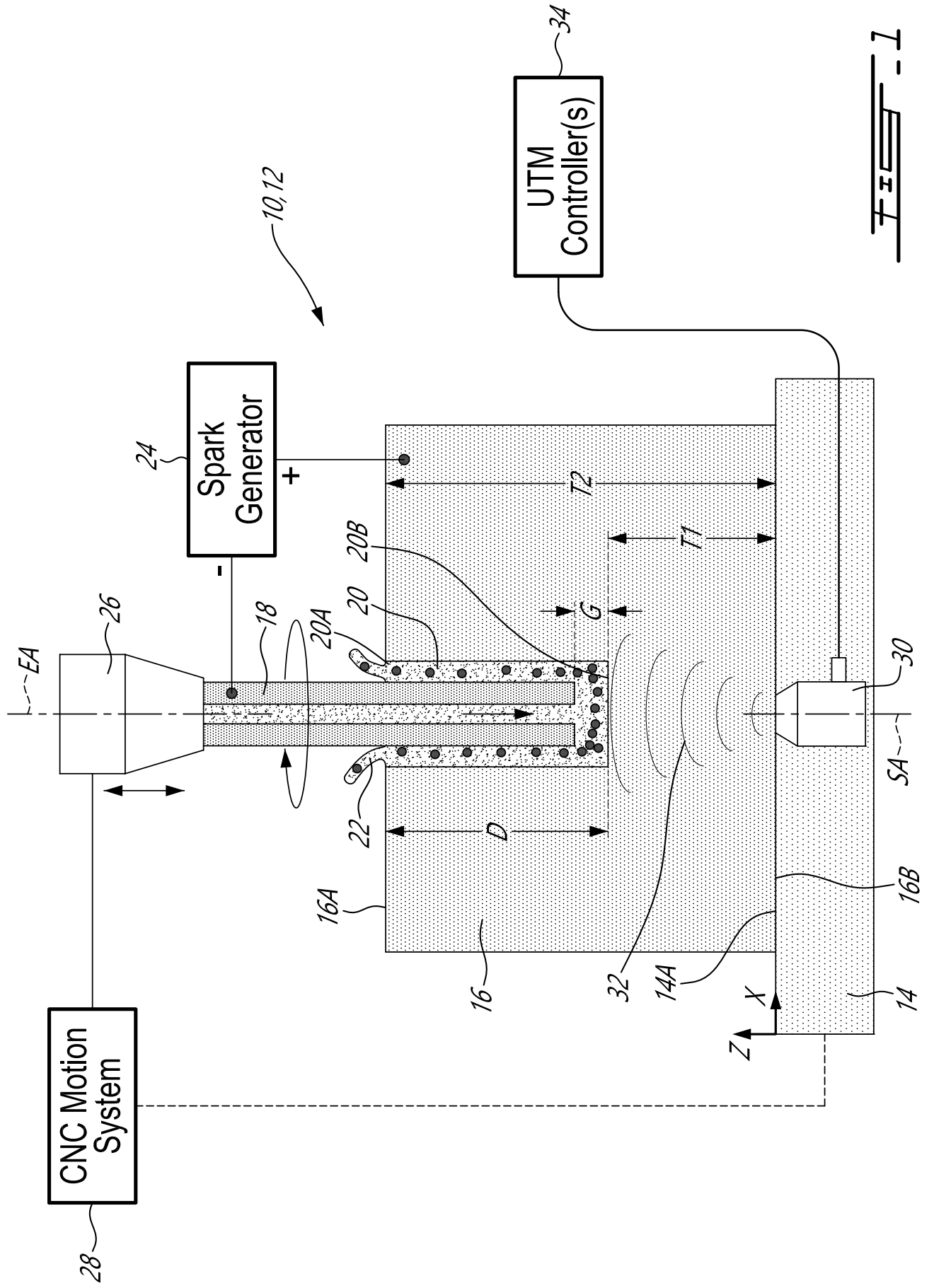
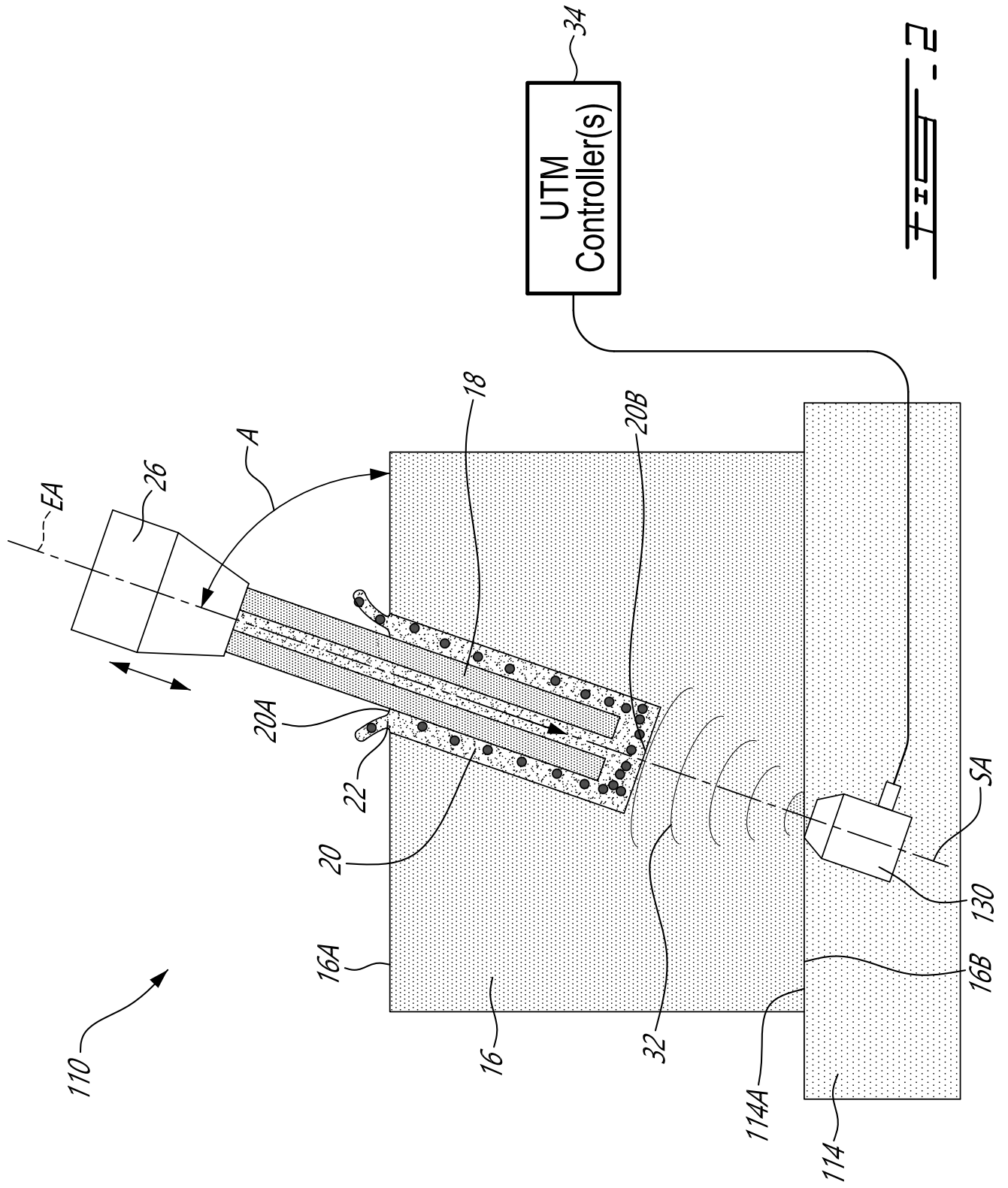






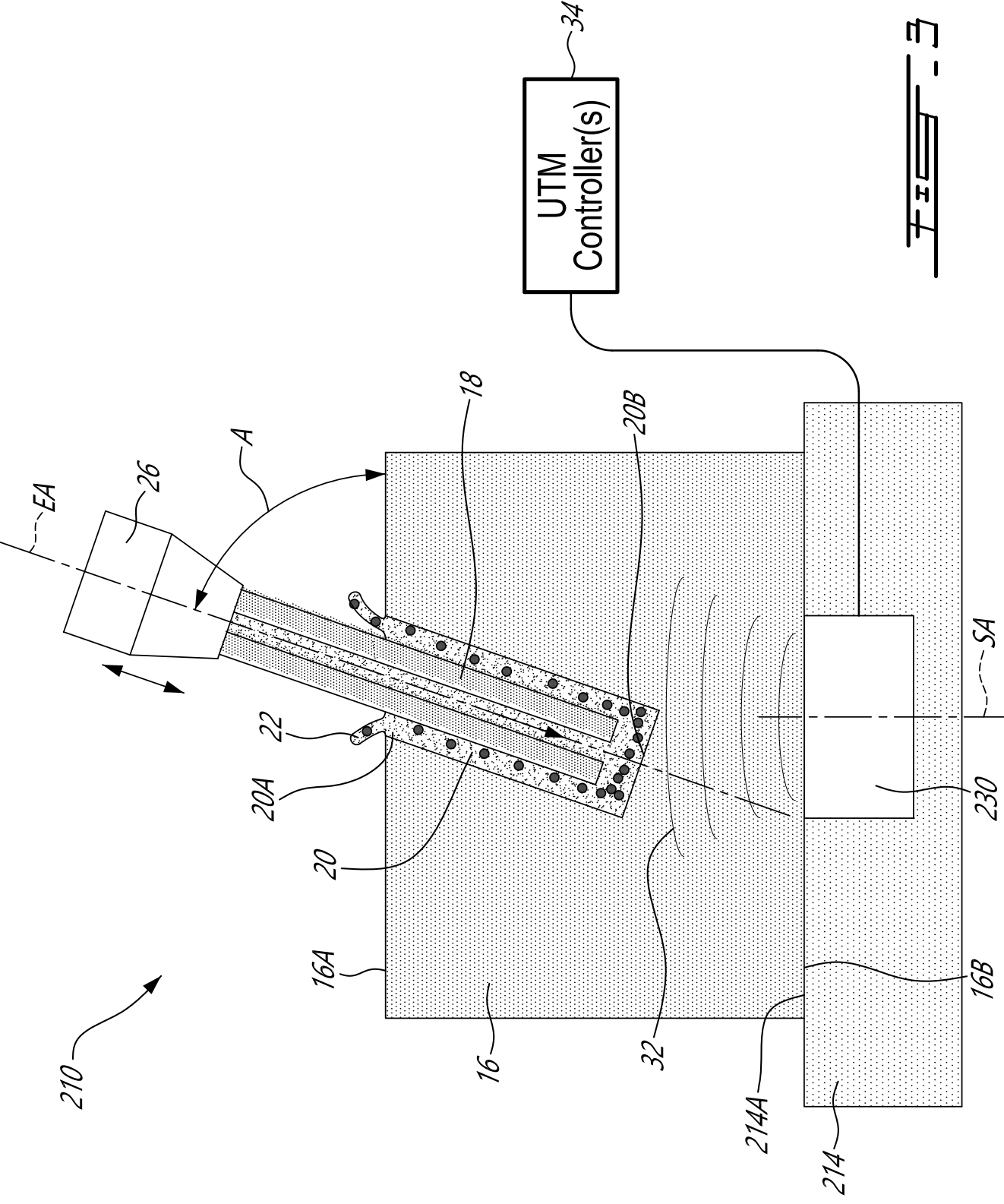


