



**Precision
runs
on wire!**



MASTER BRASS®
EDM WIRE PRODUCTION

Ø _____
Kg _____
N/mm² _____

REF. _____

TFE®
WWW.TFESRL.COM

MADE IN ITALY

BORA - CUT P®
EDM WIRE PRODUCTION

Ø _____
Kg _____
N/mm² _____

REF. _____

TFE®
WWW.TFESRL.COM

MADE IN ITALY

BORA - CUT®
EDM WIRE PRODUCTION

Ø _____
Kg _____
N/mm² _____

REF. _____

TFE®
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MADE IN ITALY

TECHNO BRASS®
EDM WIRE PRODUCTION

Ø _____
Kg _____
N/mm² _____

REF. _____

TFE®
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MADE IN ITALY

POWER CUT®
EDM WIRE PRODUCTION

Ø _____
Kg _____
N/mm² _____

REF. _____

TFE®
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MADE IN ITALY

SP...

Ø _____
Kg _____
N/mm² _____

REF. _____

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MADE IN ITALY

About Us



Our passion for electroerosion came when we were young on the first EDM machines in the Italian metalworking branch, in the plants where we were simple learners.

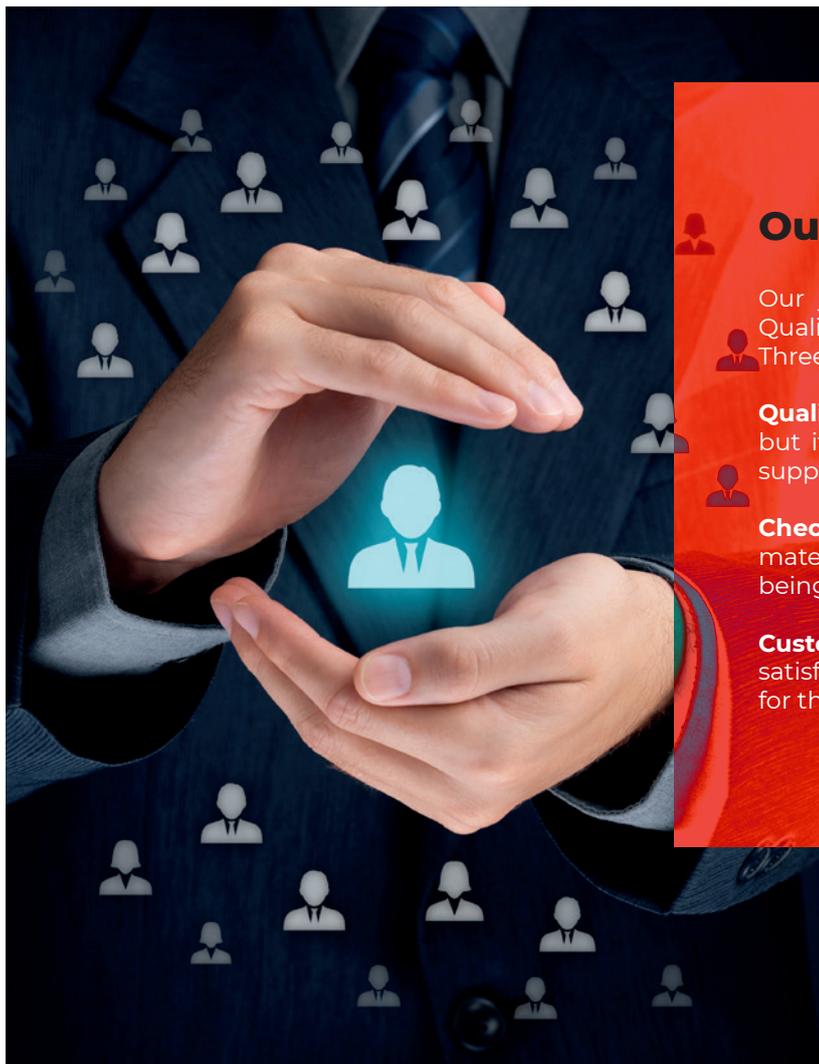
We worked at those machines which at that time looked like machines of the future.

It was 1979: since then erosion became our breathing.

“

1990 came. Future was smiling to us and with plenty of courage we founded our company: TFE Srl. There were just two of us and two drawing machines. With great passion we started manufacturing a wire that is known for its clean surface and production repeatability. Today there are 15 of us and we have covered a long route! Many years full of success.

