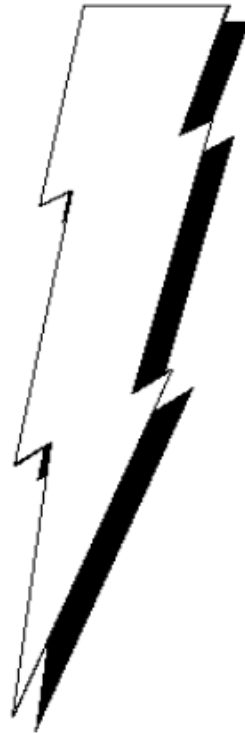
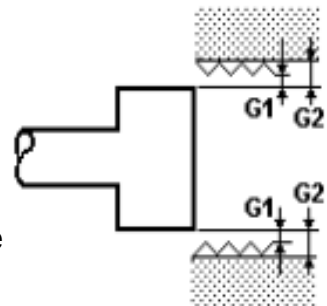


## Discharge Data



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.



**Note:**

ALL THE INFORMATION IN THIS BOOK IS ONLY A REFERENCE DATA FROM OUR OWN TESTS.

THIS BOOK SHOULD ONLY BE USED AS A GUIDE FOR STANDARD / CORRECT OPERATION OF THIS MACHINE.

WE STRONGLY SUGGEST THAT THE OPERATOR OF THIS MACHINE MUST TEST RUN A FEW SETTINGS TO FAMILIARIZE HIMSELF TO THE MACHINE.

THE OPERATOR CAN DEVELOP HIS OWN BEST CHOICE OF SETTINGS FOR EACH JOB FROM HIS OWN EXPERIENCE AND THEREFORE BETTER RESULTS CAN BE ACHIEVED.

ANOITRONIC		50A					Electrode Workpiece	Copper Steel	Polarity		+			
Current SW	Amps	Micro Spark HV1	On SW	Time µs	Off SW	Time µs	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2x G1		2x G2	
											mm	ins	mm	ins
0	0.55	1	1	10	1	20	80	16	1	<0.1	0.007	0.0003	0.008	0.0003
0	0.7	2	1	10	1	20	140	17	1	<0.1	0.008	0.0003	0.009	0.0004
0	0.9	3	1	10	1	20	180	18	1	<0.1	0.009	0.0004	0.010	0.0004
1	1.2	2	1	10	4	250	50	19	2.9	0.18	0.010	0.0004	0.011	0.0004
1	1.2	2	2	15	4	250	50	20	2.8	0.2	0.010	0.0004	0.012	0.0005
1	1.2	2	3	25	4	250	50	21	2.7	0.25	0.010	0.0004	0.013	0.0005
1	1.2	2	4	40	4	250	50	22	2.5	0.28	0.015	0.0006	0.019	0.0007
1	1.2	2	5	60	5	350	50	23	2	0.35	0.020	0.0008	0.025	0.0010
1	1.2	2	6	100	5	350	50	24	1.8	0.38	0.030	0.0012	0.035	0.0014
1	1.2	2	7	150	5	350	50	25	1.5	0.44	0.040	0.0016	0.046	0.0018
2	2	2	1	10	3	150	50	20	3.6	0.25	0.028	0.0011	0.036	0.0014
2	2	2	2	15	3	150	50	21	3.3	0.3	0.029	0.0011	0.038	0.0015
2	2	2	3	25	3	150	50	22	3	0.4	0.034	0.0013	0.044	0.0017
2	2	2	4	40	3	150	50	24	2.6	0.5	0.040	0.0016	0.053	0.0021
2	2	2	5	60	4	250	50	26	2.2	0.65	0.044	0.0017	0.058	0.0023
2	2	2	6	100	4	250	50	28	1.6	0.8	0.047	0.0018	0.062	0.0024
2	2	2	7	150	4	250	50	29	1	0.9	0.050	0.0020	0.065	0.0026
3	3	2	1	10	2	30	45	26	12	0.4	0.039	0.0015	0.064	0.0025
3	3	2	2	15	2	30	45	27	11	0.55	0.044	0.0017	0.069	0.0027
3	3	2	3	25	2	30	45	28	9	0.65	0.047	0.0018	0.072	0.0028
3	3	2	4	40	2	30	45	29	6	0.78	0.050	0.0020	0.080	0.0031
3	3	2	5	60	3	150	45	30	4	0.9	0.055	0.0022	0.085	0.0033
3	3	2	6	100	3	150	45	31	3	1.02	0.060	0.0024	0.090	0.0035
3	3	2	7	150	3	150	45	32	2	1.15	0.065	0.0026	0.096	0.0038
3	3	2	8	250	3	150	45	33	1	1.1	0.070	0.0028	0.103	0.0041

