CS-326 Guide Selection

Standard Wire Machine
6-137614 Single Blade Cutterhead
6-137615 Pivoting 2 Blade Cutterhead
6-137977 3 Blade Cutterhead, removable tool holders

Large Wire Machine
6-140710 Large Wire Single Blade Machine
6-140716 Large Wire Pivoting Cutterhead Machine
6-148880 Large Wire 3 Blade Cutterhead, removable tool holders

Standard Wire with Wire Measuring Encoder
6-144505 CS-326 with wire coding option, Single Blade Cutterhead
6-144506 CS-326 with wire coding option, 2 Blade Cutterhead
6-144507 CS-326 with wire coding option, 3 Blade Cutterhead, removable tool holders

Special Machines
6-145888 Coaxial Cable Cutterhead, programmable strips
6-142198 4 Conductor with slitting
6-142462 Coaxial Cable 5 Blade with 6.35mm strip
6-145078 Coaxial Cable 5 Blade with 7mm strip
6-143824 Steel Cable SK Blades
5-143129 3-Wire Adaption Kit

Instructions for Using the Guide Drawings
Standard Wire Machine
Large Wire Machine
Standard Wire with Wire Measuring Encoder
Special Machines
<table>
<thead>
<tr>
<th>PART NO.</th>
<th>OUTER DIAMETER</th>
<th>OUTER JACKET CUT &amp; STRIP</th>
<th>CONDUCTOR STRIP</th>
<th>INSIDE GUIDE</th>
<th>OUTSIDE GUIDE</th>
<th>OFFSET</th>
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<td>.194 4.92mm</td>
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**NOTE**

1. ON BLADE 137685-XXX THE -XXX IS THE DIAMETER OF THE Braid IN INCHES.
2. ON BLADE 145781-XXX THE -XXX IS THE DIAMETER OF THE INNER CONDUCTOR IN INCHES.
3. THE OFFSET IS DESIGNED TO BE .010 LESS THAN THE MEASURED WIRE DISTANCE. THIS IS TO COMPENSATE FOR FLATTENING OF THE WIRE IN THE FEED BELTS.
Instructions for Using the Guide Drawings

You must use the wire guide sheet that is for your machine.  
The main difference between the guides for a single blade, 2 blade, or 3 blade machine is the length of the pivoting tube.  
Make sure to use the correct drawing or the machine will not perform properly.  
The difference between a standard wire machine and a large wire machine is the type of guide holders that are mounted on the machine.  
Use the information below to determine which type of guides will fit your machine.

**How to determine if your machine is a standard wire machine or large wire machine.**

**A standard wire machine** has guides with an inside diameter range of .08 - .53 (2mm – 13.4mm)

Standard wire guide holders.

4-136582-500 wire run out assembly  
136971 holder infeed  
136633 holder cutoff or 137979 holder cutoff w/air blowoff

The center hole in all three of these parts is 0.75 inches (19mm)

136547 is the aluminum part that holds the pivot tube
**A large wire machine** has guides with an inside diameter range of .08 - .69 (2mm – 17.5mm)

Large wire guide holders

4-136582-520 wire run out assembly  140703 holder infeed  140704 holder cutoff or 142265 holder cutoff w/air blowoff

The center hole in all three of these parts is 0.875 inches (22.2mm)

140701 is the aluminum part that holds the pivot tube, notice the groove is larger for the larger tube.

**How to convert your machine from standard wire to large wire.**

This can only be done on 1 or 2 blade machines.

To do the conversion you need to order and install the parts shown in the Large wire machine section above.

For the cutoff holder, if the machine does not have air blow off order 140704. If the machine has air blow off order 142265.

Once the machine is converted you will not be able to use any of your standard wire guides, they will all have to be replaced with large wire guides.