

# AC Metal Disintegrator Selector Chart

Inch Tap Size	Metric Tap Size	Electrode Inch Size	Cutting Power Setting (Heat Selection)				Inch Drill Size	Metric Drill Size	Electrode Inch Size
			3kva	10kva	15kva	20kva			
0-80		.020	1	1	1	1			
0-90	1.6	.030	1	1	1	1			
1	1.8	.035	1	1	1	1	.040	1	.030
2	2	.040	2	1-2	2	2	.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		.060
6	3	.075	2	2	3	2			
	3	.079	2	2	3	2	.090-.100	2.5	.075
8	4	.090	3	2	3	2	.100-.115		.090
	4	.098	3	2-3	3	2			
10&12	5	.110	3	2-3	3	3	.115-.130	3	.090
	5	.118	3	3	3	3			
1/4	6	.125	4	3	4	3	.130-.150		.110
1/4*	7	.140	4	3	4	3			
5/16	8	.156	4	4	4-5	4	.150-.175	4	.140
5/16*	8	.170	4	4	4-5	4			
	8	.177	5	4	5	4	.175-.200	5	.156
3/8	10	.187	5	4	5	4	.200-.225	5.5	.170
3/8*	10	.200	5	4-5	5	4			
7/16	12	.218		5	5	5	.225-.250	6	.187
	12	.236		5	5	5	.250-.300	7	.200-.218
1/2	14	.250		5	5-6	5	.300-.375	8/9	.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	.375-.450	10/11	.290
	19	.354		6	7	6	.450-.500	12	.312
3/4	22	.375		6-7	8	7			
	22	.393		6-7	8	7			
	22	.433		7	8	7	.500-.600	14	.375
7/8	25	.437		7	8-9	7			
	25	.472		7	8-9	7			
1	32	.500		7	9	7	.600-.750	18	.375
	32	.512		8	9	7-8			
		.551		8	9-10	7-8	.750-1.0		.437
		.590		8	9-10	8			
1 1/4	38	.625		8	10	8			
1 1/2		.750		8	10	8			

## 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.

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