Roberto Riccardi Bertol Bertolus



Our Business Philosophy

Our job is based on three main targets: Quality, Check and Customer Satisfaction. Three basic topics for a successful company.

Quality: in our job this is a basic word but it loses its actual meaning if it is not supported by repeatability and constancy.

Check: in each production step – from raw material to packaging – on each spool before being vacuum packed.

Customer satisfaction, our main target: a satisfied customer is the most valuable prize for the whole TFE staff.

Made in Italy

Through a strict cooperation with a leading R&D Institute we have developed products that can reach a higher cutting speed than the other import standard brass wires distributed in most markets.

Our sales network with highly skilled technical consultants can help you to find out the right product, carry out tests and achieve the best performance from your EDM machine.



Our top diamonds





BORA CUT

Wire with a special and patented coating able to reach a performing level beyond the current standards.

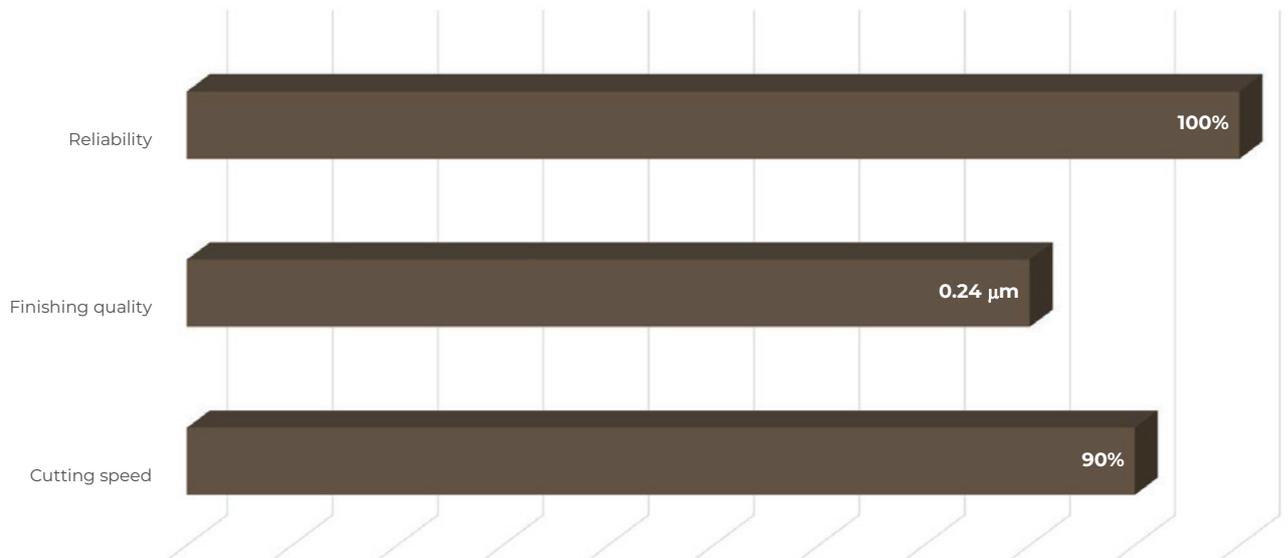
This wire shows each customer its amazing performances: cutting speed, precision and workpiece finishing, especially on high thickness.

Bora Cut wire, a high-tech new entry, assures speed values about +30% against the standard brass wires and +15% against the coated wires in the market.

A unique wire, really matchless in the market.

Recommended for all EDM machines.

Features



Spool type	Net weight	Diameter					
		0.10	0.15	0.20	0.25	0.30	0.33
DIN 125	Kg. 3,8	•	•	•	•	•	•
DIN 160	Kg. 6,5/8		•	•	•	•	•
DIN 200	Kg. 16			•	•	•	•
DIN 250	Kg. 25			•	•	•	•
DIN 355	Kg. 45			•	•	•	•
P 5	Kg. 5/6	•	•	•	•	•	•
P 10	Kg. 10			•	•	•	•
P 15	Kg. 15/20			•	•	•	•

Tensile strength:

