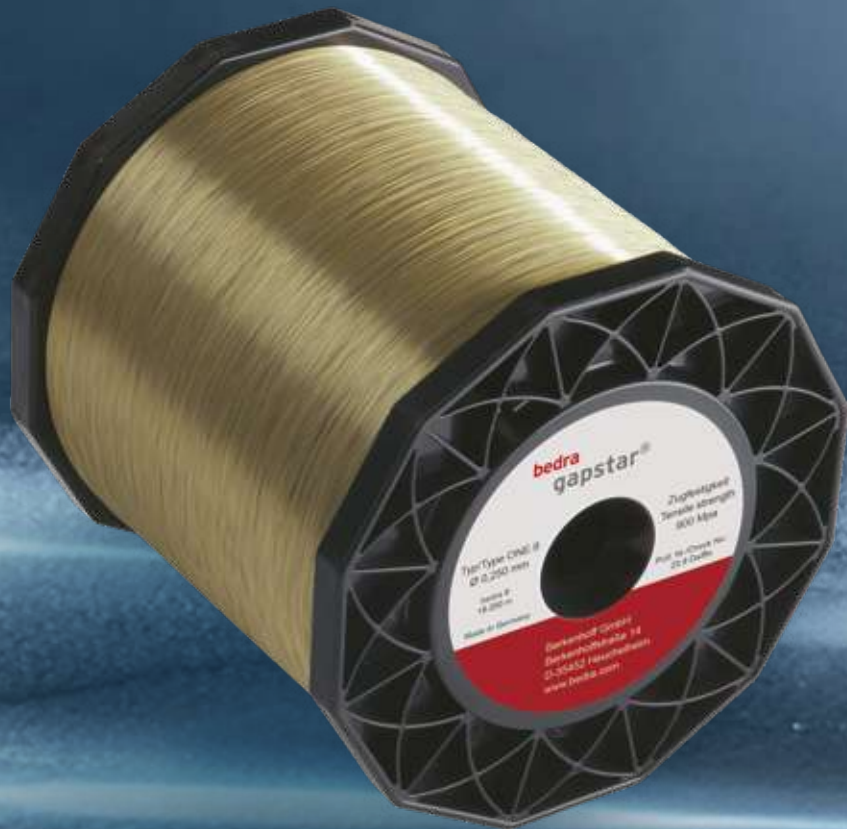




# gapstar® ONE

THE NEW EDM HIGH PERFORMANCE WIRE WITH  
THE bedra TRIMPAC TECHNOLOGY

**bedra**  
intelligent alloys

# TRIMPAC



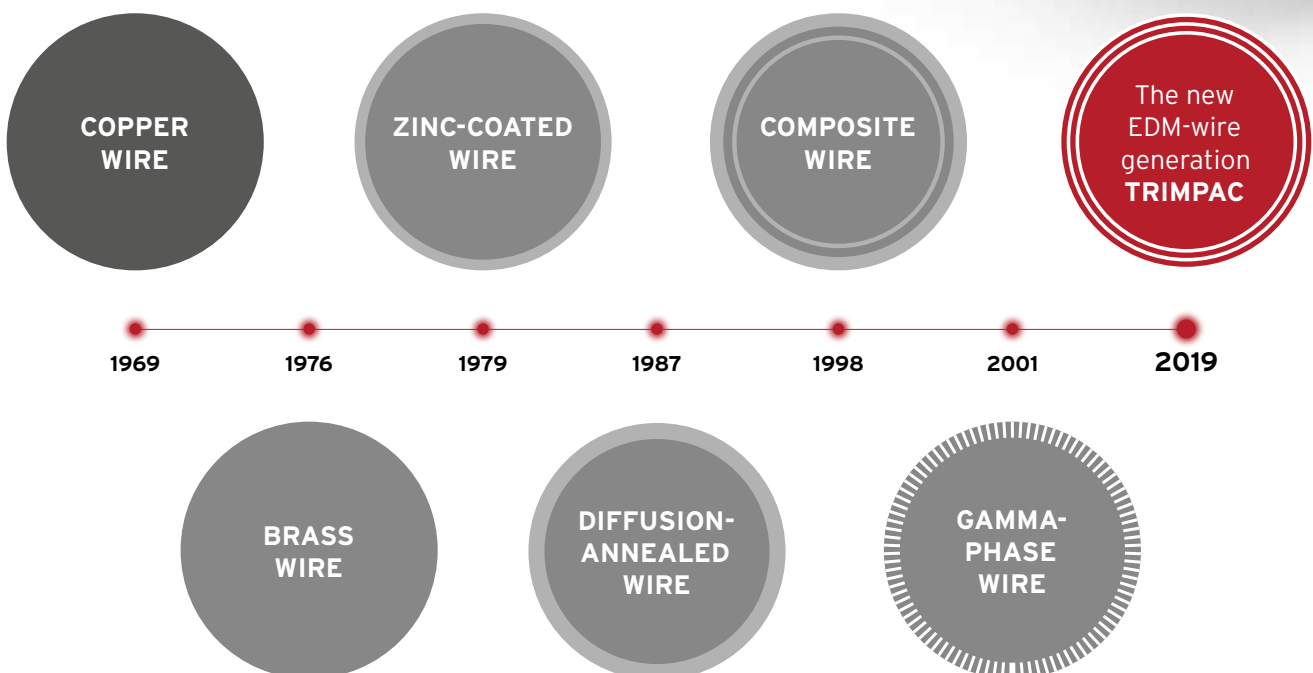
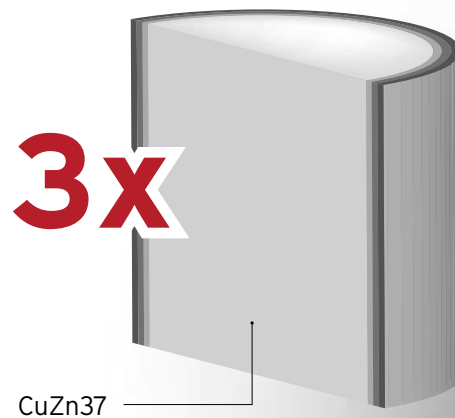
## THE NEW bedra TECHNOLOGY

