

DC Disintegrator Metal Disintegrator Selector Chart

Inch Tap Size	Metric Tap Size	Electrode Inch Size	Heat Selection (Cutting Power)	Vibration Setting	Amps (on meter)	Inch Drill Size	Metric Drill Size	Electrode Inch Size
0-80		.020**	1	4-6	5			
0-90	1.6	.030**	1	4-6	5			
1	1.8	.035**	1	4-6	5	.040	1	.035
2	2	.040	1	4-6	5	.050-.060	1.5	.040
	2	.050	1	6	5	.060-.070	2	.050
4	2.5	.060	1	6	5	.080-.090	2.5	.060
6	3	.075	2	6	10			
	3	.079	2	6	10	.090-.100	3	.075
8	4	.090	3	6	15	.100-.115	4	.090
	4	.098	3	6	15			
10&12	5	.110	4	6	20	.115-.130		.090
	5	.118	4	6	20			
1/4	6	.125	5	6	30	.130-.150	5	.110
1/4*	7	.140	5	6	30			
5/16	8	.156	6	6	35	.150-.175		.140
5/16*	8	.170	6	6	35			
	8	.177	6	6	35	.175-.200	6	.156
3/8	10	.187	7	6	40	.200-.225	7	.170
3/8*	10	.200	7	6	40			
7/16	12	.218	7	6	40	.225-.250	8	.187
	12	.236	7	6	40	.250-.300	9	.200-.218
1/2	14	.250	8	6	45	.300-.375	10	.250
	14	.276	8	6	45			
9/16	16	.290	8	6	45			
5/8	18	.312	9	6	50			
11/16	18	.342	9	6	50	.375-.450	11	.290
	19	.354	9	6	50	.450-.500	12	.312
3/4	22	.375	9	6	50			
	22	.393	10	6	50			
	22	.433	10	6	55	.500-.600	14	.375
7/8	25	.437	11	6	55			
	25	.472	11	6	55			
1	32	.500	11	6	55	.600-.750		.375
	32	.512		6				
		.551		6		.750-1.0	18	.437
		.590		6				
1 1/4	38	.625		6				
1 1/2		.750		6				

BOLTS & SPIRAL TAPS

Bolt or Tap Size	Electrode for Bolt	Electrode for Tap
#6	.079	.075
#8	.098	.079
#10	.110	.110
1/4"	.187	.156
5/16"	.237	.187
3/8"	.290	.218
1/2"	.375	.342
9/16"	.437	.375
5/8"	.500	.437
3/4"	.625	.500

BOLTS & SPIRAL TAPS (mm)

Bolt or Tap Size	Electrode for Bolt	Electrode for Tap
m4	.110	.098
m5	.140	.118
m6	.170	.140
m8	.187	.156
m10	.200	.200
m12	.290	.218
m16	.375	.342
m19	.437	.375
m22	.500	.437
m25	.625	.500

PIPE TAPS

Tap Size	(Straight) Electrode	(Tapered) Electrode
1/16	.125	.125
1/8	.175	.170
1/4	.218	.230
3/8	.290	.312
1/2	.375	.375
3/4	.465	.500

HELI-TAP

Size mm	Electrode
6	.140
8	.170
10	.230

For ordering collets, use the same diameter size as the electrode up to .312".

For electrodes larger than .312", electrodes are shanked for the .312" collet.

* Single Asterisk indicates a two flute tap.

**For electrode diameters from .020 to .035 manual Feed is recommended.

USA
Phone: (734) 761-5400
Fax: (734) 761-5426
www.electroarc.com
sales@electroarc.com



UK
Phone +44 (0)1384 263426
Fax: +44 (0)1384 79017
www.electroarc.com
sales@electroarc.co.uk