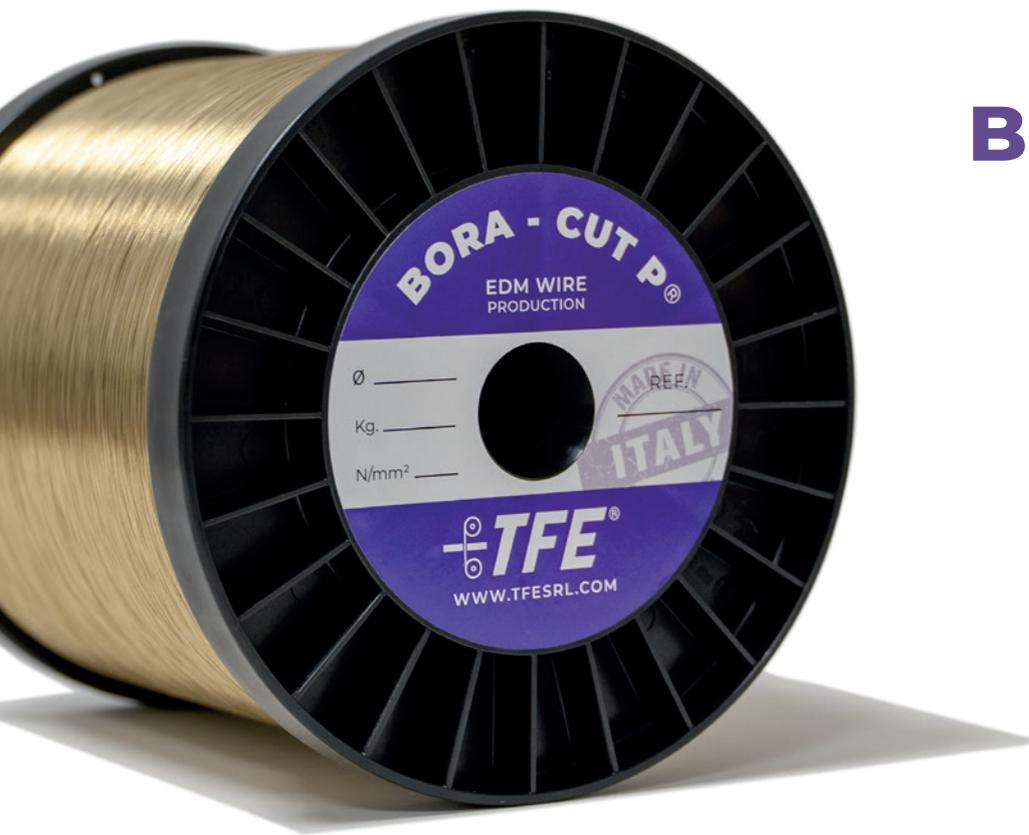
390 - 420 N/mm² standard

490 - 500 N/mm² standard

900 N/mm² standard

Diameter tolerance:

- 0,002 mm.



BORA CUT P

EDM wire with special coating and treatment, patented, empowered performances.

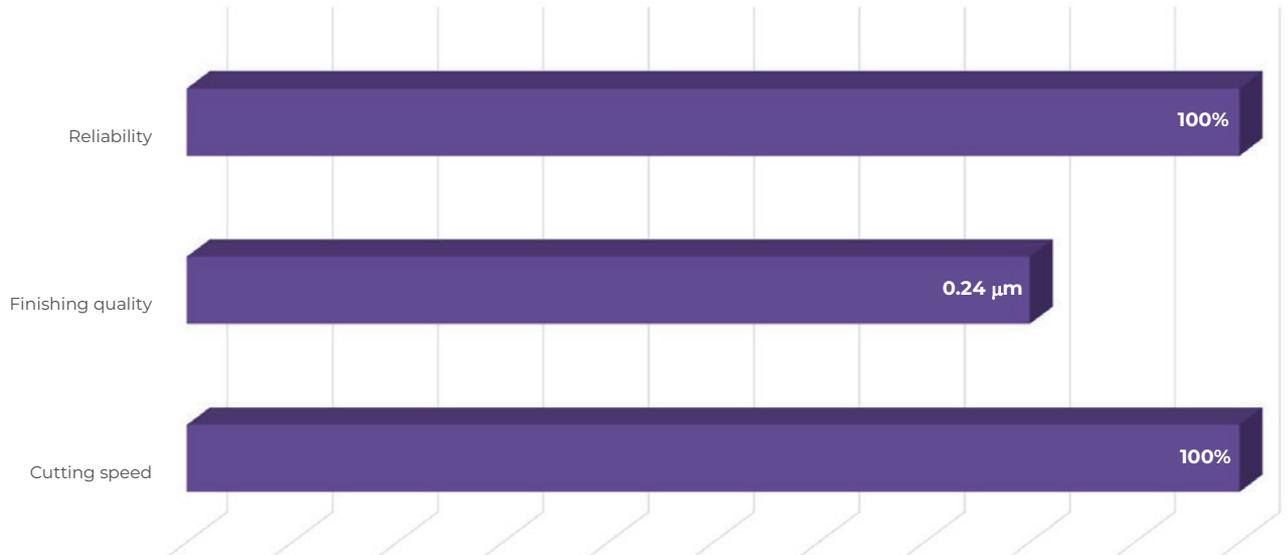
It is the top wire of our range.

