



Machine Model	CD-17 Coiling bowls	Owners Manual
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## WARNING

NEVER REACH INTO THE COILING BOWL WHILE IT IS TURNING. INJURY MAY RESULT

### CD-17 Operator controls



The **dial 0-100** controls the winding rate of the bowls. The faster the wire is fed in the CS327 machine the higher this number needs to be.

The **Clutch pressure** controls how tightly the bowl is held to the rotating drive mechanism. You want to adjust this value so that the bowl is able to rotate and collect the wire, but at the same time if the wire stops feeding the bowl will stop also. In addition if an operator puts their hand in it while it is still rotating it will stop easily. If the bowl keeps rotating when the wire stops feeding, the wire in the bowl will be pulled out and twisted. It works best to start with a low value like 20PSI and increase it until you notice that the bowl properly coming up to speed for the wire to feed in. The item that affects this setting is the weight of the wire in the bowl. When you have a coil that is very heavy the clutch pressure should be reduced.

The **Brake pressure** controls how fast the bowl comes to a stop. If this value is set too high the bowl will stop and the wire in the bowl will keep spinning thus causing a tangle. The item that affects this setting is the weight of the wire in the bowl. When you have a coil that is very heavy the brake pressure will have to be increased.

## CD-17 Coiling bowls

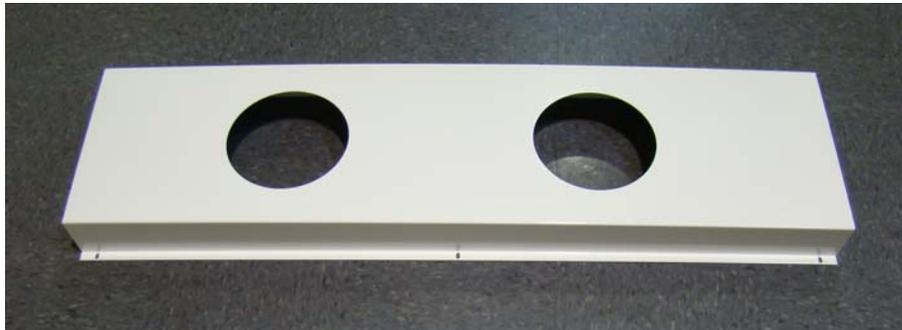
The following size coiling bowl sizes are available.

143689 18 inch bowl

143690 24 inch bowl

143691 30 inch bowl

**WARNING:** When using 143689 18 inch bowls, guard part number 146080 must be installed under the bowls. Injury can result if the belt is not covered with this guard.



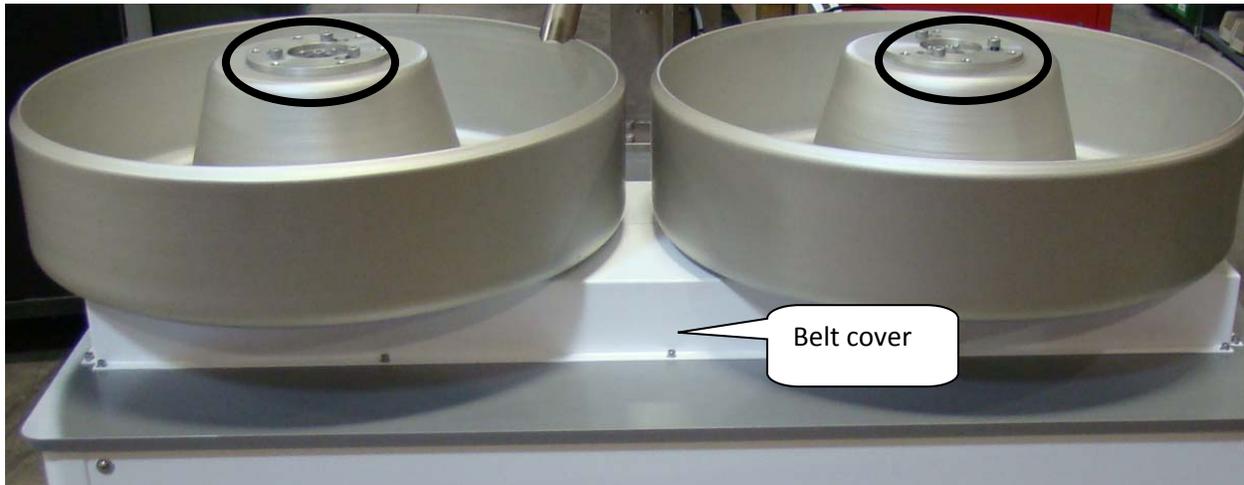
146080

**WARNING:** When using 143690 24 inch bowls or 143691 30 inch bowls, guard part number 146079 must be installed under the bowls. Injury can result if the belt is not covered with this guard.



146079

## Changing between coiling bowls.



1. Remove the 3 screws from the top of each of the bowls. Then lift the bowls off.
2. Remove the sheet metal belt cover.
3. Loosen the belt tensioner.
4. The bowl spindles can be mounted in 3 locations. There are 4 screws that hold each one in place. Move the spindle to the desired location.
  - a. The inside location (bowls closest together) is for the 18" bowls.
  - b. The middle location is for the 24" bowls.
  - c. The outside location (bowls furthest apart) is for the 30" bowls.
5. Tension the belt.
6. For the 18" bowl install sheet metal cover 146079. For the 24 or 30" bowl install sheet metal cover 146080.
7. Set the bowls in position and install the 3 screws in the top of each bowl.
8. Replace the guide tube if needed For the 18" bowl use 146081. For 24 and 30" bowl use 143763. 146081 is 5 inches longer than 143763.
9. Adjust the guide tube so that the tube properly aligns with the bowl.