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		50A		Electrode		Copper		Workpiece		Steel		Polarity		+	
Current SW	Amps	Micro Spark HV1	On SW	Time $\mu$ s	Off SW	Time $\mu$ s	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2x G1		2x G2		
											mm	ins	mm	ins	
4	5	2	1	10	2	30	40	27	15	0.7	0.046	0.0018	0.072	0.0028	
4	5	2	2	15	2	30	40	28	13	0.94	0.050	0.0020	0.072	0.0028	
4	5	2	3	25	2	30	40	29	11	1.21	0.053	0.0021	0.080	0.0031	
4	5	2	4	40	2	30	40	30	8	1.6	0.059	0.0023	0.090	0.0035	
4	5	2	5	60	3	150	40	31	6	1.88	0.065	0.0026	0.097	0.0038	
4	5	2	6	100	3	150	40	32	4	2.25	0.071	0.0028	0.105	0.0041	
4	5	2	7	150	3	150	40	33	3	3	0.075	0.0030	0.112	0.0044	
4	5	2	8	250	3	150	40	34	1	2.8	0.082	0.0032	0.120	0.0047	
5	8	2	1	10	1	20	30	28	18	3.3	0.050	0.0020	0.080	0.0031	
5	8	2	2	15	1	20	30	29	16	4.5	0.053	0.0021	0.090	0.0035	
5	8	2	3	25	1	20	30	30	14	6.8	0.058	0.0023	0.100	0.0039	
5	8	2	4	40	1	20	30	31	12	8.5	0.063	0.0025	0.115	0.0045	
5	8	2	5	60	1	20	30	32	10	11	0.068	0.0027	0.120	0.0047	
5	8	2	6	100	2	30	30	33	7	16.5	0.074	0.0029	0.132	0.0052	
5	8	2	7	150	2	30	30	34	4	18.8	0.084	0.0033	0.140	0.0055	
5	8	2	8	250	2	30	30	35	3	21	0.095	0.0037	0.162	0.0064	
5	8	2	9	350	2	30	30	36	1	24.8	0.105	0.0041	0.175	0.0069	

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		50A		Electrode		Copper		Workpiece		Steel		Polarity		+	
Current		Micro	On	Time	Off	Time	Gap		Wear	Removal	2x G1		2x G2		
SW	Amps	Spark HV1	SW	µs	SW	µs	Volts	VDI	Rate %	Rate mm <sup>3</sup> /min	mm	ins	mm	ins	
6	12	2	1	10	2	30	30	30	23	6	0.070	0.0028	0.120	0.0047	
6	12	2	2	15	2	30	30	31	19	9	0.075	0.0030	0.130	0.0051	
6	12	2	3	25	2	30	30	32	17	12	0.085	0.0033	0.145	0.0057	
6	12	2	4	40	2	30	30	33	14	16	0.092	0.0036	0.155	0.0061	
6	12	2	5	60	2	30	30	34	11	19	0.096	0.0038	0.165	0.0065	
6	12	2	6	100	2	30	30	35	8	22	0.103	0.0041	0.180	0.0071	
6	12	2	7	150	3	150	30	35	6	25	0.108	0.0042	0.189	0.0074	
6	12	2	8	250	3	150	30	36	4	30	0.115	0.0045	0.199	0.0078	
6	12	2	9	350	3	150	30	37	1	36	0.125	0.0049	0.215	0.0085	
6	12	2	10	500	3	150	30	38	0.8	43	0.145	0.0057	0.235	0.0092	
7	17	2	2	15	2	30	30	31	23	15	0.090	0.0035	0.140	0.0055	
7	17	2	3	25	2	30	30	32	19	21	0.100	0.0039	0.155	0.0061	
7	17	2	4	40	2	30	30	33	17	26	0.110	0.0043	0.165	0.0065	
7	17	2	5	60	2	30	30	34	13	32	0.120	0.0047	0.170	0.0067	
7	17	2	6	100	2	30	30	35	10	38	0.130	0.0051	0.195	0.0077	
7	17	2	7	150	2	30	30	36	7	42	0.140	0.0055	0.210	0.0083	
7	17	2	8	250	3	150	30	37	5	52	0.155	0.0061	0.235	0.0092	
7	17	2	9	350	3	150	30	38	3	60	0.175	0.0069	0.275	0.0108	
7	17	2	10	500	3	150	30	39	1	72	0.190	0.0075	0.300	0.0118	
7	17	2	11	650	3	150	30	40	0.5	65	0.200	0.0079	0.305	0.0120	