In addition to excellent performances in speed, accuracy and finishing, Bora Cut P offers an extra kick: it can reach averagely +10% more than our standard Bora Cut, which means +40% more than the standard brass wires and +25% more than the coated wires on the market.

A true rarity we put in our customers' hands.

Recommended for all EDM machines.

Features



Spool type	Net weight	Diameter					
		0.10	0.15	0.20	0.25	0.30	0.33
DIN 125	Kg. 3,8	•	•	•	•	•	•
DIN 160	Kg. 6,5/8		•	•	•	•	•
DIN 200	Kg. 16			•	•	•	•
DIN 250	Kg. 25			•	•	•	•
DIN 355	Kg. 45			•	•	•	•
P 5	Kg. 5/6		•	•	•	•	•
P 10	Kg. 10			•	•	•	•
P 15	Kg. 15/20			•	•	•	•

Tensile strength:

390 - 420 N/mm² standard

490 - 500 N/mm² standard

900 N/mm² standard

Diameter tolerance:

- 0,002 mm.



POWER CUT

Brass core and zinc coating.

Due to its particular properties this wire is especially suitable for high speed cutting where also high precision and very good finishing of the workpiece are required.

Its excellent straightness assures a perfect AWT.

POWER CUT 900 is recommended for all EDM machines, especially for Agie.

POWER CUT 500 is recommended for all EDM machines, especially for Agie (type DEM and AC50) and Charmilles.

Features



Spool type	Net weight	Diameter					
		0.10	0.15	0.20	0.25	0.30	0.33
DIN 125	Kg. 3,8	•	•	•	•	•	•
DIN 160	Kg. 6,5/8		•	•	•	•	•
DIN 200	Kg. 16			•	•	•	•
DIN 250	Kg. 25			•	•	•	•
DIN 355	Kg. 45			•	•	•	•
P 5	Kg. 5/6		•	•	•	•	•
P 10	Kg. 10			•	•	•	•
P 15	Kg. 15/20			•	•	•	•

Tensile strength:

