

ANOTRONIC		50/75A		Electrode		Copper		Workpiece		Steel		Polarity		9	
Current SW	Amps	Micro Spark HV1	On Time		Off Time		Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2xG1		2xG2		
			SW	µs	SW	µs					mm	ins	mm	ins	
	0.35	100	1	10	1	12	50	15	1	<0.1	0.006	0.0002	0.007	0.0003	
	0.55	150	1	10	1	12	80	16	1	<0.1	0.007	0.0003	0.008	0.0003	
	0.7	200	1	10	1	12	140	17	1	<0.1	0.008	0.0003	0.009	0.0004	
	0.9	260	1	10	1	12	180	18	1	<0.1	0.009	0.0004	0.010	0.0004	
!/12	1.2	200	1	10	4	240	50	19	2.9	0.1	0.010	0.0004	0.011	0.0004	
	1.2	200	2	16	4	240	50	20	2.7	0.1	0.010	0.0004	0.012	0.0005	
	1.2	200	3	26	4	240	50	21	2.5	0.2	0.010	0.0004	0.013	0.0005	
	1.2	200	4	40	4	240	50	22	2.2	0.2	0.015	0.0006	0.019	0.0007	
	1.2	200	5	66	5	350	50	23	1.8	0.3	0.020	0.0008	0.025	0.0010	
	1.2	200	6	100	5	350	50	24	1.4	0.3	0.030	0.0012	0.035	0.0014	
	1.2	200	7	160	5	350	50	25	1	0.4	0.040	0.0016	0.046	0.0018	
!/8	2	200	1	10	3	140	50	20	3.6	0.2	0.028	0.0011	0.036	0.0014	
	2	200	2	16	3	140	50	21	3.3	0.2	0.029	0.0011	0.038	0.0015	
	2	200	3	26	3	140	50	22	3	0.3	0.034	0.0013	0.044	0.0017	
	2	200	4	40	3	140	50	24	2.6	0.3	0.040	0.0016	0.053	0.0021	
	2	200	5	66	4	240	50	26	2.2	0.4	0.044	0.0017	0.058	0.0023	
	2	200	6	100	4	240	50	28	1.6	0.4	0.047	0.0019	0.062	0.0024	
	2	200	7	160	4	240	50	30	1	0.5	0.050	0.0020	0.065	0.0026	
!/4	3	200	1	10	2	50	40	27	14	0.3	0.044	0.0017	0.069	0.0027	
	3	200	2	16	2	50	40	28	12	0.3	0.047	0.0019	0.072	0.0028	
	3	200	3	26	2	50	40	29	10	0.4	0.050	0.0020	0.080	0.0031	
	3	200	4	40	2	50	40	30	7	0.4	0.055	0.0022	0.085	0.0033	
	3	200	5	66	3	140	40	31	5	0.5	0.060	0.0024	0.090	0.0035	
	3	200	6	100	3	140	40	32	4	0.4	0.065	0.0026	0.096	0.0038	
	3	200	7	160	3	140	40	33	3	0.4	0.070	0.0028	0.103	0.0041	
	3	200	8	240	3	140	40	34	1	0.3	0.075	0.0030	0.110	0.0043	

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging.

The OFF TIME should be adjusted longer to eliminate instability.

Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.

