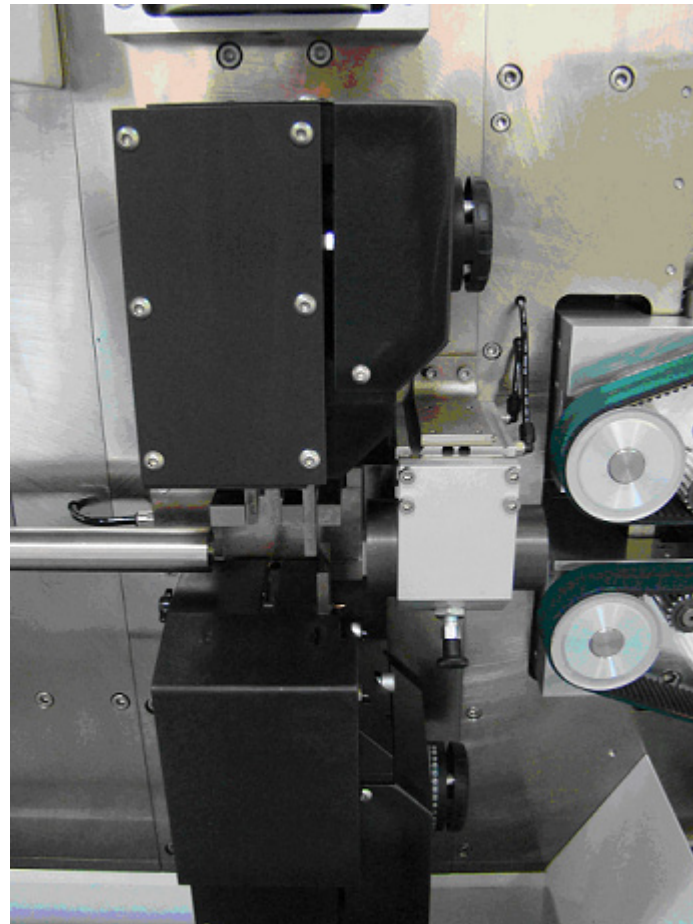


# Table of Contents

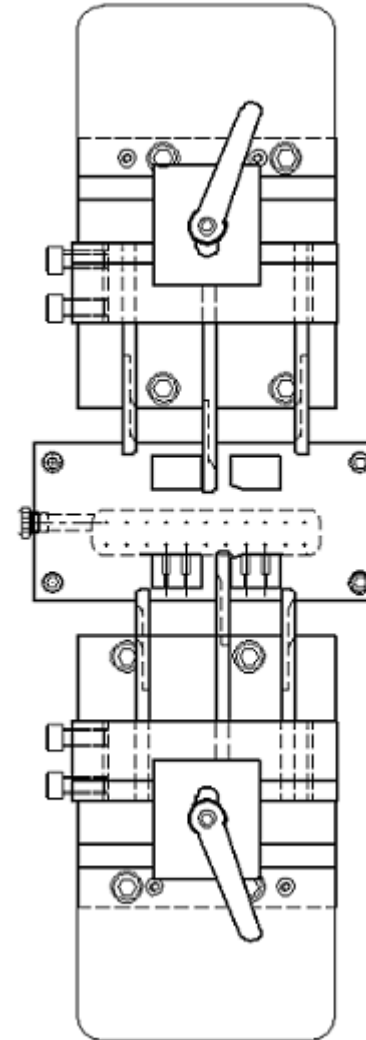
## CS327 Guide Selection

REV 3 01/17/2013

5-142406 Page 1 Guides for 2 blade cutterhead  
5-142406 Page 2 Modifications to use wire depth stops  
5-142406 Page 3 Guides for 3 blade cutterhead