390 - 420 N/mm² standard

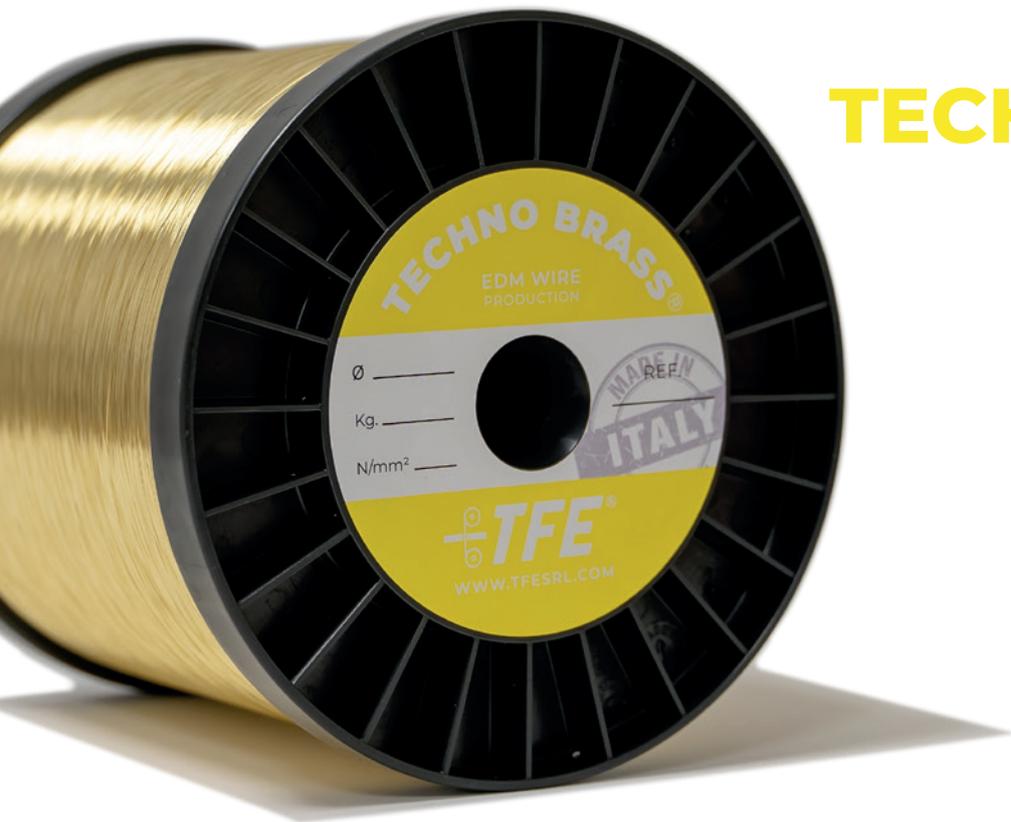
490 - 500 N/mm² standard

900 N/mm² standard

others on request

Diameter tolerance:

- 0,002 mm.



TECHNO BRASS

Plain wire made of a metal alloy which is the result of a long and targeted metallurgical research in our labs.

If used on modern and high-tech machines, this wire of new generation offers excellent performances, can reach a remarkable cutting speed (top rate) and assures a perfect precision and surface finishing.

Paraffin free.

Recommended for all EDM machines, above all Mitsubishi (RA, FA, QA), Agie (HSS, Classic, Evolution), Fanuc Alpha, ONA, and Sodick.

Features



Spool type	Net weight	Diameter				
		0.20	0.25	0.30	0.33	0.36
DIN 125	Kg. 3,8	•	•	•		
DIN 160	Kg. 6,5/8	•	•	•	•	•
DIN 200	Kg. 16	•	•	•	•	•
DIN 250	Kg. 25	•	•	•	•	•
DIN 355	Kg. 45		•	•	•	•
P 5	Kg. 5/6	•	•	•		
P 10	Kg. 10	•	•	•	•	•
P 15	Kg. 15/20	•	•	•	•	•

Tensile strength:

1000 - 1200 N/mm²

standard

others

on request

Diameter tolerance:

- 0,002 mm.



MASTER BRASS

Plain brass wire with a wide range of applications.

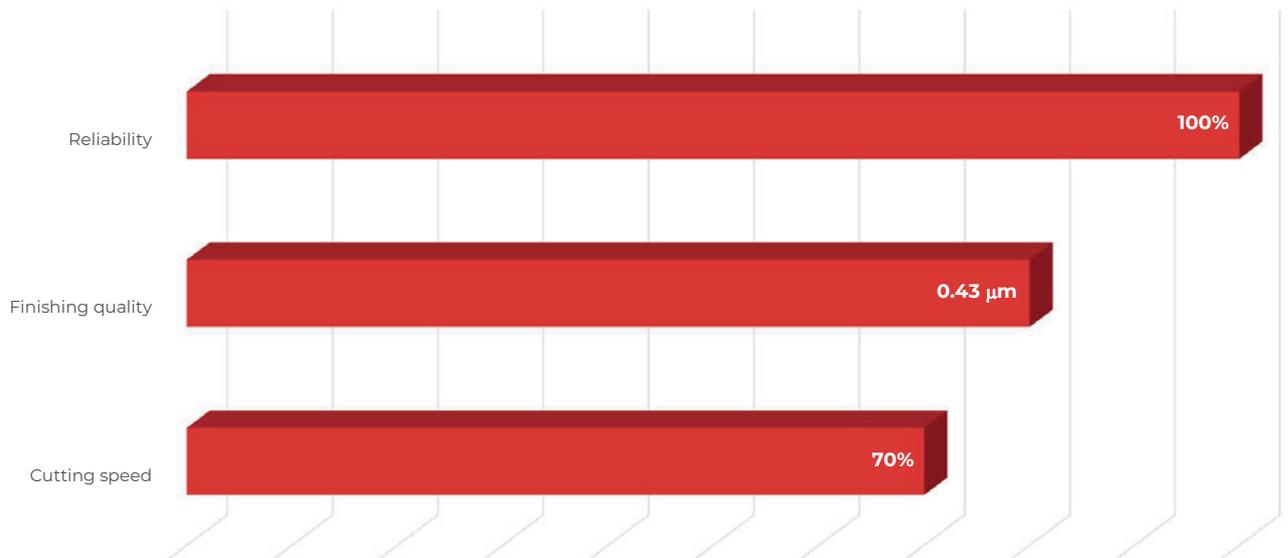
Suitable for any machining operation, it assures a uniform and high precision cutting, also for particular taper cuts.