ANOTRONIC		50/75A		Electrode		Copper		Workpiece		Steel		Polarity		9	
Current SW	Amps	Micro Spark HV1	On Time		Off Time		Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2xG1		2xG2		
			SW	µs	SW	µs					mm	ins	mm	ins	
!2	6	200	1	10	1	12	30	28	18	2.5	0.050	0.0020	0.080	0.0031	
	6	200	2	16	1	12	30	29	16	2.8	0.053	0.0021	0.090	0.0035	
	6	200	3	26	1	12	30	30	14	3	0.055	0.0022	0.100	0.0039	
	6	200	4	40	1	12	30	31	12	3.2	0.060	0.0024	0.110	0.0043	
	6	200	5	66	1	12	30	32	10	3.4	0.065	0.0026	0.120	0.0047	
	6	200	6	100	2	50	30	33	7	3.6	0.070	0.0028	0.130	0.0051	
	6	200	7	160	2	50	30	34	4	3.8	0.080	0.0031	0.140	0.0055	
	6	200	8	240	2	50	30	35	3	4.1	0.090	0.0035	0.160	0.0063	
	6	200	9	340	2	50	30	36	1	4.2	0.100	0.0039	0.170	0.0067	
!4 + !2	9	200	1	10	1	12	30	29	20	3.1	0.051	0.0020	0.080	0.0031	
	9	200	2	16	1	12	30	30	18	3.7	0.055	0.0022	0.090	0.0035	
	9	200	3	26	1	12	30	31	16	5	0.060	0.0024	0.100	0.0039	
	9	200	4	40	1	12	30	32	13	5.7	0.065	0.0026	0.110	0.0043	
	9	200	5	66	1	12	30	33	13	7.3	0.070	0.0028	0.120	0.0047	
	9	200	6	100	2	50	30	34	10	8.1	0.080	0.0031	0.130	0.0051	
	9	200	7	160	2	50	30	35	7	10	0.090	0.0035	0.150	0.0059	
	9	200	8	240	2	50	30	36	5	12	0.100	0.0039	0.170	0.0067	
	9	200	9	340	2	50	30	37	3	13	0.110	0.0043	0.180	0.0071	
1	12	200	1	10	2	50	30	30	23	6	0.070	0.0028	0.120	0.0047	
	12	200	2	16	2	50	30	31	19	7	0.075	0.0030	0.130	0.0051	
	12	200	3	26	2	50	30	32	17	8	0.080	0.0031	0.140	0.0055	
	12	200	4	40	2	50	30	33	14	9	0.085	0.0033	0.150	0.0059	
	12	200	5	66	2	50	30	34	11	10	0.090	0.0035	0.160	0.0063	
	12	200	6	100	2	50	30	34	8	11	0.096	0.0038	0.170	0.0067	
	12	200	7	160	3	140	30	35	6	12	0.103	0.0041	0.180	0.0071	
	12	200	8	240	3	140	30	36	4	13	0.110	0.0043	0.190	0.0075	
	12	200	9	340	3	140	30	37	1.5	14	0.120	0.0047	0.210	0.0083	
	12	200	10	540	3	140	30	38	0.8	15	0.140	0.0055	0.230	0.0091	

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging.

The OFF TIME should be adjusted longer to eliminate instability.

Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.

ANOTRONIC		50/75A		Electrode Copper		Workpiece Steel		Polarity 9							
Current SW	Amps	Micro Spark HV1	On Time SW	μs	Off Time SW	μs	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2xG1		2xG2		
											mm	ins	mm	ins	
1	21	200	2	16	2	50	30	32	23	20	0.100	0.0039	0.150	0.0059	
	+	21	200	3	26	2	50	30	33	19	25	0.110	0.0043	0.160	0.0063
	!2	21	200	4	40	2	50	30	34	16	30	0.120	0.0047	0.170	0.0067
	+	21	200	5	66	2	50	30	34	13	34	0.130	0.0051	0.180	0.0071
	!4	21	200	6	100	2	50	30	35	10	37	0.140	0.0055	0.200	0.0079
		21	200	7	160	2	50	30	36	7	42	0.150	0.0059	0.220	0.0087
		21	200	8	240	3	140	30	36	5	48	0.160	0.0063	0.240	0.0094
		21	200	9	340	3	140	30	37	3	57	0.170	0.0067	0.260	0.0102
		21	200	10	540	3	140	30	38	1	65	0.180	0.0071	0.280	0.0110
		21	200	11	850	3	140	30	39	0.5	59	0.200	0.0079	0.320	0.0126
1½	24	200	3	26	2	50	30	33	25	27	0.120	0.0047	0.180	0.0071	
		24	200	4	40	2	50	30	34	22	30	0.120	0.0047	0.190	0.0075
		24	200	5	66	2	50	30	35	20	36	0.130	0.0051	0.200	0.0079
		24	200	6	100	2	50	30	36	16	44	0.140	0.0055	0.220	0.0087
		24	200	7	160	2	50	30	37	12	52	0.150	0.0059	0.240	0.0094
		24	200	8	240	3	140	30	37	8	60	0.160	0.0063	0.270	0.0106
		24	200	9	340	3	140	30	38	3	65	0.180	0.0071	0.300	0.0118
		24	200	10	540	3	140	30	39	1	67	0.200	0.0079	0.360	0.0142
		24	200	11	850	3	140	30	40	0.8	62	0.220	0.0087	0.400	0.0157

