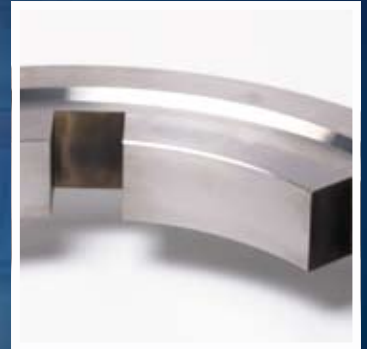
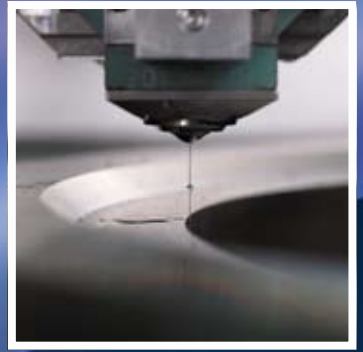


LONESTAR E R O S I O N



+GF+
AgieCharmilles

Large Capacity EDM

CNC Wire Eroding

CNC Spark Eroding

Small Hole EDM

Water Jet Cutting



Licensed Under:
API Spec. 6A-0946



FM30100
ISO9001:2008



OHS53990
OHSAS 18001:2007



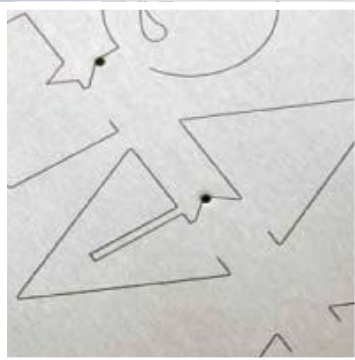
CNC Wire Erosion

- State-of-the-art Swiss wire erosion
- Large capacity - Maximum size 1300 x 1000 x 510mm
- Maximum weight 3000kg
- Sub micron surface integrity (better than grinding)
- Accurate to +/- 0.005mm • 30 degree angle



CNC Spark Erosion

- State-of-the-art Swiss spark erosion
- Large capacity - Maximum size 1300 x 1000 x 500mm
- Maximum weight 1000kg
- Surface finish to 0.2µm • Full C Axis (splines and threads)
- Vectoring at any angle • Auto tool changer
- In-house electrode manufacturing



Small Hole EDM

- EDM drilling of small holes 0.5 to 6mm diameter
- Hole drilling is a production process for the forming of holes in hardened and exotic materials (e.g Inconel, Duplex and Carbide)
- Drilling can be between 0.5mm and 6mm in diameter and up to a depth of 300mm



Water Jet Cutting

- In-house, twin headed water jet cutting machine, made in Sweden
- 3000mm x 1500mm bed size can profile cut using pure water or an abrasive element can be added to increase cutting power
- Powered by a 100hp pump, allows us to cut thicker, tougher materials up to 300mm thick • Cuts without interfering with the materials inherent structure as there is no heat affected zone



Inspection and Quality

- ISO 9001: 2008, OHSAS 18001: 2007 & API 6A Accredited
- 3 no CMM's and 2 no Faro Gages
- PMI, MPI and DPI all carried out on site
- 10 full time QA and QC staff

Lone Star Erosion has a strong technical heritage in all types of EDM. We not only offer sub-contract EDM services but advice, consultancy and feasibility studies. We undertake the following types of work:

- **Aerospace**
- **Medical**
- **Tool making punches, dies & moulds**
- **Food processing**
- **Oil and gas**
- **Nuclear**
- **Precision engineering**
- **Motor sport**

Fields of Expertise

We have amassed vast experience in the sub-contract wire erosion and CNC EDM industries on many prestigious projects.

- Achieving the +/- 2 µm tolerance and 0.2 Ra in titanium on a major satellite component for NASA utilising both CNC EDM and wire erosion
- Produced by wire EDM and CNC EDM all the key features on the tantalum target on the Lucerne accelerator for neutron image experiments
- Microscopic components for implantation in bio-mechanical hearing devices
- Working on numerous petro-chemical projects in Inconel and super duplex materials
- Development of wire eroding of the root section on the Euro fighter canard wings
- Wire erosion of the Inconel bow fins on nuclear submarines
- Wire eroding of the gas compressor blades in nuclear pumps with minimal recast area and minimal copper pollution to prevent copper embrittlement and cracking
- Development of CNC EDM on production of femoral rasp for hip implants to tolerances of +/- 10 µm
- Wire erosion of endoscopic components for ultrasound crack testing on assembled jet engines

Lone Star Erosion

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