Fig. 3

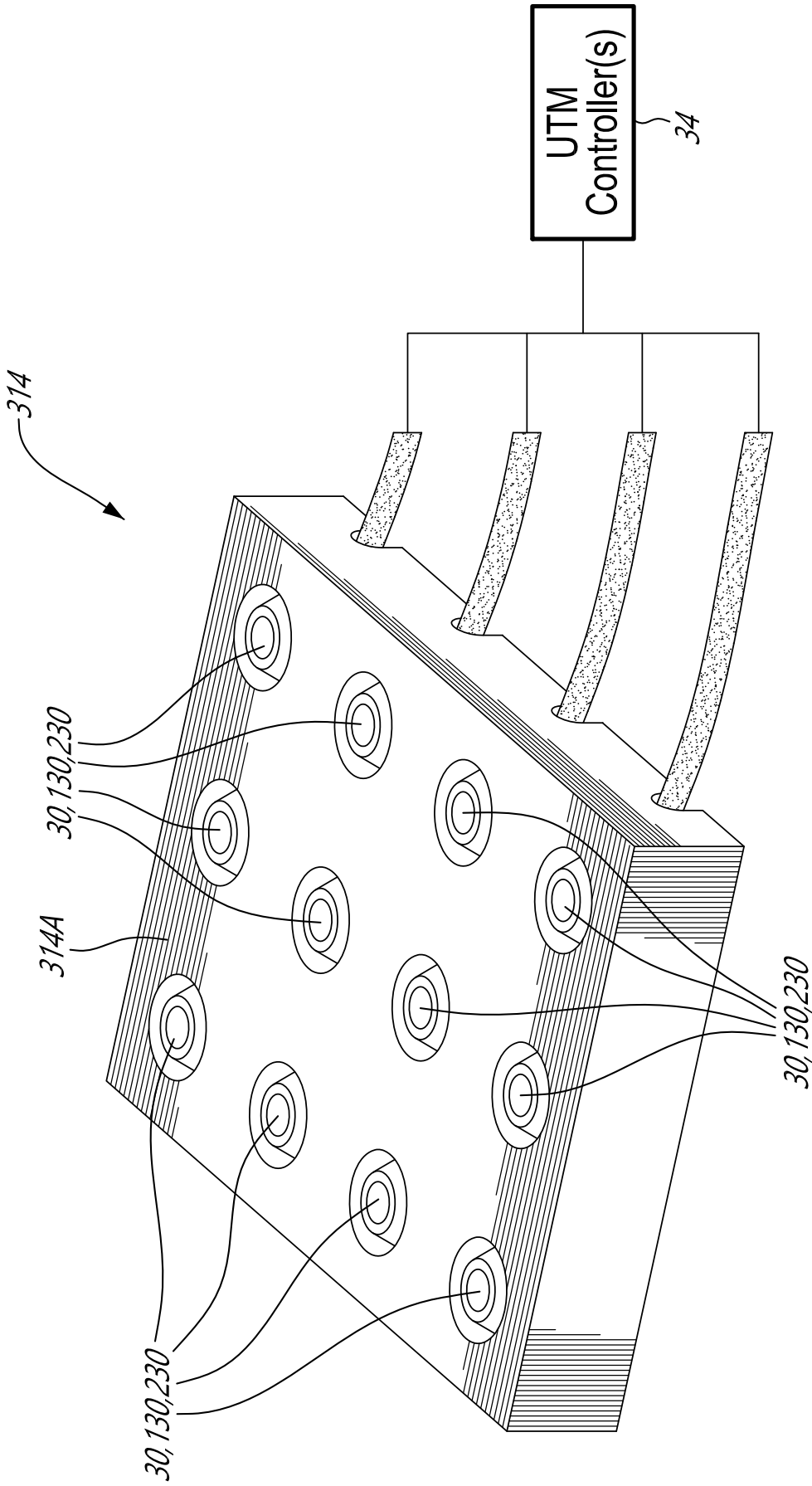


FIG. 4

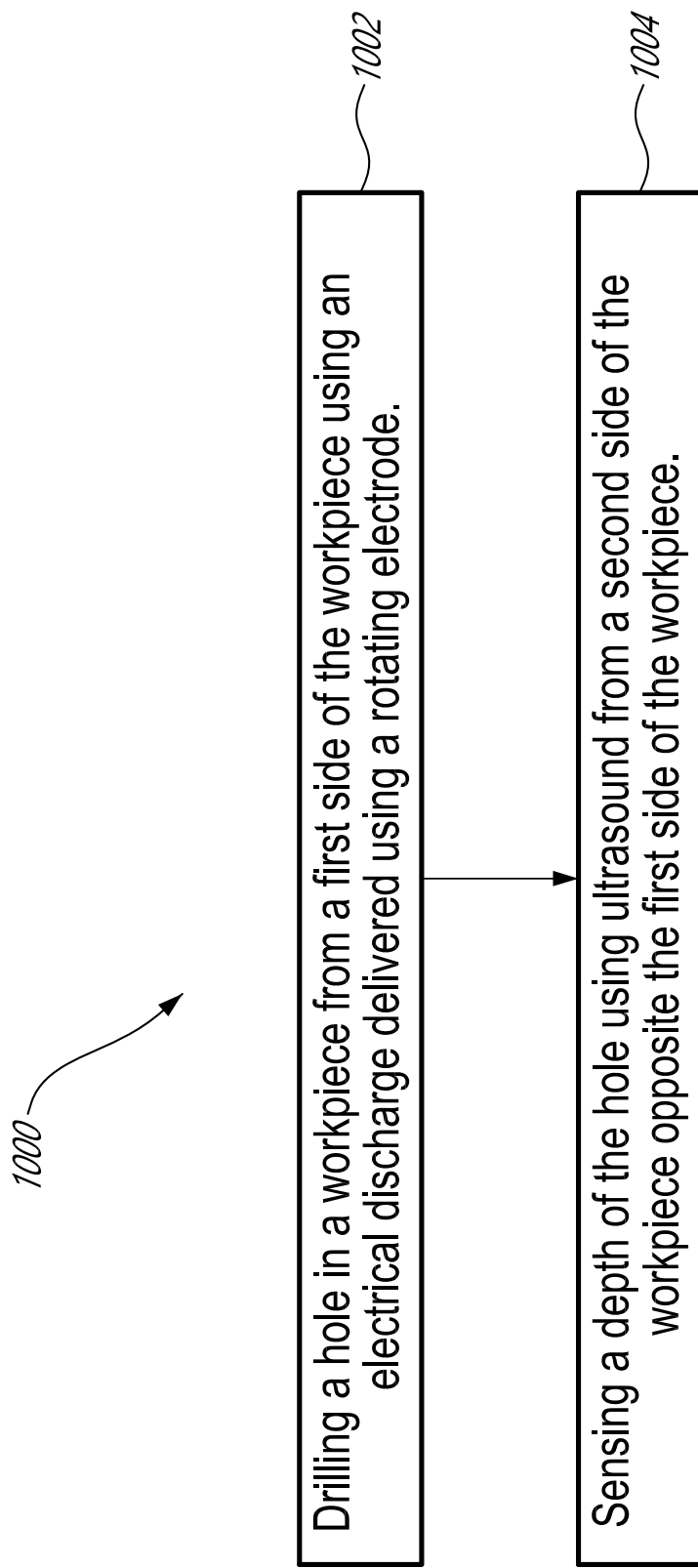