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging. The OFF TIME should be adjusted longer to eliminate instability. Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.

ANOTRONIC		50/75A		Electrode Copper		Workpiece Steel		Polarity 9						
Current SW	Amps	Micro Spark HV1	On Time SW	µs	Off Time SW	µs	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2xG1		2xG2	
											mm	ins	mm	ins
1½ + 1	36	200	3	26	2	50	30	34	27	29	0.130	0.0051	0.190	0.0075
	36	200	4	40	2	50	30	35	22	33	0.130	0.0051	0.200	0.0079
	36	200	5	66	2	50	30	35	18	41	0.140	0.0055	0.210	0.0083
	36	200	6	100	2	50	30	36	15	52	0.150	0.0059	0.230	0.0091
	36	200	7	160	2	50	30	37	10	76	0.160	0.0063	0.260	0.0102
	36	200	8	240	3	140	30	38	7	88	0.170	0.0067	0.290	0.0114
	36	200	9	340	3	140	30	39	4	99	0.190	0.0075	0.310	0.0122
	36	200	10	540	3	140	30	40	1	105	0.210	0.0083	0.330	0.0130
	36	200	11	850	3	140	30	41	0.8	98	0.230	0.0091	0.380	0.0150
	36	200	12	1300	3	140	30	42	0.6	92	0.250	0.0098	0.410	0.0161
1½+ 1+½ + ¼ + !8	47	200	4	40	3	140	30	35	37	69	0.150	0.0059	0.220	0.0087
	47	200	5	66	3	140	30	36	32	73	0.160	0.0063	0.240	0.0094
	47	200	6	100	3	140	30	37	27	80	0.170	0.0067	0.260	0.0102
	47	200	7	160	3	140	30	38	21	90	0.180	0.0071	0.280	0.0110
	47	200	8	240	3	140	30	39	15	130	0.190	0.0075	0.300	0.0118
	47	200	9	340	4	240	30	40	9	160	0.200	0.0079	0.320	0.0126
	47	200	10	540	4	240	30	41	3	190	0.220	0.0087	0.360	0.0142
	47	200	11	850	4	240	30	42	1	198	0.240	0.0094	0.400	0.0157
47	200	12	1300	4	240	30	43	0.8	200	0.280	0.0110	0.470	0.0185	
2+ 1½ +½ +!4 + !8 + !12	96.2	200	4	40	2	50	30	40	60	70	0.190	0.0075	0.290	0.0114
	96.2	200	5	66	2	50	30	41	50	100	0.210	0.0083	0.310	0.0122
	96.2	200	6	100	2	50	30	41	42	140	0.230	0.0091	0.340	0.0134
	96.2	200	7	160	2	50	30	42	34	190	0.250	0.0098	0.370	0.0146
	96.2	200	8	240	2	50	30	43	26	250	0.270	0.0106	0.400	0.0157
	96.2	200	9	340	3	140	30	43	18	300	0.290	0.0114	0.430	0.0169
	96.2	200	10	540	3	140	30	44	11	314	0.330	0.0130	0.510	0.0201
	96.2	200	11	850	3	140	30	45	7	312	0.400	0.0157	0.600	0.0236
96.2	200	12	1300	3	140	30	45	5	310	0.500	0.0197	0.780	0.0307	

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging.

The OFF TIME should be adjusted longer to eliminate instability.

Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.

ANOTRONIC		50/75A		Electrode Graphite		Workpiece Steel		Polarity 9						
Current SW	Amps	Micro Spark HV1	On Time SW	µs	Off Time SW	µs	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2xG1		2xG2	
											mm	ins	mm	ins
1/2	6	100	4	40	1	12	35	27	20	7.5	0.120	0.0047	0.140	0.0055
	6	100	5	66	1	12	35	28	10	6.3	0.130	0.0051	0.160	0.0063
	6	100	6	100	1	12	35	29	6	5.3	0.150	0.0059	0.180	0.0071
	6	100	7	160	1	12	35	30	4	4.5	0.160	0.0063	0.200	0.0079
	6	100	8	240	1	12	35	31	1	4.5	0.170	0.0067	0.210	0.0083
	6	100	5	66	1	12	35	32	6	11.5	0.070	0.0028	0.120	0.0047
1	12	100	6	100	1	12	35	33	4	15.5	0.090	0.0035	0.150	0.0059
	12	100	7	160	1	12	35	34	3	14	0.110	0.0043	0.170	0.0067
	12	100	8	240	1	12	35	35	1	12.5	0.130	0.0051	0.190	0.0075
	12	100	9	340	1	12	35	36	0.5	11.5	0.150	0.0059	0.230	0.0091
	12	100	10	540	1	12	35	37	0.3	10	0.170	0.0067	0.300	0.0118
1 +	18	100	5	66	1	12	35	30	3	19.5	0.150	0.0059	0.190	0.0075
	18	100	6	100	2	50	35	31	2.5	22.5	0.170	0.0067	0.220	0.0087
	1/2	18	100	7	160	2	50	35	2	31.3	0.190	0.0075	0.240	0.0094
	18	100	8	240	2	50	35	33	1	29	0.210	0.0083	0.290	0.0114
	18	100	9	340	2	50	35	34	0.5	27	0.230	0.0091	0.320	0.0126
	18	100	10	540	2	50	35	35	0.3	25	0.250	0.0098	0.350	0.0138
1 1/2	24	100	5	66	2	50	35	32	10	30	0.130	0.0051	0.215	0.0085
	24	100	6	100	2	50	35	33	8	33.5	0.150	0.0059	0.230	0.0091
	24	100	7	160	2	50	35	34	5.5	38	0.170	0.0067	0.260	0.0102
	24	100	8	240	2	50	35	35	3	61	0.190	0.0075	0.290	0.0114
	24	100	9	340	2	50	35	36	1	66	0.210	0.0083	0.320	0.0126
	24	100	10	540	2	50	35	37	0.8	46.5	0.230	0.0091	0.350	0.0138

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging. The OFF TIME should be adjusted longer to eliminate instability. Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.

ANOTRONIC		50/75A		Electrode Graphite		Workpiece Steel		Polarity 9						
Current SW	Amps	Micro Spark HV1	On Time SW	µs	Off Time SW	µs	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2xG1		2xG2	
											mm	ins	mm	ins
1½	42	100	7	160	2	50	35	37	15	31	0.210	0.0083	0.300	0.0118
	42	100	8	240	2	50	35	38	10	45	0.230	0.0091	0.320	0.0126
1	42	100	9	340	2	50	35	39	7	62.5	0.250	0.0098	0.370	0.0146
	42	100	10	540	2	50	35	40	3	83	0.270	0.0106	0.400	0.0157
½	42	100	11	850	2	50	35	41	1	95	0.290	0.0114	0.450	0.0177
	42	100	12	1300	2	50	35	42	0.5	105	0.310	0.0122	0.460	0.0181
1½	45	100	7	160	2	50	35	42	1.5	107	0.270	0.0106	0.390	0.0154
	45	100	8	240	2	50	35	43	1	120	0.290	0.0114	0.430	0.0169
+1	45	100	9	340	2	50	35	44	0.8	112.5	0.300	0.0118	0.450	0.0177
+½	45	100	10	540	2	50	35	45	0.5	100	0.310	0.0122	0.470	0.0185
+¼	45	100	11	850	2	50	35	46	0.5	90	0.330	0.0130	0.500	0.0197
	45	100	12	1300	2	50	35	47	0.4	78	0.340	0.0134	0.520	0.0205
2+	95	100	7	160	3	140	35	43	20	138.8	0.290	0.0114	0.430	0.0169
1½+	95	100	8	240	3	140	35	44	15	163.5	0.330	0.0130	0.500	0.0197
1+½	95	100	9	340	3	140	35	45	5	172.5	0.400	0.0157	0.600	0.0236
+¼	95	100	10	540	3	140	35	46	4	187.5	0.430	0.0169	0.650	0.0256
+	95	100	11	850	3	140	35	48	3	202.5	0.500	0.0197	0.800	0.0315
!8	95	100	12	1300	3	140	35	50	2	185	0.550	0.0217	0.900	0.0354

