

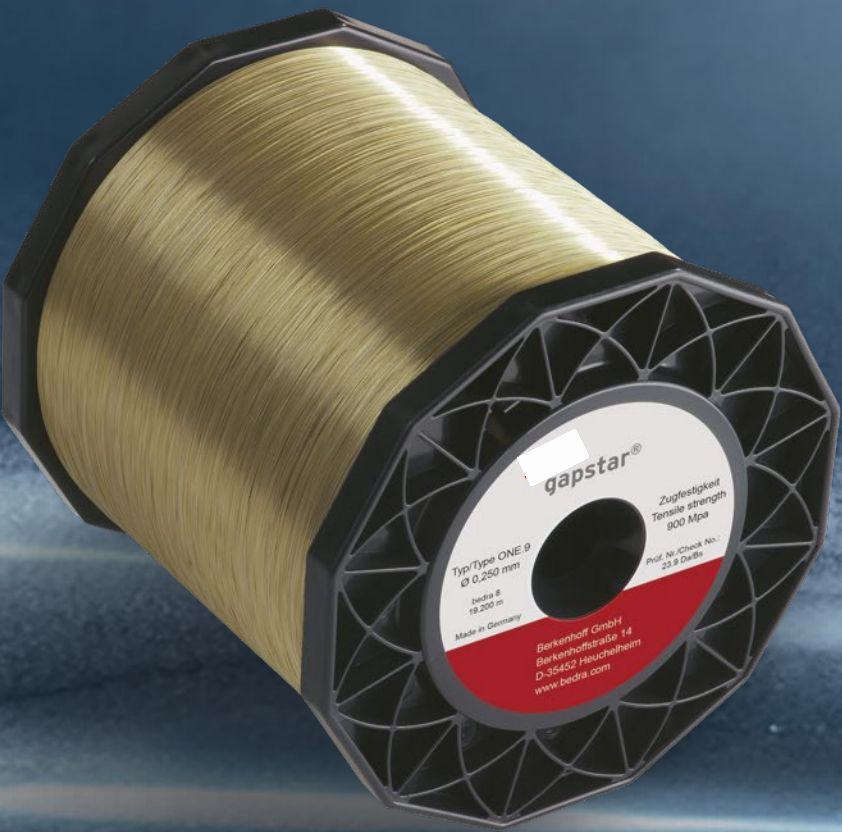
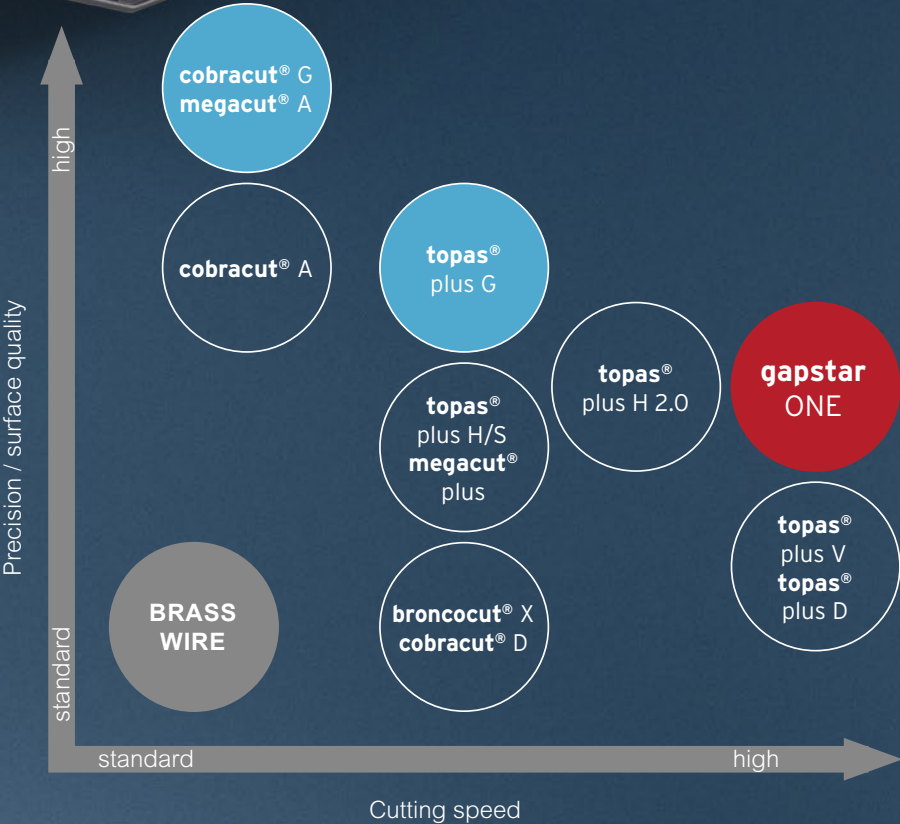
# gapstar ONE

THE NEW GENERATION OF  
HIGH PERFORMANCE WIRES



Being the pioneer in all EDM wire generations, bedra considered the best features of its high performance wires from former generations to invent a new outperforming electrode. The result is gapstar ONE.