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		50A		Electrode		Copper		Workpiece		Steel		Polarity		+	
Current SW	Amps	Micro Spark HV1	On SW	Time $\mu$ s	Off SW	Time $\mu$ s	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2x G1		2x G2		
											mm	ins	mm	ins	
8	23	2	2	15	2	30	30	32	22	18	0.100	0.0039	0.150	0.0059	
8	23	2	3	25	2	30	30	33	18	21	0.110	0.0043	0.160	0.0063	
8	23	2	4	40	2	30	30	34	15	30	0.120	0.0047	0.170	0.0067	
8	23	2	5	60	2	30	30	34	12	36	0.130	0.0051	0.180	0.0071	
8	23	2	6	100	2	30	30	35	10	44	0.140	0.0055	0.200	0.0079	
8	23	2	7	150	2	30	30	36	7	52	0.150	0.0059	0.220	0.0087	
8	23	2	8	250	3	150	30	36	5	59	0.160	0.0063	0.240	0.0094	
8	23	2	9	350	3	150	30	37	3	70	0.185	0.0073	0.285	0.0112	
8	23	2	10	500	3	150	30	38	1	82	0.210	0.0083	0.315	0.0124	
8	23	2	11	650	3	150	30	39	0.5	75	0.220	0.0087	0.345	0.0136	
9	36	2	3	25	2	30	30	33	25	31	0.105	0.0041	0.165	0.0065	
9	36	2	4	40	2	30	30	34	20	40	0.115	0.0045	0.175	0.0069	
9	36	2	5	60	2	30	30	35	17	54	0.125	0.0049	0.195	0.0077	
9	36	2	6	100	2	30	30	36	14	67	0.135	0.0053	0.215	0.0085	
9	36	2	7	150	2	30	30	37	10	79	0.145	0.0057	0.240	0.0094	
9	36	2	8	250	3	150	30	38	6	84	0.160	0.0063	0.270	0.0106	
9	36	2	9	350	3	150	30	39	4	88	0.180	0.0071	0.290	0.0114	
9	36	2	10	500	3	150	30	40	1	92	0.200	0.0079	0.310	0.0122	
9	36	2	11	650	3	150	30	40	1	84	0.220	0.0087	0.355	0.0140	
9	36	2	12	850	3	150	30	41	0.8	77	0.230	0.0091	0.380	0.0150	

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		50A		Electrode		Copper		Workpiece		Steel		Polarity		+	
Current SW	Amps	Micro Spark HV1	On SW	Time $\mu$ s	Off SW	Time $\mu$ s	Gap Volts	VDI	Wear Rate %	Removal Rate mm <sup>3</sup> /min	2x G1		2x G2		
											mm	ins	mm	ins	
10	48	2	3	25	2	30	30	34	26	45	0.120	0.0047	0.170	0.0067	
10	48	2	4	40	2	30	30	35	21	60	0.125	0.0049	0.185	0.0073	
10	48	2	5	60	2	30	30	35	18	80.5	0.135	0.0053	0.205	0.0081	
10	48	2	6	100	2	30	30	36	15	98	0.145	0.0057	0.225	0.0089	
10	48	2	7	150	2	30	30	37	10	110	0.155	0.0061	0.240	0.0094	
10	48	2	8	250	3	150	30	38	6	117	0.165	0.0065	0.270	0.0106	
10	48	2	9	350	3	150	30	39	5	122	0.185	0.0073	0.295	0.0116	
10	48	2	10	500	3	150	30	40	2	128	0.210	0.0083	0.320	0.0126	
10	48	2	11	650	3	150	30	41	1	120	0.220	0.0087	0.355	0.0140	
10	48	2	12	850	3	150	30	42	0.5	100	0.245	0.0096	0.390	0.0154	
11	54	2	3	25	2	30	30	35	30	61	0.130	0.0051	0.190	0.0075	
11	54	2	4	40	2	30	30	36	25	79	0.135	0.0053	0.200	0.0079	
11	54	2	5	60	2	30	30	36	21	93	0.140	0.0055	0.210	0.0083	
11	54	2	6	100	2	30	30	37	17	111	0.150	0.0059	0.230	0.0091	
11	54	2	7	150	2	30	30	38	11	120	0.160	0.0063	0.260	0.0102	
11	54	2	8	250	3	150	30	39	8	135	0.170	0.0067	0.290	0.0114	
11	54	2	9	350	3	150	30	40	4	149	0.190	0.0075	0.310	0.0122	
11	54	2	10	500	3	150	30	41	2	162	0.210	0.0083	0.330	0.0130	
11	54	2	11	650	3	150	30	42	1	150	0.230	0.0091	0.380	0.0150	
11	54	2	12	850	3	150	30	43	0.8	134	0.250	0.0098	0.410	0.0161	

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.

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