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging. The OFF TIME should be adjusted longer to eliminate instability. Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.

ANOTRONIC		50/75A		Electrode Graphite		Workpiece Steel		Polarity -						
Current SW	Amps	Micro Spark HV1	On Time SW	µs	Off Time SW	µs	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2xG1		2xG2	
											mm	ins	mm	ins
1/4	3	100	1	10	1	12	35	25	50	10.1	0.070	0.0028	0.120	0.0047
	3	100	2	16	1	12	35	26	26	8.85	0.090	0.0035	0.130	0.0051
	3	100	3	26	1	12	35	27	15	6.25	0.100	0.0039	0.140	0.0055
	3	100	4	40	1	12	35	28	10	5.35	0.120	0.0047	0.170	0.0067
1/2	6	100	4	40	1	12	35	29	30	14	0.130	0.0051	0.170	0.0067
	6	100	5	66	1	12	35	30	26	15.63	0.140	0.0055	0.190	0.0075
	6	100	6	100	1	12	35	31	23.5	16.5	0.160	0.0063	0.210	0.0083
	6	100	7	160	1	12	35	32	21	17.85	0.175	0.0069	0.230	0.0091
	6	100	8	240	1	12	35	33	18	19	0.190	0.0075	0.250	0.0098
1	12	100	4	40	1	12	35	33	28	23.5	0.100	0.0039	0.160	0.0063
	12	100	5	66	1	12	35	33	26	31	0.120	0.0047	0.180	0.0071
	12	100	6	100	1	12	35	34	22	41.5	0.140	0.0055	0.220	0.0087
	12	100	7	160	1	12	35	35	18	52	0.160	0.0063	0.260	0.0102
	12	100	8	240	1	12	35	36	15.5	61	0.180	0.0071	0.300	0.0118
	12	100	9	340	1	12	35	37	12	62.5	0.200	0.0079	0.330	0.0130
1	18	100	5	66	1	12	35	35	35	50	0.220	0.0087	0.280	0.0110
	18	100	6	100	1	12	35	36	30	55	0.240	0.0094	0.330	0.0130
1/2	18	100	7	160	1	12	35	37	15	62.5	0.260	0.0102	0.360	0.0142
	18	100	8	240	1	12	35	38	13	78	0.280	0.0110	0.400	0.0157
	18	100	9	340	1	12	35	39	12	104	0.300	0.0118	0.440	0.0173
	18	100	10	540	1	12	35	40	12	93.5	0.320	0.0126	0.460	0.0181

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging. The OFF TIME should be adjusted longer to eliminate instability. Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.