PATENTED

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



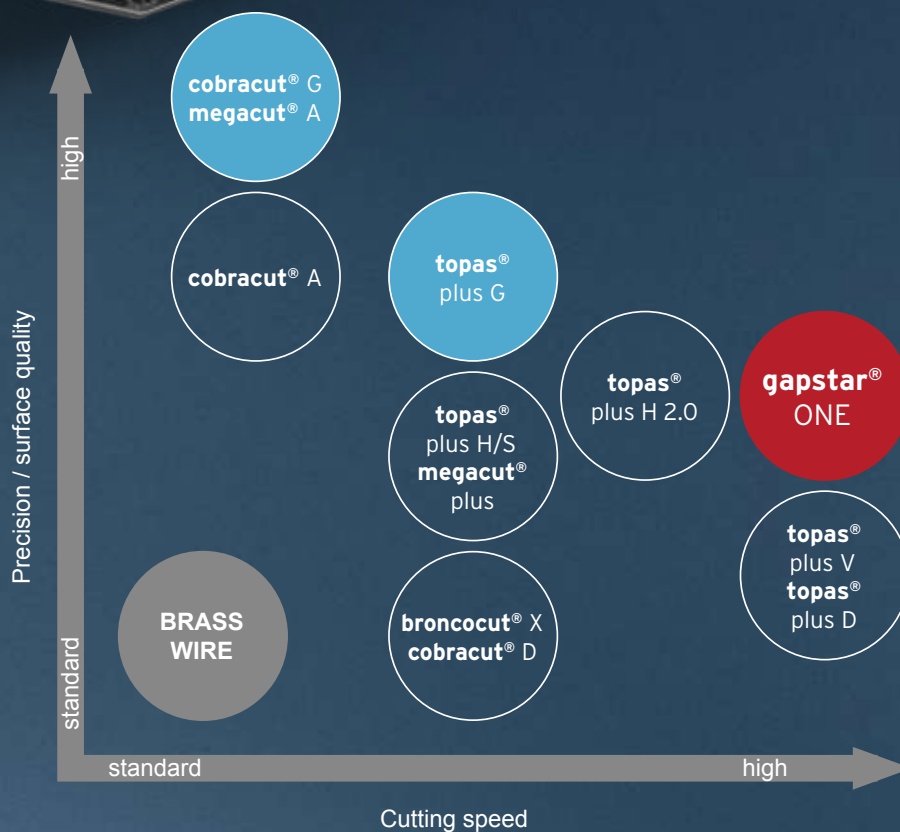
# gapstar® ONE

## 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**

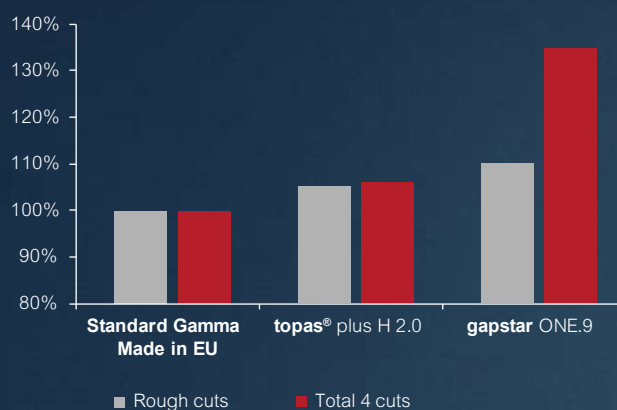


# Up to 37% savings

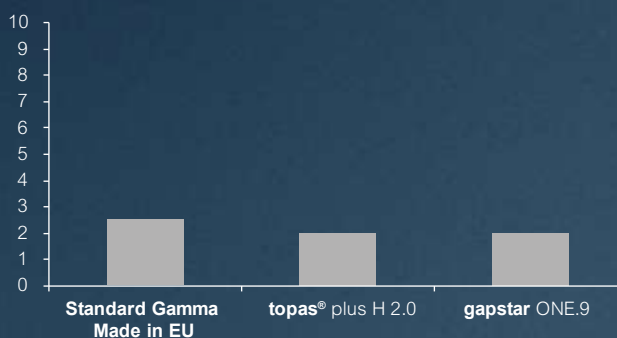
Save now:  
Cost comparison  
calculator



## Cutting rate



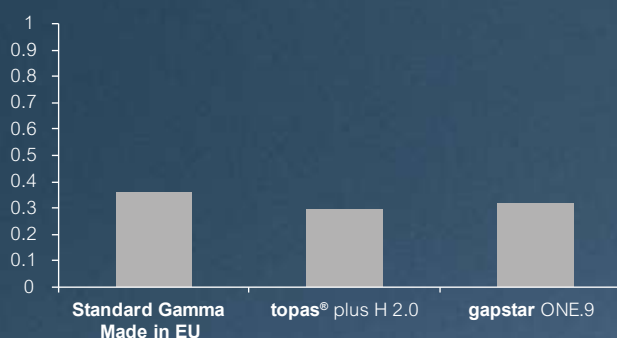
## Precision (µm)



## gapstar<sup>®</sup> ONE.9

|                    |                                    |
|--------------------|------------------------------------|
| Work material      | Tool steel                         |
| Thickness (mm)     | 50                                 |
| Wire diameter (mm) | 0.25                               |
| Technology         | 4 cuts<br>$R_a = 0.30 \mu\text{m}$ |

## $R_a$ (µm)





# gapstar® ONE

... available in 3 variants, which differ from each other in strength and thus also in elongation:

**gapstar® ONE.9**  
(900 MPa)

**gapstar® ONE.5**  
(500 MPa)

**gapstar® ONE.4**  
(430 MPa)

Extra soft  
version for  
extreme taper  
cutting

Soft  
version for  
taper  
cutting

## Features

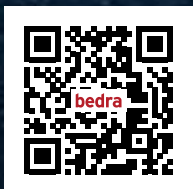
- Significant increase of feed rates in rough cut and trimcuts without adjustments
- Reduced abrasion of wire preserves wire guides and power contacts
- Novel TRIMPAC coating enables roughness on the workpiece of  $R_a = 0,25 \mu m$
- Reliable, automatic wire threading

|                           | gapstar®<br>ONE.9                               | gapstar®<br>ONE.5 | gapstar®<br>ONE.4 |
|---------------------------|-------------------------------------------------|-------------------|-------------------|
| Core                      | CuZn37                                          |                   |                   |
| Coating                   | TRIMPAC                                         |                   |                   |
| Color                     | Amber Brown                                     |                   |                   |
| Tensile strength<br>(MPa) | 900                                             | 500               | 430               |
| Elongation<br>(%)         | 1                                               | 10                | > 30              |
| Diameter<br>(mm)          | 0.20 / 0.25 / 0.30                              | 0.25              | 0.25              |
| Spool types               | bedra 8, bedra 16<br>K250, K355<br>P5, P10, P15 |                   |                   |

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**bedra**  
intelligent alloys