Two blade machine

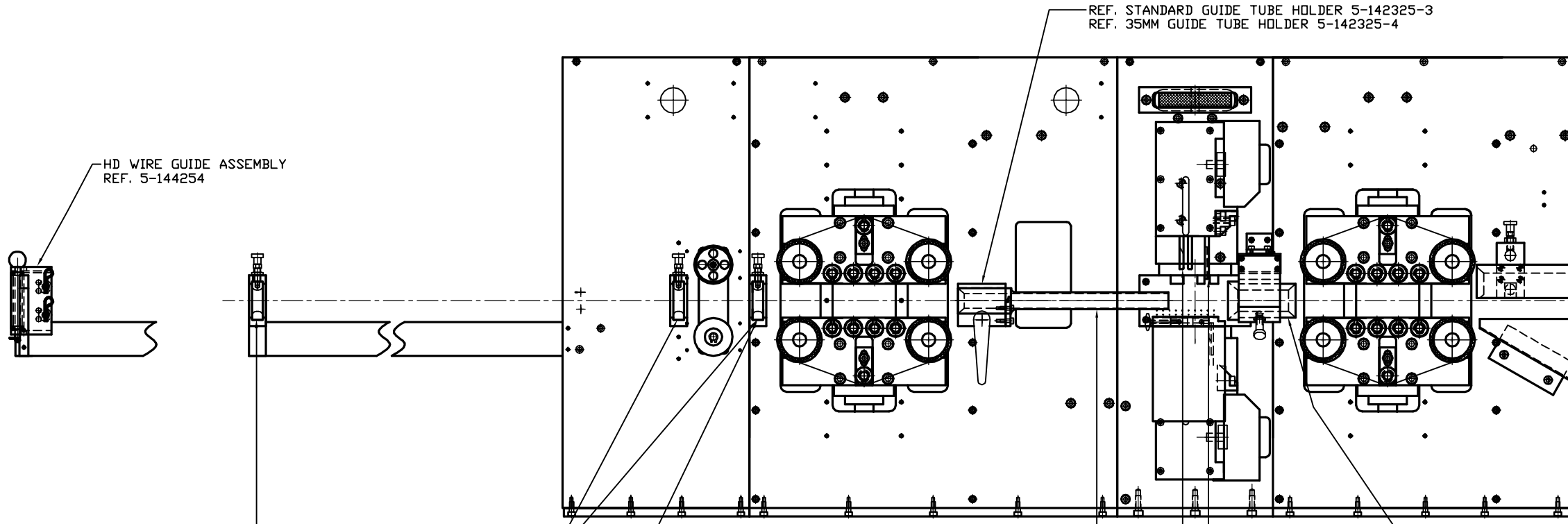


Three blade machine

Note: To view drawing, click on it in Table of Contents above.

## **CS327 Guide Selection**

REV 2 09/24/2012



WIRE GUIDE FOR BAR OPTIONAL

I.D.	PART NO.
.25 (6.35)	142405-3
.50 (12.7)	142405-7
.75 (19.1)	142405-11
1.00 (25.4)	142405-13
1.25 (31.8)	142405-15
1.50 (38.1)	142405-17

WIRE GUIDE FOR ENCODER STANDARD SERIES

I.D.	PART NO.
.12 (3.05)	142405-1
.19 (4.06)	142405-2
.25 (6.35)	142405-3
.31 (7.87)	142405-4
.37 (9.40)	142405-5
.43 (10.9)	142405-6
.50 (12.7)	142405-7
.56 (14.2)	142405-8
.62 (15.7)	142405-9
.69 (17.5)	142405-10
.75 (19.1)	142405-11
.88 (22.4)	142405-12
1.00 (25.4)	142405-13
1.12 (28.4)	142405-14
1.25 (31.8)	142405-15
1.37 (34.8)	142405-16
1.50 (38.1)	142405-17

FEED TUBE FOR WIRE D.D. 30mm OR LESS WITH IMAJE

I.D.	PART NO.
.12 (3.05)	5-143060-1
.19 (4.06)	5-143060-2
.25 (6.35)	5-143060-3
.31 (7.87)	5-143060-4
.37 (9.40)	5-143060-5
.43 (10.9)	5-143060-6
.50 (12.7)	5-143060-7
.56 (14.2)	5-143060-8
.62 (15.7)	5-143060-9
.69 (17.5)	5-143060-10
.75 (19.1)	5-143060-11
.88 (22.4)	5-143060-12
1.00 (25.4)	5-143060-13
1.12 (28.4)	5-143060-14
1.25 (31.8)	5-143060-15

FEED TUBE FOR WIRE D.D. 30mm OR LESS WITHOUT IMAJE

I.D.	PART NO.
.12 (3.05)	5-142400-1
.19 (4.06)	5-142400-2
.25 (6.35)	5-142400-3
.31 (7.87)	5-142400-4
.37 (9.40)	5-142400-5
.43 (10.9)	5-142400-6
.50 (12.7)	5-142400-7
.56 (14.2)	5-142400-8
.62 (15.7)	5-142400-9
.69 (17.5)	5-142400-10
.75 (19.1)	5-142400-11
.88 (22.4)	5-142400-12
1.00 (25.4)	5-142400-13
1.12 (28.4)	5-142400-14
1.25 (31.8)	5-142400-15

WIRE GUIDE FOR ENCODER SPECIAL SMALL WIRE

I.D.	PART NO.
.06 (1.52)	5-143259-1
.09 (2.29)	5-143259-2
.12 (3.05)	5-143259-3
.18 (4.72)	5-143259-4
.25 (6.35)	5-143259-5