ANOTRONIC		50/75A		Electrode Graphite		Workpiece Steel		Polarity -						
Current SW	Amps	Micro Spark HV1	On Time SW	µs	Off Time SW	µs	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2xG1		2xG2	
											mm	ins	mm	ins
1½	24	100	5	66	1	12	35	39	35	75	0.160	0.0063	0.220	0.0087
	24	100	6	100	1	12	35	40	30	97	0.180	0.0071	0.300	0.0118
	24	100	7	160	1	12	35	41	27	109	0.200	0.0079	0.320	0.0126
	24	100	8	240	1	12	35	42	20	122.5	0.230	0.0091	0.480	0.0189
	24	100	9	340	1	12	35	43	17	140.5	0.250	0.0098	0.510	0.0201
	24	100	10	540	1	12	35	44	15	125	0.270	0.0106	0.530	0.0209
	24	100	11	850	1	12	35	45	10	117.5	0.290	0.0114	0.560	0.0220
1½	42	100	7	160	2	50	35	42	22	112.5	0.290	0.0114		
	+	42	100	8	240	2	50	35	44	18	160.5	0.350	0.0138	
1	42	100	9	340	2	50	35	46	16	168.5	0.400	0.0157		
	+	42	100	10	540	2	50	35	48	14	157.5	0.460	0.0181	
½	42	100	11	850	2	50	35	49	12	112.5	0.480	0.0189		
	42	100	12	1300	2	50	35	50	10	97.5	0.560	0.0220		
1½	45	100	7	160	2	50	35	44	25	168.7	0.320	0.0126		
	+1	45	100	8	240	2	50	35	46	22	200	0.380	0.0150	
+½	45	100	9	340	2	50	35	48	19	207.5	0.440	0.0173		
	+¼	45	100	10	540	2	50	35	50	14	200	0.480	0.0189	
+¼	45	100	11	850	2	50	35	51	13	168.7	0.510	0.0201		
	45	100	12	1300	2	50	35	53	10	150	0.550	0.0217		

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging. The OFF TIME should be adjusted longer to eliminate instability. Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.



ANOTRONIC		50/75A		Electrode		Graphite		Workpiece		Tungsten Carbide		Polarity		+	
Current SW	Amps	Micro Spark HV1	On Time		Off Time		Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2xG1		Tungsten Carbide Spark		
			SW	µs	SW	µs					mm	ins			
!/12	1.2	100	1	10	4	240	50	16	6	1	0.150	0.0059	S1		
	1.2	100	2	16	4	240	50	17	5	3	0.020	0.0008	S1		
!/8	2	100	1	10	4	240	50	18	7	5	0.030	0.0012	S1		
	2	100	2	16	4	240	50	19	6	6	0.035	0.0014	S1		
!/4	3	100	1	10	4	240	50	20	8	8	0.060	0.0024	S1		
	3	100	2	16	4	240	50	21	7	8.8	0.070	0.0028	S1		
!/8+	5	100	1	10	4	240	50	23	10	8.7	0.080	0.0031	S1		
!/4	5	100	2	16	4	240	50	24	8.5	9.5	0.090	0.0035	S1		
!/2	6	100	1	10	4	240	50	26	12	10	0.100	0.0039	S2		
	6	100	2	16	4	240	50	27	10	10.9	0.120	0.0047	S2		
!/4+	9	100	1	10	4	240	50	31	14	12.5	0.140	0.0055	S2		
!/2	9	100	2	16	4	240	50	32	11	13	0.150	0.0059	S2		
1	12	100	2	16	4	240	50	34	15	14.9	0.170	0.0067	S2		
	12	100	4	40	4	240	50	35	13	15.7	0.180	0.0071	S2		
1+	18	100	2	16	4	240	50	37	16	17.8	0.190	0.0075	S2		
1/2	18	100	4	40	4	240	50	38	14	18.3	0.200	0.0079	S2		
1 1/2	24	100	2	16	4	240	50	40	18	20	0.210	0.0083	S2		
	24	100	4	40	4	240	50	41	15	20.93	0.220	0.0087	S2		
1 1/2+	45	100	2	16	4	240	50	44	20	30	0.240	0.0094	S3		
1+1/2	45	100	4	40	4	240	50	45	20	35	0.250	0.0098	S3		
+1/4															

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging. The OFF TIME should be adjusted longer to eliminate instability. Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.

