

Bolt Eater Metal Disintegrator Selector Chart

ELECTRODE SHAPE	ELECTRODE SIZE			COOLANT PRESSURE	CUTTING POWER	VIBRATION AMPLITUDE	CUTTING AMPERAGE	RECOMMENDED ELECTRODE MATERIAL
	MM	Inches	Dec.					
ANY UNDER:	12.7	1/2	.500	50#	1 - 3	6-1/2	30 - 150	GRAPHITE
ROUND SQUARE	12.7 9.525	1/2 3/8"	.500 .375	50#	2 - 4	6-1/2	100 - 150	MOLYBDENUM
ROUND SQUARE	19.05 15.875	3/4 5/8"	.750 .625	40#	3 - 4	6-1/2	150 - 200	GRAPHITE MOLYBDENUM
ROUND SQUARE	25.4 19.05	1 3/4	1.0 .750	30#	5 - 9	7 - 8	200 - 300	GRAPHITE
ROUND SQUARE	31.75 25.4	1-1/4 1	1.25 1.0	15 - 25#	6- 11	7 - 8	250 - 350	GRAPHITE
ROUND SQUARE	38.1 31.75	1-1/2 1-1/4	1.5 1.25	15 - 25#	7- 11	7 - 8	250 - 350	GRAPHITE
ROUND SQUARE	50.8 44.45	2" 1-3/4"	2.0 1.75	15 - 20#	8- 11	7 - 8	250 - 350	GRAPHITE

OPERATING RECOMMENDATIONS

1. Start all cuts at 1/2 cutting power and low amperage, then increase as electrode becomes seated in the cut (10 - 45 seconds).
2. Do not try to cut until coolant is flowing.
3. CUTTING POWER DOES NOT COME ON UNLESS BOTH COOLANT AND VIBRATION SWITCHES ARE ON.
4. Higher cutting power gives more overcut, rougher finish, faster cutting and more electrode wear.
5. Lower cutting power gives smaller overcut, finer finish, slower cutting and less electrode wear.
6. Large electrodes or deeper cut may require an increase in Vibration Amplitude.
7. Alloys with carbide, chrome or molybdenum such as B-7 or B-16 bolts or stellite, are slower cutting.
8. Warm or hot coolant slows cutting.

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