

DC 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		.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*		.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		.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
	20	.354	9	6	50	.450-.500	12	.312
3/4	20	.375	9	6	50			
	20	.393	10	6	50			
	22	.433	10	6	55	.500-.600	14	.375
7/8		.437	11	6	55			
	24	.472	11	6	55			
1		.500	11	6	55	.600-.750		.375
		.512	11	6	55			
		.551	11	6	55	.750-1.0	18	.437
		.590	11	6	55			
1 1/4		.625	11	6	55			
1 1/2		.750	11	6	55			

BOLTS & SPIRAL TAPS

Bolt/Tap Size	Electrode
#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
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.

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

For larger sizes please contact us.

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