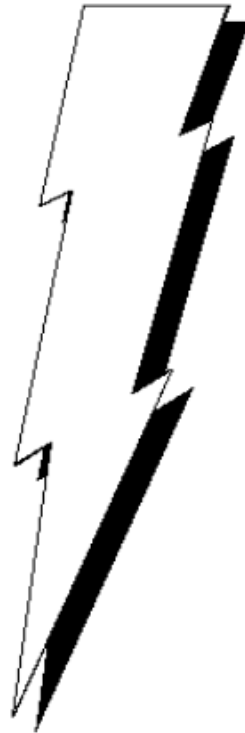
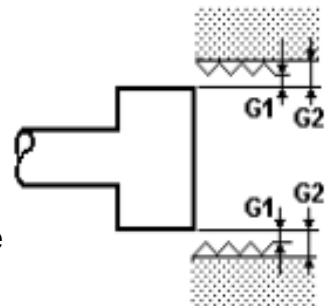


Discharge Data



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.

ANOIRONIC		75/100A		Electrode Workpiece				Copper Steel		Polarity +				
Current SW	Amps	Micro Spark HV1	On SW	Time μ s	Off SW	Time μ s	Gap Volts	VDI	Wear Rate %	Removal Rate mm ³ /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	4.2	2	1	10	2	30	40	27	14	0.52	0.044	0.0017	0.069	0.0027
3	4.2	2	2	15	2	30	40	28	12	0.75	0.047	0.0018	0.072	0.0028
3	4.2	2	3	25	2	30	40	29	10	0.84	0.050	0.0020	0.080	0.0031
3	4.2	2	4	40	2	30	40	30	7	1.01	0.055	0.0022	0.085	0.0033
3	4.2	2	5	60	3	150	40	31	5	1.2	0.060	0.0024	0.090	0.0035
3	4.2	2	6	100	3	150	40	32	4	1.35	0.065	0.0026	0.095	0.0037
3	4.2	2	7	150	3	150	40	33	3	1.6	0.070	0.0028	0.103	0.0041
3	4.2	2	8	250	3	150	40	34	1	1.5	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		75/100A		Electrode				Copper				Polarity +			
				Workpiece				Steel							
Current SW	Amps	Micro Spark HV1	On SW	Time μ s	Off SW	Time μ s	Gap Volts	VDI	Wear Rate %	Removal Rate mm ³ /min	2x G1		2x G2		
											mm	ins	mm	ins	
4	8	2	1	10	1	20	30	28	18	2.5	0.050	0.0020	0.080	0.0031	
4	8	2	2	15	1	20	30	29	16	2.8	0.053	0.0021	0.090	0.0035	
4	8	2	3	25	1	20	30	30	14	3.8	0.058	0.0023	0.100	0.0039	
4	8	2	4	40	1	20	30	31	12	4.6	0.063	0.0025	0.115	0.0045	
4	8	2	5	60	1	20	30	32	10	5.5	0.068	0.0027	0.120	0.0047	
4	8	2	6	100	2	30	30	33	7	6.8	0.074	0.0029	0.130	0.0051	
4	8	2	7	150	2	30	30	34	4	7.2	0.084	0.0033	0.140	0.0055	
4	8	2	8	250	2	30	30	35	3	7.8	0.095	0.0037	0.160	0.0063	
4	8	2	9	350	2	30	30	36	1	8	0.105	0.0041	0.175	0.0069	
5	12	2	1	10	2	30	30	30	23	6	0.070	0.0028	0.120	0.0047	
5	12	2	2	15	2	30	30	31	19	9	0.075	0.0030	0.130	0.0051	
5	12	2	3	25	2	30	30	32	17	12	0.085	0.0033	0.145	0.0057	
5	12	2	4	40	2	30	30	33	14	16	0.092	0.0036	0.155	0.0061	
5	12	2	5	60	2	30	30	34	11	19	0.096	0.0038	0.165	0.0065	
5	12	2	6	100	2	30	30	35	8	22	0.103	0.0041	0.180	0.0071	
5	12	2	7	150	3	150	30	36	6	25	0.108	0.0042	0.189	0.0074	
5	12	2	8	250	3	150	30	37	4	30	0.115	0.0045	0.199	0.0078	
5	12	2	9	350	3	150	30	38	1.5	36	0.125	0.0049	0.215	0.0085	
5	12	2	10	500	3	150	30	39	0.8	43	0.145	0.0057	0.235	0.0092	

