



Machine Model	CD-11 Coiling bowls	Owners Manual
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Artos Engineering Company  
21605 Gateway Court  
Brookfield, WI 53045  
Phone 262-252-4545 Fax 262-252-4544  
[www.artosnet.com](http://www.artosnet.com)  
[service@artosnet.com](mailto:service@artosnet.com)

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## SPECIFICATIONS

### POWER

115±10% VAC 47-63 Hz. Single Phase 6 amps (Nominal)

or

230±10% VAC 47-63 Hz. Single Phase 3 amps (Nominal)

Connection to Supply: Detachable cord

Protection Against Electric Shock: Grounded metal enclosure

### DIMENSIONS

Bowl Height from floor 37.5" (953mm)

Assembly Height 35" (889mm)

Length 22.4" (570mm)

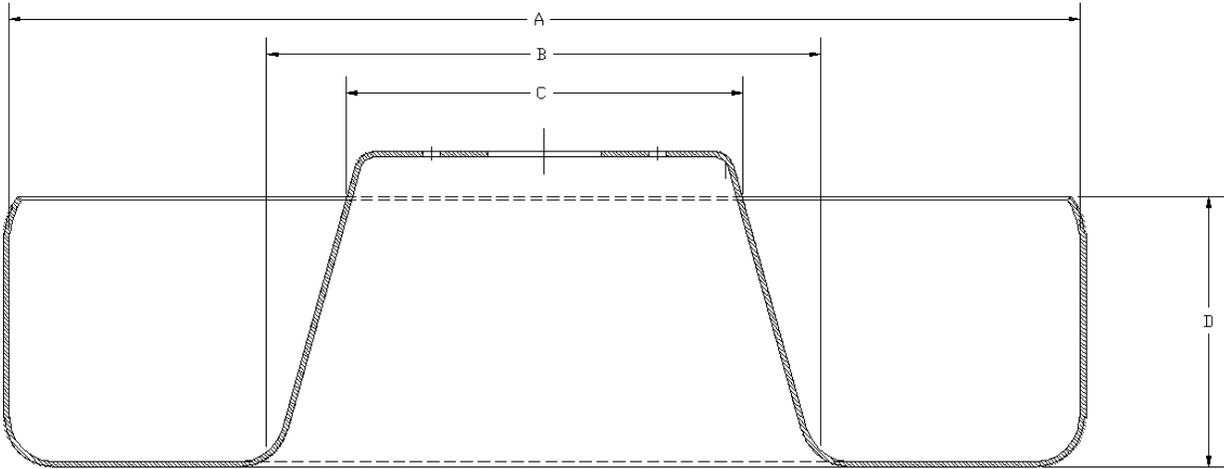
Depth 32.6" (828mm)

Weight 100 pounds (45kg)

### AIR REQUIREMENT

Average air requirement 2 cfm (56 L/m) 80 psi (5.5 bar)

# BOWL DIMENSIONS



**For bowl 81521-1 12 inch 305mm diameter**

- Outer dimension of coil
  - A=11.8 inches 300mm
- Inner dimension of coil
  - B=5.7 inches 145mm at bottom of bowl
  - C=5.2 inches 132mm at top of bowl
- Height of coil
  - D=2.9 inches 74mm at top of bowl

**For bowl 81521-2 16 inch 406mm diameter**

- Outer dimension of coil
  - A=15.8 inches 401mm
- Inner dimension of coil
  - B=9.7 inches 246mm at bottom of bowl
  - C=9.2 inches 234mm at top of bowl

Height of coil

D=2.9 inches 74mm at top of bowl

**For bowl 81521-3 16 inch 406mm diameter**

Outer dimension of coil

A=15.8 inches 401mm

Inner dimension of coil

B=5.7 inches 145mm at bottom of bowl

C=5.1 inches 130mm at top of bowl

Height of coil

D=3.8 inches 97mm at top of bowl

**Guide tube size**

The inside of the guide tube is 32mm. The maximum wire diameter is somewhat dependent on the how sticky the wire insulation is. In general the maximum size wire you could run is 30mm

## BOWL CAPACITY

The formulas below can be used to determine approximately what length of wire will fit in the bowl. These formulas were found by experimentation with different types of wire that tend to lay differently as they are coiled.

