

AC Metal Disintegrator Selector Chart

ELECTRODES FOR TAPS			MACHINE SETTINGS					ELECTRODES FOR DRILLS				
Tap Size Inch	Tap Size Metric	Electrode Size Inch	Cutting Power Setting (Heat Selection)				Power Stroke	Auto Feed Speed Low Range	Drill Size Inch	Drill Size Metric	Electrode Size Inch	
			3kva	10kva	15kva	20kva						
0-80		.020	1	1	1	1	50			.032		
0-90	1.6	.030	1	1	1	1			.1	.036		
1		.035	1	1	1	1				.040	1	.035
2	2	.040	2	1-2	2	2	75-100		.050-.060	1.5	.040	
	2	.050	2	2	2	2			.060-.070	2	.050	
4	2.5	.060	2	2	2	2			.080-.090	2.5	.060	
6	3	.075	2	2	3	2						
	3	.079	2	2	3	2			.2	.090-.100	3	.075
8	4	.090	3	2	3	2			.100-.115	4	.090	
	4	.098	3	2-3	3	2						
10&12	5	.110	3	2-3	3	3			.115-.130		.090	
	5	.118	3	3	3	3						
1/4	6	.125	4	3	4	3		.3	.130-.150	5	.110	
1/4*		.140	4	3	4	3						
5/16	8	.156	4	4	4-5	4			.150-.175		.140	
5/16*	8	.170	4	4	4-5	4						
	8	.177	5	4	5	4			.175-.200	6	.156	
3/8	10	.187	5	4	5	4			.200-.225	-	.170	
3/8*	10	.200	5	4-5	5	4		.4				
7/16	12	.218		5	5	5	100		.225-.250	8	.187	
	12	.236		5	5	5			.250-.300	9	.200-.218	
1/2	14	.250		5	5-6	5			.300-.375	10	.250	
	14	.276		5	5-6	5						
9/16	16	.290		6	6	6						
5/8	18	.312		6	6-7	6						
11/16	18	.342		6	7	6		.3	.375-.450	11	.290	
	20	.354		6	7	6			.450-.500	12	.312	
3/4	20	.375		6-7	8	7						
	20	.393		6-7	8	7						
	22	.433		7	8	7			.500-.600	14	.375	
7/8		.437		7	8-9	7		.25				
	24	.472		7	8-9	7						
1		.500		7	9	7			.600-.750		.375	
		.512		8	9	7-8						
		.551		8	9-10	7-8			.750-1.0	18	.437	
		.590		8	9-10	8		.2				
1 1/4		.625		8	10	8						
1 1/2		.750		8	10	8						

BOLTS & SPIRAL TAPS

Bolt/Tap Size	Electrode Size
#6	.079
#8	.110
#10	.140
1/4"	.177
5/16"	.236
3/8"	.290
1/2"	.393
9/16"	.406
5/8"	.500
3/4"	.590

BOLTS & SPIRAL TAPS (mm)

Bolt/Tap Size	Electrode Size
m4	.098
m5	.140
m6	.170
m8	.236
m10	.312
m12	.375
m16	.512
m19	.590
m22	.625
m24	.750

PIPE TAPS

Tap Size	Electrode
1/16	.110
1/8	.312
1/4	.393
3/8	.551
1/2	.625
3/4	.875

For ordering collets, use the same diameter size as the electrode up to .312" (8 mm). Larger electrodes are shanked to fit the .312" (8 mm) collet.

* Single Asterisk indicates a two flute tap.

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