

DC Metal Disintegrator Selector Chart

Tooling Size							Machine Settings		
Tap Size Inch	Tap Size Metric	Drill Size Inch	Drill Size Metric	Bolts & Spiral Tap	Pipe Tap	Electrode Size	Cutting Power	Vibration Setting	Amps on Meter ^C
0-80	—	—	—	—	—	0.020 ^A	1	4-6	5
—	M1.6	.040-.050	1	—	—	0.025 ^A			
—	M1.8	—	—	—	—	0.030 ^A			
No. 1	M2	—	—	—	—	0.035 ^A			
No. 2	M2.2	.050-.060	1.5	—	—	0.040 (1mm)			
No. 3	—	.060-.070	2	—	—	0.050			
No. 4	M2.5	.080-.090	2.5	—	—	0.060 (1.5mm)			
No. 5 & 6	M3	.090-.100	3	—	—	0.075			
—	M3.5	—	—	No. 6	—	0.079 (2mm)			
No. 8	M4	.100-.115	4	—	—	0.090			
—	M4.5	.115-.130	—	M4	—	0.098 (2.5mm)			
No. 10	M5	.130-.150	—	No. 8	1/16	0.110	2	10	
No. 12	M5	—	5	—	—	0.118 (3mm)	3	15	
1/4	M6	—	—	—	—	0.125	4	20	
1/4*	—	.150-.175	6	No. 10 & M5	—	0.140 (3.5mm)	5	30	
5/16	M8	.175-.200	—	—	—	0.156 (4mm)	6	35	
5/16*	M8	.200-.225	7	M6	—	0.170			
—	M8	—	—	1/4	—	0.177 (4.5mm)	7	40	
3/8	M10	.225-.250	8	—	—	0.187			
3/8*	M10	—	—	—	—	0.200 (5mm)			
7/16	M12	.250-.300	9	—	—	0.218 (5.5mm)			
—	M12	—	10	5/16 & M8	—	0.236 (6mm)	8	45	
1/2	M14	.300-.375	—	—	—	0.250			
—	M14	—	11	—	—	0.276 (7mm)	9	50	
9/16	M16	.375-.450	12	3/8	—	0.290			
5/8	M18	.450-.500	13	M10	1/8	0.312 (8mm)			
11/16	M18	—	14	—	—	0.342 ^B	10	55	
—	M20	—	15	—	—	0.354 (9mm) ^B			
3/4	M20	.500-.600	15	M12	—	0.375 ^B	11	55	
—	M20	—	16	1/2	1/4	0.393 (10mm) ^B			
—	—	.600-.700	17	9/16	—	0.406 ^B			
—	M22	.700-.750	18	—	—	0.433 (11mm) ^B			
7/8	—	.750-.850	19	—	—	0.437 ^B			
—	M24	—	20	—	—	0.472 (12mm) ^B			
1	—	.850-1.000	21-25	5/8	—	0.500 ^B			
1 1/8	M27	—	—	M16	—	0.512 (13mm) ^B			
—	M30	—	—	—	3/8	0.551 (14mm) ^B			
—	M33	—	—	3/4 & M19	—	0.562 ^B			
1 1/4	M36	—	—	M22	1/2	0.625 ^B			
1 3/8	—	—	—	M24	—	0.750 ^B			
1 1/2	M39	—	—	—	—	0.750 ^B			
—	—	—	—	—	3/4	0.875 ^B			

Notes:

* Denotes two flute taps

** Very Slow Cutting, Not Recommended for Extensive Use

^A Uses Pin Vise P/N A1515 mounted in P/NA1504-312 Collet

^B Electrodes come with .312"x2" Shank, Use P/N A1504-312 Collet

^C Adjust Servo Feed to get and Average Amp Reading, A Burn with Smooth Head Feed with Little "Pecking" is Best

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