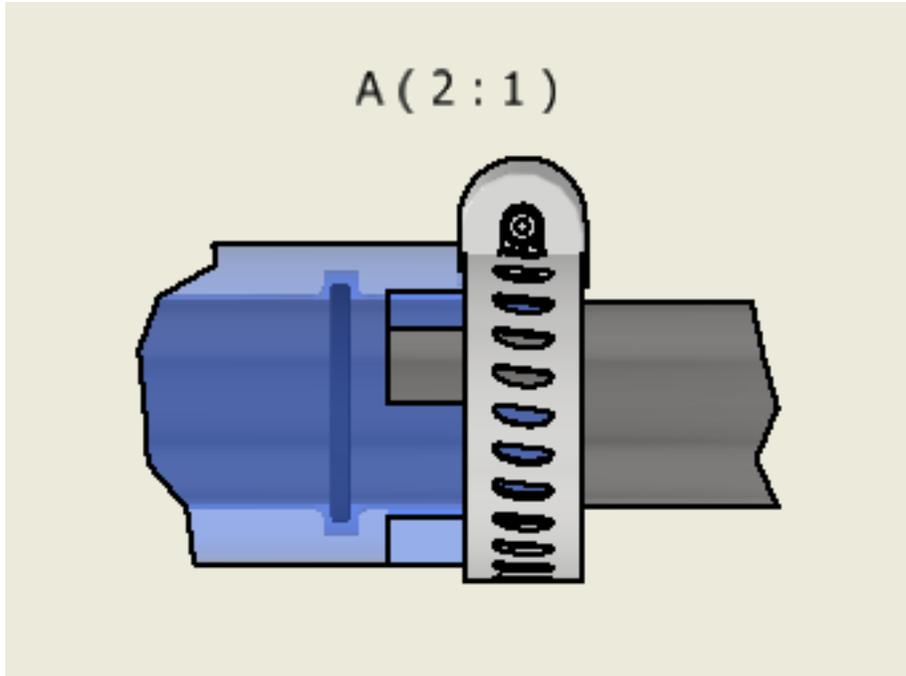


## General ECM Steps

1. Mix electrolyte solution in bucket
2. Secure fixture using clamps. Ensure clamps are flush with the outside of the fixture fingers.



Failure to secure clamps flush with the edges will result in the fingers snapping when tightened.

3. Secure clamps onto 10mm pipe on high pressure side on both ends
4. Place filter to the low pressure side of pump pipe, push to the bottom of the bucket
5. Erect and secure bucket handle to the fully upright position
6. Measure inside chamber diameter several times and record the largest accurate measurement
7. Secure ECM assembly to the bucket handle
8. Route exit hose into the bucket
9. Short circuit lab power supply leads
10. Slowly increase the amperage and voltage on the Lab power supply until amperage reaches 7.5A
11. Make electrical connections to barrel and boring rod/mandrill/chamber rod
12. Positive to barrel, negative to the tool
13. Set timer to 0
14. Turn on pump, ensure there are no leaks

15. Turn on lab power supply
16. Start timer
17. For first cut, cut for 1.5 minutes
18. Disassembly and take measurements
19. Using the new measurement calculate the estimated cut time and cut again
20. For example if current diameter is 5.42mm and it was 5.41 then to get to 5.51 would take 15 mins
21. Cut for half of that period
22. Repeat cutting steps until near the desired diameter
23. When close to the final bore diameter I recommend no more than 1 minute cuts.
24. Flush everything with fresh water
25. If you are performing other cuts this is the last step
26. Using an oil soaked rag, wipe down the outside of the barrel
27. Force an oil soaked rag through the inside to make sure it doesn't rust
28. Mark barrels with the date and specific information