ANOTRONIC		50/75A		Electrode Copper		Workpiece Copper		Polarity -						
Current SW	Amps	Micro Spark HV1	On Time SW	µs	Off Time SW	µs	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2xG1		2xG2	
											mm	ins	mm	ins
!1/2	1.2	100	2	16	1	10	80	18	30	<1	0.030	0.0012		
!8	2	100	2	16	1	10	80	19	30	<1	0.040	0.0016		
!4	3	100	2	16	1	10	80	21	28	<1	0.050	0.0020		
!2	6	100	2	16	1	10	80	24	27	1.5	0.075	0.0030		
¼+½	9	100	2	16	1	10	80	27	27	2	0.090	0.0035		
1	12	100	2	16	1	10	80	28	23	3	0.110	0.0043		
1+½	18	100	2	16	1	10	80	32	23	5	0.140	0.0055		
1½	24	100	2	16	1	10	80	34	22	15	0.200	0.0079		
1½+	42	100	2	16	1	10	80	37	22	20	0.230	0.0091		
1+½	45	100	2	16	1	10	80	39	23	45	0.240	0.0094		
+¼														

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.

2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging.

The OFF TIME should be adjusted longer to eliminate instability.

Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.

ANOTRONIC		50/75A		Electrode	Steel	Workpiece	Steel	Polarity	-					
Current SW	Amps	Micro Spark HV1	On Time SW	µs	Off Time SW	µs	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2xG1		2xG2	
											mm	ins	mm	ins
1/4	3	260	1	10	1	10	80	23	42	1	0.090	0.0035	0.110	0.0043
1/2	6	260	1	10	1	10	80	29	40	2	0.140	0.0055	0.170	0.0067
	6	260	4	40	1	10	80	30	35	3	0.160	0.0063	0.190	0.0075
1	12	260	1	10	1	10	80	28	25	10.9	0.120	0.0047	0.150	0.0059
	12	260	4	40	1	10	80	29	22	11.2	0.140	0.0055	0.180	0.0071
	12	260	7	160	1	10	80	30	20	13.6	0.160	0.0063	0.210	0.0083
	12	260	8	240	1	10	80	31	16	17.2	0.170	0.0067	0.230	0.0091
	12	260	9	340	1	10	80	32	10	19.6	0.190	0.0075	0.250	0.0098
	12	260	10	540	1	10	80	33	2	21	0.200	0.0079	0.280	0.0110
	12	260	11	850	1	10	80	34	1	15.5	0.220	0.0087	0.300	0.0118
1 1/2	24	260	5	66	1	10	80	37	30	43	0.180	0.0071	0.260	0.0102
	24	260	7	160	1	10	80	38	20	47	0.200	0.0079	0.290	0.0114
	24	260	8	240	1	10	80	39	15	50	0.220	0.0087	0.320	0.0126
	24	260	9	340	1	10	80	40	8	52	0.240	0.0094	0.390	0.0154
	24	260	10	540	1	10	80	41	3.8	57	0.260	0.0102	0.430	0.0169
	24	260	11	850	1	10	80	42	2	50	0.280	0.0110	0.470	0.0185
	24	260	12	1300	1	10	80	43	1	47	0.300	0.0118	0.500	0.0197
1 1/2	45	260	8	240	1	10	80	43	15	83.7	0.290	0.0114	0.490	0.0193
+1	45	260	9	340	1	10	80	44	11	85	0.310	0.0122	0.530	0.0209
+1/2	45	260	10	540	1	10	80	45	9	87	0.330	0.0130	0.550	0.0217
+1/4	45	260	11	850	1	10	80	46	3	90	0.350	0.0138	0.590	0.0232
	45	260	12	1300	1	10	80	47	1	82	0.380	0.0150	0.650	0.0256

2\*G1 is the total gap measured both sides of the electrode measured to the peaks of the surface.  
2\*G2 is the total gap measured both sides of the electrode measured to the pits of the surface.

OFF TIME selections in this chart are based on electrode area / current combination under testing standard. Any changes of this combination may cause unstable discharging. The OFF TIME should be adjusted longer to eliminate instability. Adjusting the GAP VOLTAGE to 30 - 40V can increase working efficiency.