Abstract

An apparatus for aiming to improve the machining efficiency by arranging so as to be machinable without causing a breaking accident to the wire electrode while in machining in wire cut electrical-discharge machining.
The wire electrode breaking accident is due to the occurrence of a locally concentrated state of spark-generated positions on the portion to be machined, so that, it is intended to control the working conditions to prevent the wire electrode from breaking by detecting positions of sparking pulses successively generating at the portion to be machined and by discriminating the concentrated condition according to the biased state of individual positions of detected sparking pulses. Whereas, it is arranged so that particularly for the above detection and discrimination of the biased condition of sparking positions of sparking pulses, sparking pulses in the biased area which was set adjacent to the sparking positions of previously detected sparking pulses are measured as in a biased condition, and for sparking pulses out of this biased area, a new biased area is set, measuring them as not in biased, and hereafter this is repeated.

This Sheet Has Been Replaced