

# AC Metal Disintegrator Selector Chart

| ELECTRODES FOR TAPS |                 |                     | MACHINE SETTINGS                       |       |       |       |              | ELECTRODES FOR DRILLS     |                 |                   |                     |
|---------------------|-----------------|---------------------|--|-------|-------|-------|--------------|---------------------------|-----------------|-------------------|---------------------|
| Tap Size Inch       | Tap Size Metric | Electrode Size Inch | Cutting Power Setting (Heat Selection) |       |       |       | Power Stroke | Auto Feed Speed Low Range | Drill Size Inch | Drill Size Metric | Electrode Size Inch |
|                     |                 |                     | 3kva                                   | 10kva | 15kva | 20kva |              |                           |                 |                   |                     |
| 0-80                |                 | .020                | 1                                      | 1     | 1     | 1     | 50           | .1                        | .032            |                   |                     |
| 0-90                | 1.6             | .030                | 1                                      | 1     | 1     | 1     |              |                           | .036            |                   |                     |
| 1                   |                 | .035                | 1                                      | 1     | 1     | 1     |              |                           | .040            | 1                 | .035                |
| 2                   | 2               | .040                | 2                                      | 1-2   | 2     | 2     | 75-100       | .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                 | 2.5             | .060              |                     |
| 6                   | 3               | .075                | 2                                      | 2     | 3     | 2     |              |                           |                 |                   |                     |
|                     | 3               | .079                | 2                                      | 2     | 3     | 2     |              | .090-.100                 | 3               | .075              |                     |
| 8                   | 4               | .090                | 3                                      | 2     | 3     | 2     |              | .100-.115                 | 4               | .090              |                     |
|                     | 4               | .098                | 3                                      | 2-3   | 3     | 2     |              |                           |                 |                   |                     |
| 10&12               | 5               | .110                | 3                                      | 2-3   | 3     | 3     |              | .115-.130                 |                 | .090              |                     |
|                     | 5               | .118                | 3                                      | 3     | 3     | 3     |              |                           |                 |                   |                     |
| 1/4                 | 6               | .125                | 4                                      | 3     | 4     | 3     |              | .130-.150                 | 5               | .110              |                     |
| 1/4*                |                 | .140                | 4                                      | 3     | 4     | 3     |              |                           |                 |                   |                     |
| 5/16                | 8               | .156                | 4                                      | 4     | 4-5   | 4     | 100          | .150-.175                 |                 | .140              |                     |
| 5/16*               | 8               | .170                | 4                                      | 4     | 4-5   | 4     |              | .175-.200                 | 6               | .156              |                     |
|                     | 8               | .177                | 5                                      | 4     | 5     | 4     |              | .200-.225                 | -               | .170              |                     |
| 3/8                 | 10              | .187                | 5                                      | 4     | 5     | 4     |              | .225-.250                 | 8               | .187              |                     |
| 3/8*                | 10              | .200                | 5                                      | 4-5   | 5     | 4     |              | .250-.300                 | 9               | .200-.218         |                     |
| 7/16                | 12              | .218                |  | 5     | 5     | 5     |              | .300-.375                 | 10              | .250              |                     |
|                     | 12              | .236                |  | 5     | 5     | 5     |              |                           |                 |                   |                     |
| 1/2                 | 14              | .250                |  | 5     | 5-6   | 5     |              |                           |                 |                   |                     |
|                     | 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     | .3           | .375-.450                 | 11              | .290              |                     |
|                     | 20              | .354                |  | 6     | 7     | 6     |              | .450-.500                 | 12              | .312              |                     |
| 3/4                 | 20              | .375                |  | 6-7   | 8     | 7     | .25          |                           |                 |                   |                     |
|                     | 20              | .393                |  | 6-7   | 8     | 7     |              | .500-.600                 | 14              | .375              |                     |
|                     | 22              | .433                |  | 7     | 8     | 7     |              |                           |                 |                   |                     |
| 7/8                 |                 | .437                |  | 7     | 8-9   | 7     |              |                           |                 |                   |                     |
|                     | 24              | .472                |  | 7     | 8-9   | 7     |              | .600-.750                 |                 | .375              |                     |
| 1                   |                 | .500                |  | 7     | 9     | 7     |              |                           |                 |                   |                     |
|                     |                 | .512                |  | 8     | 9     | 7-8   |              |                           |                 |                   |                     |
|                     |                 | .551                |  | 8     | 9-10  | 7-8   |              | .750-1.0                  | 18              | .437              |                     |
|                     |                 | .590                |  | 8     | 9-10  | 8     |              |                           |                 |                   |                     |
| 1 1/4               |                 | .625                |  | 8     | 10    | 8     |              |                           |                 |                   |                     |
| 1 1/2               |                 | .750                |  | 8     | 10    | 8     |              |                           |                 |                   |                     |

## BOLTS & SPIRAL TAPS

| Bolt/Tap Size | Electrode Size |
|---------------|----------------|
| #6            | .079           |
| #8            | .110           |
| #10           | .140           |
| 1/4"          | .177           |
| 5/16"         | .236           |
| 3/8"          | .290           |
| 1/2"          | .393           |
| 9/16"         | .406           |
| 5/8"          | .500           |
| 3/4"          | .590           |

## BOLTS & SPIRAL TAPS (mm)

| Bolt/Tap Size | Electrode Size |
|---------------|----------------|
| m4            | .098           |
| m5            | .140           |
| m6            | .170           |
| m8            | .236           |
| m10           | .312           |
| m12           | .375           |
| m16           | .512           |
| m19           | .590           |
| m22           | .625           |
| m24           | .750           |

## PIPE TAPS

| Tap Size | Electrode |
|----------|-----------|
| 1/16     | .110      |
| 1/8      | .312      |
| 1/4      | .393      |
| 3/8      | .551      |
| 1/2      | .625      |
| 3/4      | .875      |

For ordering collets, use the same diameter size as the electrode up to .312" (8 mm).  
Larger electrodes are shanked to fit the .312" (8 mm) collet.

\* Single Asterisk indicates a two flute tap.

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