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		75/100A		Electrode Workpiece				Copper Steel		Polarity +				
Current SW	Amps	Micro Spark HV1	On SW	Time μ s	Off SW	Time μ s	Gap Volts	VDI	Wear Rate %	Removal Rate mm ³ /min	2x G1		2x G2	
											mm	ins	mm	ins
6	20	2	2	15	2	30	30	31	23	15	0.090	0.0035	0.140	0.0055
6	20	2	3	25	2	30	30	32	19	21	0.100	0.0039	0.150	0.0059
6	20	2	4	40	2	30	30	33	17	26	0.110	0.0043	0.160	0.0063
6	20	2	5	60	2	30	30	34	13	32	0.120	0.0047	0.170	0.0067
6	20	2	6	100	2	30	30	35	10	38	0.130	0.0051	0.195	0.0077
6	20	2	7	150	2	30	30	36	7	42	0.140	0.0055	0.210	0.0083
6	20	2	8	250	3	150	30	37	5	52	0.155	0.0061	0.235	0.0092
6	20	2	9	350	3	150	30	38	3	30	0.175	0.0069	0.275	0.0108
6	20	2	10	500	3	150	30	39	1	72	0.190	0.0075	0.300	0.0118
6	20	2	11	650	3	150	30	40	0.05	65	0.200	0.0079		
7	26	2	2	15	2	30	30	32	23	20	0.100	0.0039	0.150	0.0059
7	26	2	3	25	2	30	30	33	19	25	0.110	0.0043	0.160	0.0063
7	26	2	4	40	2	30	30	34	17	39	0.120	0.0047	0.170	0.0067
7	26	2	5	60	2	30	30	34	13	48	0.130	0.0051	0.180	0.0071
7	26	2	6	100	2	30	30	35	10	57	0.140	0.0055	0.200	0.0079
7	26	2	7	150	2	30	30	36	7	70	0.150	0.0059	0.220	0.0087
7	26	2	8	250	3	150	30	36	5	82	0.160	0.0063	0.240	0.0094
7	26	2	9	350	3	150	30	37	3	88	0.185	0.0073	0.285	0.0112
7	26	2	10	500	3	150	30	38	1	98	0.210	0.0083	0.315	0.0124
7	26	2	11	650	3	150	30	39	0.5	90	0.240	0.0094	0.365	0.0144

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		75/100A		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 ³ /min	2x G1		2x G2	
											mm	ins	mm	ins
8	38	2	3	25	2	30	30	33	25	39	0.120	0.0047	0.170	0.0067
8	38	2	4	40	2	30	30	34	20	51	0.120	0.0047	0.180	0.0071
8	38	2	5	60	2	30	30	35	17	68	0.130	0.0051	0.200	0.0079
8	38	2	6	100	2	30	30	36	14	84	0.140	0.0055	0.220	0.0087
8	38	2	7	150	2	30	30	37	10	90	0.150	0.0059	0.240	0.0094
8	38	2	8	250	3	150	30	38	6	105	0.160	0.0063	0.270	0.0106
8	38	2	9	350	3	150	30	40	4	110	0.180	0.0071	0.290	0.0114
8	38	2	10	500	3	150	30	40	1	115	0.200	0.0079	0.310	0.0122
8	38	2	11	650	3	150	30	41	1	103	0.220	0.0087	0.360	0.0142
8	38	2	12	850	3	150	30	42	0.8	85	0.240	0.0094	0.390	0.0153
9	56	2	3	25	2	30	30	34	27	54	0.130	0.0051	0.190	0.0075
9	56	2	4	40	2	30	30	35	22	67	0.130	0.0051	0.200	0.0079
9	56	2	5	60	2	30	30	35	18	80	0.140	0.0055	0.210	0.0083
9	56	2	6	100	2	30	30	36	15	93	0.150	0.0059	0.230	0.0091
9	56	2	7	150	2	30	30	37	10	100	0.160	0.0063	0.260	0.0102
9	56	2	8	250	3	150	30	38	7	115	0.170	0.0067	0.290	0.0114
9	56	2	9	350	3	150	30	39	4	128	0.190	0.0075	0.310	0.0122
9	56	2	10	500	3	150	30	40	1	139	0.210	0.0083	0.330	0.0130
9	56	2	11	650	3	150	30	41	0.8	125	0.230	0.0091	0.380	0.0150
9	56	2	12	850	3	150	30	42	0.6	112	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.