- Unprecedented cutting performance for a wide range of applications
- Uncompromising precision and surface quality
- Increased stiffness and excellent straightness for automatic threading



gapstar ONE

THE NEW EDM HIGH PERFORMANCE WIRE WITH  
THE bedra TRIMPAC TECHNOLOGY



# TRIMPAC

## THE NEW bedra TECHNOLOGY

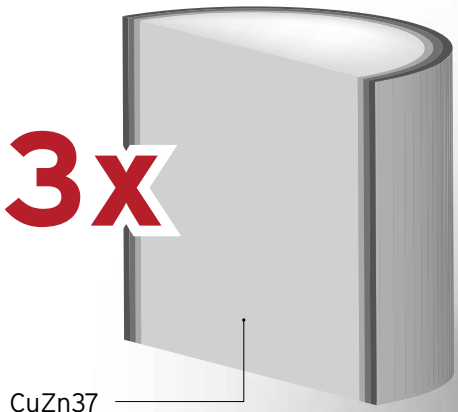
From the strengths of the wire generations **cobra-cut®**, **broncocut®** and **topas®** bedra developed in 2019 the new coating technology **TRIMPAC**.

### TRIPLE IMPACT SHEATH:

- New heat treatment
- Zinc-enhanced coating
- Structured surface

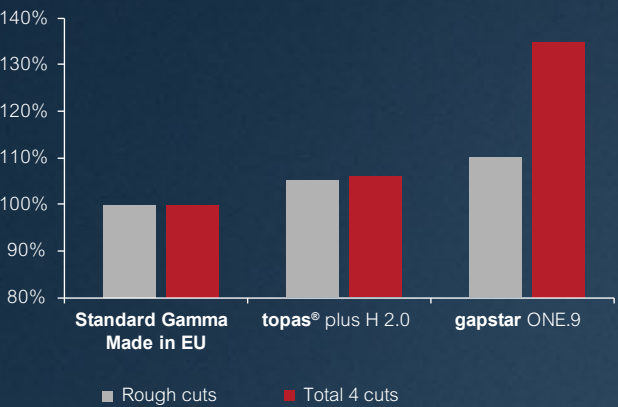


PATENT PENDING

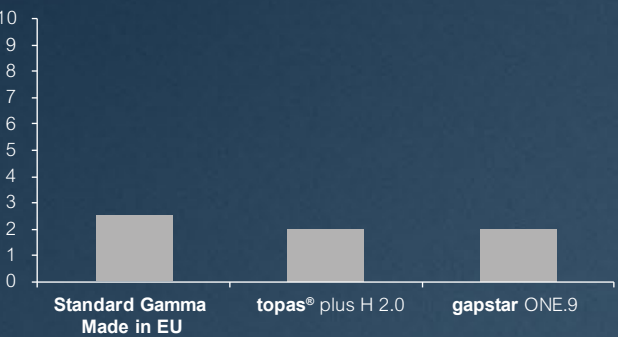


# Up to 37% savings

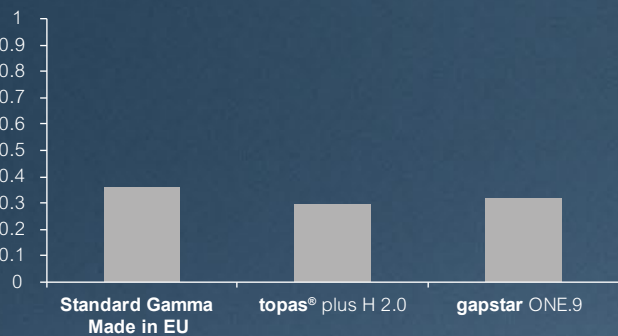
Cutting rate



Precision (µm)



R<sub>a</sub> (µm)



gapstar ONE.9	
Work material	Tool steel
Thickness (mm)	50
Wire diameter (mm)	0.25
Technology	4 cuts R <sub>a</sub> = 0.30 µm

## gapstar ONE.9



### Features

- Significant increase of feed rates in rough cut and trimcuts without adjustments
- Reduced abrasion of wire preserves wire guides and power contacts
- Novel TRIMPAC coating enables roughness on the workpiece of R<sub>a</sub> = 0,25 µm
- Reliable, automatic wire threading

## gapstar ONE.5



Soft  
version for  
taper  
cutting

	gapstar ONE.9	gapstar ONE.5
Core	CuZn37	
Coating	TRIMPAC	
Color	Amber Brown	
Tensile strength (MPa)	900	500
Elongation (%)	1	10
Diameter (mm)	0.20 / 0.25 / 0.30	0.25
Spool types	bedra 8, bedra 16 K250, K355 P5, P10, P15	

Example cost accounting		Brass-wire	gapstar ONE
Input data			
Wire diameter	mm	0.25	0.25
Wire run-off speed	m/Min.	10	10
Price	€/kg	8.5	15
Hourly rate for WEDM machine	€/h	30	30
No. of machines		1	1
Cutting time per machine	h	1,000	600
Wire cost			
Used weight of wire	m	600,000	360,000
Used weight of wire	kg	247	148
Resulting wire cost	€	2,103	2,227
Relative	%	100	100
Machine cost		30,000	18,000
Overall cost		€ 32,103	20,227
savings up to		€	11,876
		%	37%