r = outside radius of wire

**For bowl 81521-1 12 inch 305mm diameter**

$2.4404/(r^2)$  = length of cable in bowl in inches

**For bowl 81521-2 16 inch 406mm diameter**

$3.8197/(r^2)$  = length of cable in bowl in inches

**For bowl 81521-3 16 inch 406mm diameter**

$7.0028/(r^2)$  = length of cable in bowl in inches

## CD-11 CONTROLS



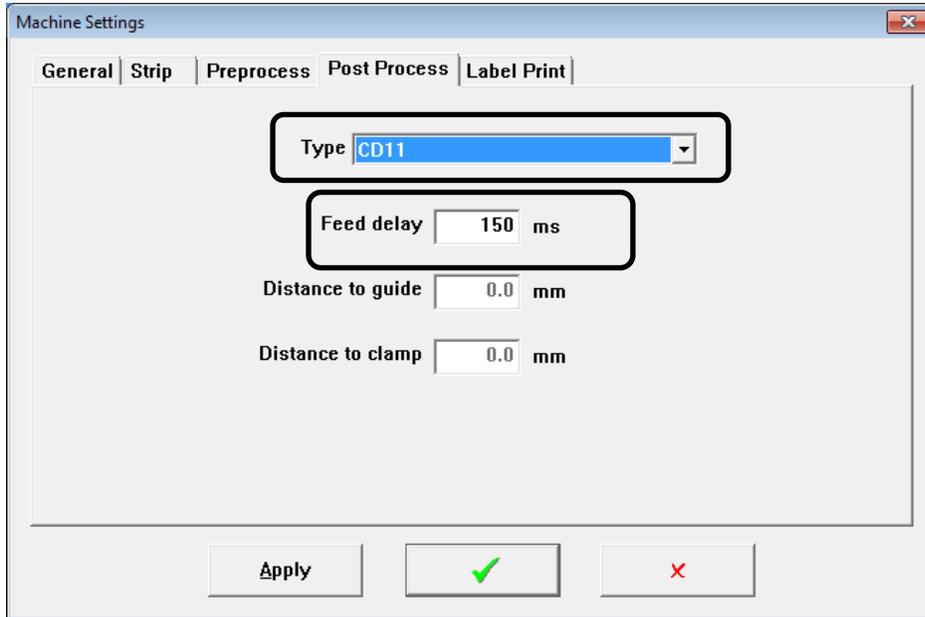
**Main Pressure** – This controls both the brake pressure and the main air on the manifold. You want to set this gauge low enough that the bowl does not slam to a stop causing the wire to spin and tangle up in the bowl. However if you set this gauge too low the shuttle will not be fast enough to switch between the bowls. If it is not fast enough you will get wire jams in the CS326.

**Clutch Pressure** – This controls how hard the bowls are pulling on the wire. There are times that the CS326 is holding the wire tight (like during the cut and strip) so the bowl needs to slip so the wire does not pull out of the bowl. You also want to be able to safely touch the bowl while it is spinning and it will stop easily. Keep in mind that as you increase the clutch pressure the brake pressure will slightly decrease, this decrease is not visible on the gauge.

**0-100 Dial** - This controls how fast the bowl is spinning. Ideally you want to set this so the bowls collect the wire at the same speed it is being fed through the machine. If it is too slow you will get a pile of wire in the bowl or jams in the CS326. If it is too fast the wire will be tightly coiled on the inner part of the bowl and may even slip over the top of the bowl.

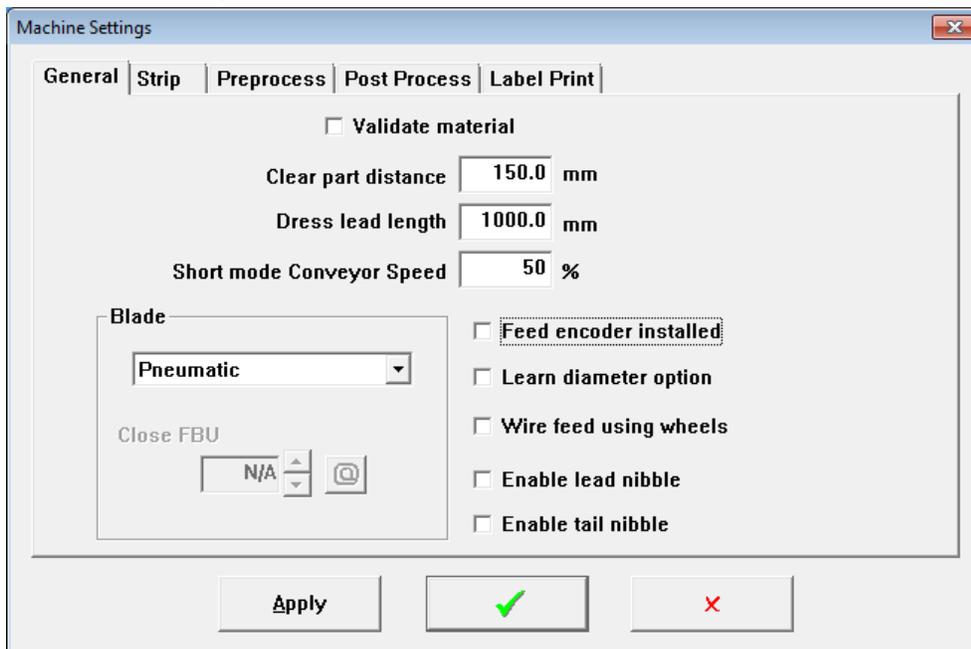
# CS326 Machine configuration

## In machine settings



- The CD-11 has to be selected.
- The feed delay will add time between cycles so that coiler can completely pull the wire from the tube. Also it will give more time for the operator to remove the coil between cycles.

## In machine settings



- The clear part distance has to be long enough for the wire to get out of the out feed belts.

- The dress feed length either must be short enough for the lead in scrap part to fall down in to the slug collection area. Or it has to be long enough to be coiled in the bowls. If you select a distance in between the scrap part will get jammed in the CD-11 tube.

### In the part properties screen

Part Property

Name: MDI [v] [New] [Remove]

Process | Label | Other

Preprocess

Preprocess: [ ]

Adjust pre-process to fit

Post Process

Post Process: CD11 [v]

Auto Outfeed

[Apply] [✓] [✗]

- Select CD11 as the Post Process.
- Check the box Auto Outfeed.