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		75/100A		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 ³ /min	2x G1		2x G2	
											mm	ins	mm	ins
10	68	2	4	40	2	30	30	35	37	87	0.150	0.0059	0.220	0.0087
10	68	2	5	60	2	30	30	36	32	95	0.160	0.0063	0.240	0.0094
10	68	2	6	100	2	30	30	37	27	106	0.170	0.0067	0.260	0.0102
10	68	2	7	150	2	30	30	38	21	118	0.180	0.0071	0.280	0.0110
10	68	2	8	250	3	150	30	39	15	137	0.190	0.0075	0.300	0.0118
10	68	2	9	350	3	150	30	40	9	165	0.200	0.0079	0.320	0.0126
10	68	2	10	500	3	150	30	41	3	190	0.220	0.0087	0.360	0.0142
10	68	2	11	650	3	150	30	42	1	196	0.240	0.0094	0.400	0.0157
10	68	2	12	850	3	150	30	43	0.8	185	0.280	0.0110	0.470	0.0185
11	78.2	2	4	40	2	30	30	40	60	105	0.190	0.0075	0.290	0.0114
11	78.2	2	5	60	2	30	30	41	50	114	0.210	0.0083	0.310	0.0122
11	78.2	2	6	100	2	30	30	41	42	128	0.230	0.0091	0.340	0.0134
11	78.2	2	7	150	2	30	30	42	34	140	0.250	0.0098	0.370	0.0146
11	78.2	2	8	250	3	150	30	43	26	165	0.270	0.0106	0.400	0.0157
11	78.2	2	9	350	3	150	30	43	18	191	0.290	0.0114	0.430	0.0169
11	78.2	2	10	500	3	150	30	44	11	225	0.330	0.0130	0.510	0.0201
11	78.2	2	11	650	3	150	30	45	7	235	0.400	0.0157	0.600	0.0236
11	78.2	2	12	850	3	150	30	45	5	220	0.500	0.0197	0.780	0.0307
11	102.2	3	5	60	3	150	30	43	55	165	0.270	0.0106	0.420	0.0165
+	102.2	3	6	100	3	150	30	44	42	212	0.320	0.0126	0.480	0.0189
LV2	102.2	3	7	150	3	150	30	45	35	250	0.400	0.0157	0.580	0.0228
	102.2	3	8	250	3	150	30	46	28	275	0.520	0.0205	0.720	0.0283
	102.2	3	9	350	4	250	30	47	22	328	0.670	0.0264	0.930	0.0366
	102.2	3	10	500	4	250	30	48	18	395	0.780	0.0307	1.000	0.0394
	102.2	3	11	650	4	250	30	49	15	368	1.050	0.0413	1.300	0.0512
	102.2	3	12	850	4	250	30	51	10	350	1.300	0.0512	1.580	0.0622

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		75/100A		Electrode				Graphite				Workpiece				Steel		Polarity +	
Current SW	Amps	Micro Spark HV1	On SW	Time μ s	Off SW	Time μ s	Gap Volts	VDI	Wear Rate %	Removal Rate mm ³ /min	2x G1		2x G2						
											mm	ins	mm	ins					
3	4.2	0	4	40	1	20	35	28	15	1.8	0.080	0.0031	0.950	0.0374					
3	4.2	0	5	60	1	20	35	29	10	2	0.090	0.0035	0.100	0.0039					
3	4.2	0	6	100	1	20	35	30	6	2.5	0.100	0.0039	0.120	0.0047					
3	4.2	0	7	150	1	20	35	31	4	3	0.120	0.0047	0.140	0.0055					
3	4.2	0	8	250	1	20	35	32	2	2.8	0.140	0.0055	0.160	0.0063					
4	8	0	4	40	1	20	35	29	10	5	0.100	0.0039	0.120	0.0047					
4	8	0	5	60	1	20	35	30	6	6	0.110	0.0043	0.130	0.0051					
4	8	0	6	100	1	20	35	31	4	7	0.120	0.0047	0.140	0.0055					
4	8	0	7	150	1	20	35	32	3	8	0.130	0.0051	0.150	0.0059					
4	8	0	8	250	1	20	35	33	2	9.5	0.140	0.0055	0.160	0.0063					
5	12	0	5	60	1	20	35	30	6	19.5	0.150	0.0059	0.190	0.0075					
5	12	0	6	100	2	30	35	31	4	24	0.170	0.0067	0.210	0.0083					
5	12	0	7	150	2	30	35	32	3	33	0.190	0.0075	0.230	0.0091					
5	12	0	8	250	2	30	35	33	1	35	0.210	0.0083	0.260	0.0102					
5	12	0	9	350	2	30	35	34	1	38	0.230	0.0091	0.290	0.0114					
5	12	0	10	500	2	30	35	35	1	36	0.250	0.0098	0.330	0.0130					
6	20	0	5	60	2	30	35	32	10	30	0.130	0.0051	0.200	0.0079					
6	20	0	6	100	2	30	35	33	8	33.5	0.150	0.0059	0.230	0.0091					
6	20	0	7	150	2	30	35	34	6	38	0.170	0.0067	0.250	0.0098					
6	20	0	8	250	2	30	35	35	4	49	0.190	0.0075	0.280	0.0110					
6	20	0	9	350	2	30	35	36	2	55	0.210	0.0083	0.300	0.0118					
6	20	0	10	500	2	30	35	37	1	46.5	0.230	0.0091	0.330	0.0130					