Its high straightness makes it an excellent wire for AWT (Automatic Wire Threading).

Paraffin free.

Recommended for all EDM machines.

Features



Spool Type	Net Weight	Diameter					
		0.10	0.15	0.20	0.25	0.30	0.33
DIN 125	Kg. 3,8	•	•	•	•	•	•
DIN 160	Kg. 6,5/8		•	•	•	•	•
DIN 200	Kg. 16			•	•	•	•
DIN 250	Kg. 25			•	•	•	•
DIN 355	Kg. 45				•	•	•
P 5	Kg. 5/6		•	•	•	•	•
P 10	Kg. 10			•	•	•	•
P 15	Kg. 15/20			•	•	•	•

Tensile strength:

390 - 420 N/mm² standard

490 - 500 N/mm² standard

900 N/mm² standard

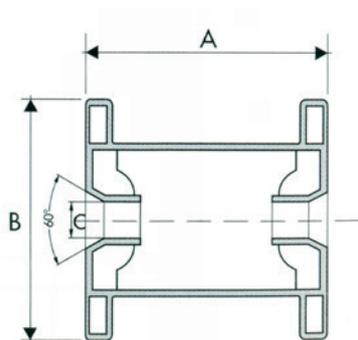
1000 - 1100 N/mm² standard

others on request

Diameter tolerance:

- 0,002 mm.

Packaging Tables



Spool	Dimensions mm			Net Weight kg (*)
	A	B	C	
DIN 125	125	125	16	3,8
DIN 160	160	160	22	6,5/8
DIN 200	200	200	22	16
DIN 250	200	250	22	25
DIN 355	200	355	36	45
P 5	114	160	20	5/6
P 10	135	200	21	10
P 15	140	250	21	15/20

* OTHER WEIGHTS ON REQUEST

Spool	Spool/Box	Box Dimensions mm LxLxH	Boxes/pallet	Net Weight of a full pallet (kg*)
DIN 125	4	26x26x17	48	729,6
DIN 160	2	33x17x18	56	728
DIN 200	1	22x22x22	45	720
DIN 250	1	28,5x24x33	--	--
DIN 355	1	36x20,5x37	--	--
P 5	2	33x17x14,5	66	660
P 10	1	21x21x25	64	640
P 15	1	26x26x34	48	960

* OTHER WEIGHTS ON REQUEST

Wire Meters and Spool Weights

Spool type	Wire diameter (mm)	Wire length/spool (m)	Net weight/spool (kg)
DIN 125	0.10	45.180	3
	0.15	25.400	3,5
	0.20	14.250	3,5
	0.25	9.160	3,5
	0.30	6.360	3,5
	0.33	5.270	3,5
DIN 160	0.15	43.460	6,5
	0.20	24.370	6,5
	0.25	15.680	6,5
	0.30	10.880	6,5
DIN 160	0.33	9.010	6,5
	0.15	53.500	8
	0.20	30.000	8
	0.25	19.300	8
	0.30	13.400	8
DIN 160	0.33	11.100	8
	0.20	60.000	16
	0.25	38.600	16
	0.30	26.800	16
	0.33	22.200	16
DIN 200	0.20	93.750	25
	0.25	60.310	25
	0.30	41.870	25
	0.33	34.680	25
DIN 250	0.25	108.560	45
	0.30	75.370	45
	0.33	62.430	45
DIN 355	0.15	33.430	5
	0.20	18.750	5
	0.25	12.060	5
	0.30	8.370	5
	0.33	6.930	5
P5	0.15	40.120	6
	0.20	22.500	6
	0.25	14.470	6
	0.30	10.050	6
	0.33	8.320	6
P10	0.20	37.500	10
	0.25	24.120	10
	0.30	16.750	10
	0.33	13.870	10
P15	0.20	56.250	15
	0.25	36.180	15
	0.30	25.120	15
	0.33	20.810	15
P15	0.20	75.000	20
	0.25	48.250	20
	0.30	33.500	20
	0.33	27.750	20

* VALUES ESTIMATED ON CuZn ALLOY WITH 8.44 g/cm³ DENSITY



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