

# 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 - 50	GRAPHITE
ROUND	12.7	1/2	.500	50#	2 - 4	6-1/2	100 - 150	MOLYBDENUM
SQUARE	9.525	3/8"	.375					
ROUND	19.05	3/4	.750	40#	3 - 4	6-1/2	150 - 200	GRAPHITE MOLYBDENUM
SQUARE	15.875	5/8"	.625					
ROUND	25.4	1	1.0	30#	5 - 9	7 - 8	200 - 300	GRAPHITE
SQUARE	19.05	3/4	.750					
ROUND	31.75	1-1/4	1.25	15 - 25#	6- 11	7 - 8	250 - 350	GRAPHITE
SQUARE	25.4	1	1.0					
ROUND	38.1	1-1/2	1.5	15 - 25#	7- 11	7 - 8	250 - 350	GRAPHITE
SQUARE	25.4	1-1/4	1.25					
ROUND	50.8	2"	2.0	15 - 20#	8- 11	7 - 8	250 - 350	GRAPHITE
SQUARE	44.45	1-3/4"	1.75					

## 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 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. Heavy electrodes or deeper cut may require an increase in Vibration level.
7. Alloys with carbide, chrome or molybdenum such as B-7 or B-16 bolts or stellite, are slower cutting.
8. When making heavy or long cuts, note that warm or hot coolant slows cutting.

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