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		75/100A		Electrode				Graphite				Workpiece				Steel		Polarity +	
Current SW	Amps	Micro Spark HV1	On SW	Time μ s	Off SW	Time μ s	Gap Volts	VDI	Wear Rate %	Removal Rate mm ³ /min	2x G1		2x G2						
											mm	ins	mm	ins					
7	26	0	7	150	2	30	35	37	15	31	0.210	0.0083	0.300	0.0118					
7	26	0	8	250	2	30	35	38	10	45	0.230	0.0091	0.320	0.0126					
7	26	0	9	350	2	30	35	39	7	62.5	0.250	0.0098	0.370	0.0146					
7	26	0	10	500	2	30	35	40	3	83	0.290	0.0114	0.400	0.0157					
7	26	0	11	650	2	30	35	41	1	95	0.300	0.0118	0.450	0.0177					
7	26	0	12	850	2	30	35	42	1	90	0.320	0.0126	0.470	0.0185					
8	38	0	7	150	2	30	35	42	3	107	0.270	0.0106	0.390	0.0153					
8	38	0	8	250	2	30	35	43	2	112.5	0.290	0.0114	0.430	0.0169					
8	38	0	9	350	2	30	35	44	1	120	0.310	0.0122	0.450	0.0177					
8	38	0	10	500	2	30	35	45	1	128	0.320	0.0126	0.470	0.0185					
8	38	0	11	650	2	30	35	46	1	122	0.330	0.0130	0.500	0.0197					
8	38	0	12	850	2	30	35	47	1	115	0.340	0.0134	0.520	0.0205					
10	68	0	7	150	3	150	35	43	20	138.8	0.290	0.0114	0.430	0.0169					
10	68	0	8	250	3	150	35	44	15	163.5	0.330	0.0130	0.500	0.0197					
10	68	0	9	350	3	150	35	45	5	172.5	0.400	0.0157	0.600	0.0236					
10	68	0	10	500	3	150	35	46	4	187.5	0.430	0.0169	0.650	0.0256					
10	68	0	11	650	3	150	35	48	3	202.5	0.500	0.0197	0.800	0.0315					
10	68	0	12	850	3	150	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		75/100A		Electrode				Steel				Workpiece				Steel		Polarity +	
Current SW	Amps	Micro Spark HV1	On SW	Time μ s	Off SW	Time μ s	Gap Volts	VDI	Wear Rate %	Removal Rate mm ³ /min	2x G1		2x G2						
											mm	ins	mm	ins					
3	4.2	3	1	10	1	20	80	25	42	1	0.090	0.0035	0.110	0.0043					
4	8	3	1	10	1	20	80	29	40	2	0.140	0.0055	0.170	0.0067					
4	8	3	4	40	1	20	80	31	35	3	0.160	0.0063	0.190	0.0075					
5	12	3	1	10	1	20	80	29	25	10.9	0.150	0.0059	0.190	0.0075					
5	12	3	4	40	1	20	80	30	22	11.2	0.170	0.0067	0.220	0.0087					
5	12	3	7	150	1	20	80	33	20	13.6	0.190	0.0075	0.240	0.0094					
5	12	3	8	250	1	20	80	34	16	17.2	0.210	0.0083	0.250	0.0098					
5	12	3	9	350	1	20	80	35	10	19.6	0.230	0.0091	0.280	0.0110					
5	12	3	10	500	1	20	80	36	3	21	0.250	0.0098	0.300	0.0118					
5	12	3	11	650	1	20	80	37	2	15.5	0.270	0.0106	0.310	0.0122					
6	20	3	5	60	1	20	80	38	30	43	0.190	0.0075	0.260	0.0102					
6	20	3	7	150	1	20	80	39	21	47	0.220	0.0087	0.290	0.0114					
6	20	3	8	250	1	20	80	40	17	50	0.240	0.0094	0.320	0.0126					
6	20	3	9	350	1	20	80	41	8	52	0.260	0.0102	0.390	0.0154					
6	20	3	10	500	1	20	80	42	5	57	0.280	0.0110	0.430	0.0169					
6	20	3	11	650	1	20	80	43	3	50	0.300	0.0118	0.470	0.0185					
6	20	3	12	850	1	20	80	43	2	47	0.320	0.0126	0.500	0.0197					
8	38	3	8	250	1	20	80	43	15	83.7	0.310	0.0122	0.490	0.0193					
8	38	3	9	350	1	20	80	44	11	85	0.330	0.0130	0.530	0.0209					
8	38	3	10	500	1	20	80	45	9	87	0.340	0.0134	0.550	0.0217					
8	38	3	11	650	1	20	80	46	5	90	0.360	0.0142	0.590	0.0232					
8	38	0	12	850	1	20	80	47	2	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.

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