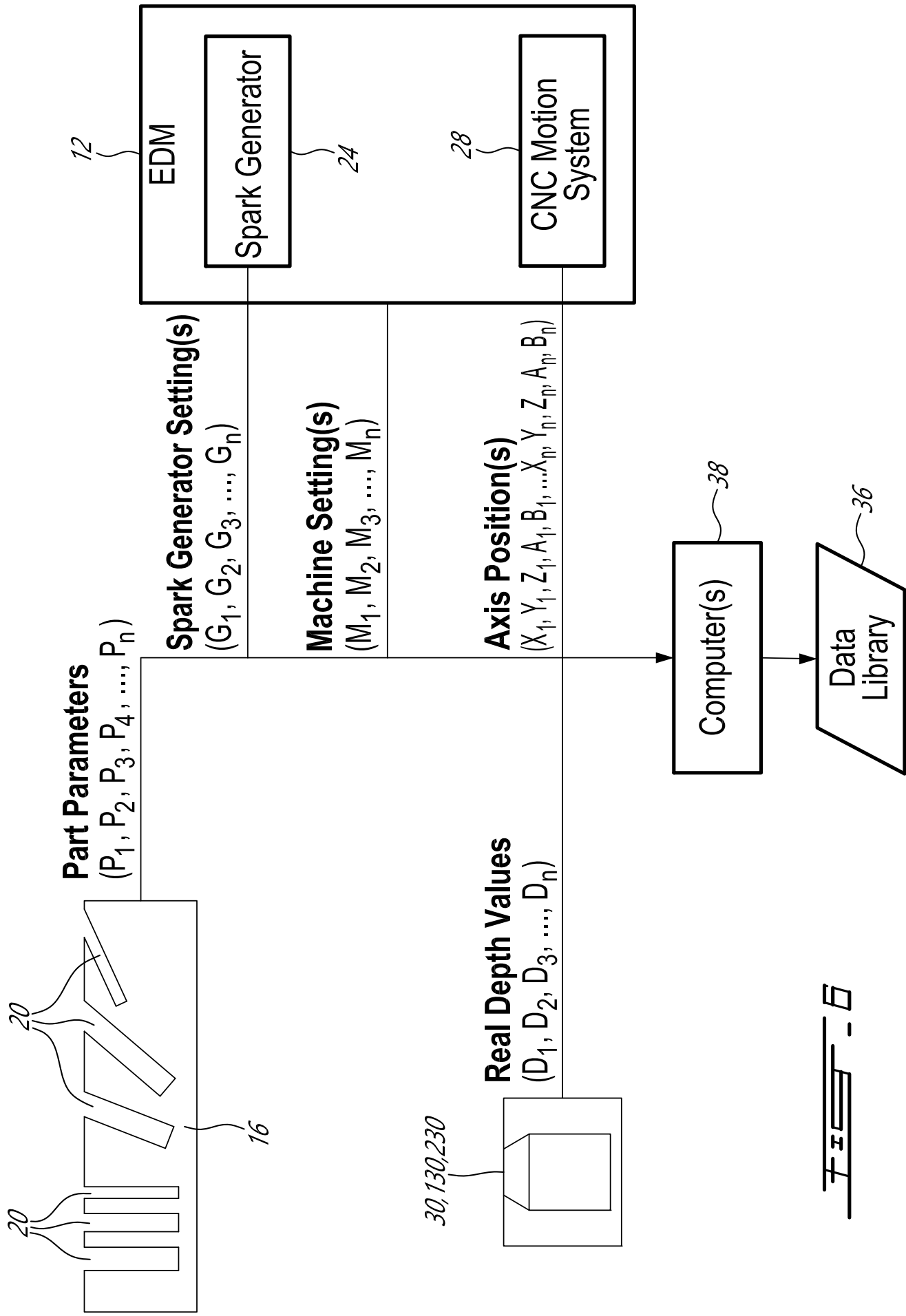


FIG. 5



36



Test Hole ID	Part Parameters		Time (sec)	Real Depth Values (mm)	Spark Generator Settings	Machine Settings	Axis Positions
	Material	Hole Diameter					
1	MAT1	Ø1	T1	D1	G1	M1	X1, Y1, Z1
1	MAT1	Ø1	T2	D2	G2	M2	X2, Y2, Z2
1	MAT1	Ø1	T3	D3	G3	M3	X3, Y3, Z3
...	...	...	...	...	...	...	...
2	MAT2	Ø2	T4	D4	G4	M4	X4, Y4, Z4
2	MAT2	Ø2	T5	D5	G5	M5	X5, Y5, Z5
2	MAT2	Ø2	T6	D6	G6	M6	X6, Y6, Z6
...	...	...	...	...	...	...	...