FEED TUBE FOR WIRE D.D. 32mm TO 35mm WITH IMAJE \*

I.D.	PART NO.
1.37 (34.8)	5-143144-1
1.50 (38.1)	5-143144-2

FEED TUBE FOR WIRE D.D. 32mm TO 35mm WITHOUT IMAJE \*

I.D.	PART NO.
1.37 (34.8)	5-143142-1
1.50 (38.1)	5-143142-2

FEED TUBE FOR SMALL WIRE D.D. WITH IMAJE

I.D.	PART NO.
.06 (1.52)	5-143269-1
.09 (2.29)	5-143269-2
.12 (3.05)	5-143269-3

FEED TUBE FOR SMALL WIRE D.D. END OF TUBE CLOSE TO BLADE

I.D.	PART NO.
.12 (3.05)	5-146507-1
.19 (4.83)	5-146507-2
.25 (6.35)	5-146507-3
.31 (7.95)	5-146507-4

STANDARD FEED TUBE 2.25 (57) DIAMETER, 60° INLET

I.D.	PART NO.
.12 (3.05)	143057-1
.19 (4.06)	143057-2
.25 (6.35)	143057-3
.31 (7.87)	143057-4
.37 (9.40)	143057-5
.43 (10.9)	143057-6
.50 (12.7)	142318-7
.56 (14.2)	142318-8
.62 (15.7)	142318-9
.69 (17.5)	142318-10
.75 (19.1)	142318-11
.88 (22.4)	142318-12
1.00 (25.4)	142318-13
1.12 (28.4)	142318-14
1.25 (31.8)	142318-15

FEED TUBE 2.75 (70) DIAMETER, 82° INLET

I.D.	PART NO.
.50 (12.7)	143139-1
.56 (14.2)	143139-2
.62 (15.7)	143139-3
.69 (17.5)	143139-4
.75 (19.1)	143139-5
.88 (22.4)	143139-6
1.00 (25.4)	143139-7
1.12 (28.4)	143139-8
1.25 (31.8)	143139-9
1.37 (34.8)	143139-10
1.50 (38.1)	143139-11

TUBE LOCATED CLOSE TO BLADE FEED TUBE 2.25 (57) DIAMETER, 60° INLET

I.D.	PART NO.
.12 (3.05)	146509-1
.19 (4.06)	146509-2
.25 (6.35)	146509-3
.31 (7.87)	146509-4
.37 (9.40)	146509-5
.43 (10.9)	146509-6
.50 (12.7)	146510-1
.56 (14.2)	146510-2
.62 (15.7)	146510-3
.69 (17.5)	146510-4
.75 (19.1)	146510-5
.88 (22.4)	146510-6
1.00 (25.4)	146510-7
1.12 (28.4)	146510-8
1.25 (31.8)	146510-9

PART NO.	DESCRIPTION
142337-XXX	STRIPPING BLADE (TRUE RADIUS)
143066-XXX	STRIPPING BLADE (TANGENT V)
142945-1	STRIPPING BLADE (UNIVERSAL 30°)
142945-2	STRIPPING BLADE (UNIVERSAL 20°)
123723	STRIPPING BLADE (MULTI-V)
145034-XXX	WIRE STOP

PART NO.	DESCRIPTION
142336-060	CUT OFF BLADE WIRE (V)
142336-125	CUT OFF BLADE WIRE (V)
143059	CUT OFF BLADE WIRE (-)
5-142978	STEEL CUT OFF ASS'Y
5-143296	CARBIDE CUT OFF ASS'Y

SLOTTED DISCHARGE GUIDE ASSEMBLY

I.D.	PART NO.
.31 (7.87)	5-142736-4
.56 (14.2)	5-142736-8
.88 (22.4)	5-142736-12
1.25 (31.8)	5-142736-15
1.50 (38.1)	5-142736-17

ROUND DISCHARGE GUIDE ASSEMBLY

I.D.	PART NO.
.31 (7.87)	5-143114-1
.50 (12.7)	5-143114-2
.75 (19.1)	5-143114-3
1.00 (25.4)	5-143114-4
1.25 (31.8)	5-143114-5

RAMATECH DISCHARGE GUIDE ASSEMBLY

I.D.	PART NO.
1.50 (38.1)	5-143326

WIRE GUIDE FOR BOWL COLLECTOR CD-17  
WIRE GUIDE FOR STATIONARY PASSIVE COLLECTOR  
WIRE GUIDE FOR 3M COLLECTOR ASSEMBLY  
GUIDE TUBE 7.0 (178) LONG

I.D.	PART NO.	TUBE HOLDER NUMBER
.31 (7.87)	143347-1	5-143346
.50 (12.7)	143347-2	
.75 (19.1)	143347-3	
1.00 (25.4)	143347-4	
1.25 (31.8)	143347-5	

WIRE GUIDE FOR ROLLUP PASSIVE COLLECTOR  
GUIDE TUBE 4.63 (118) LONG

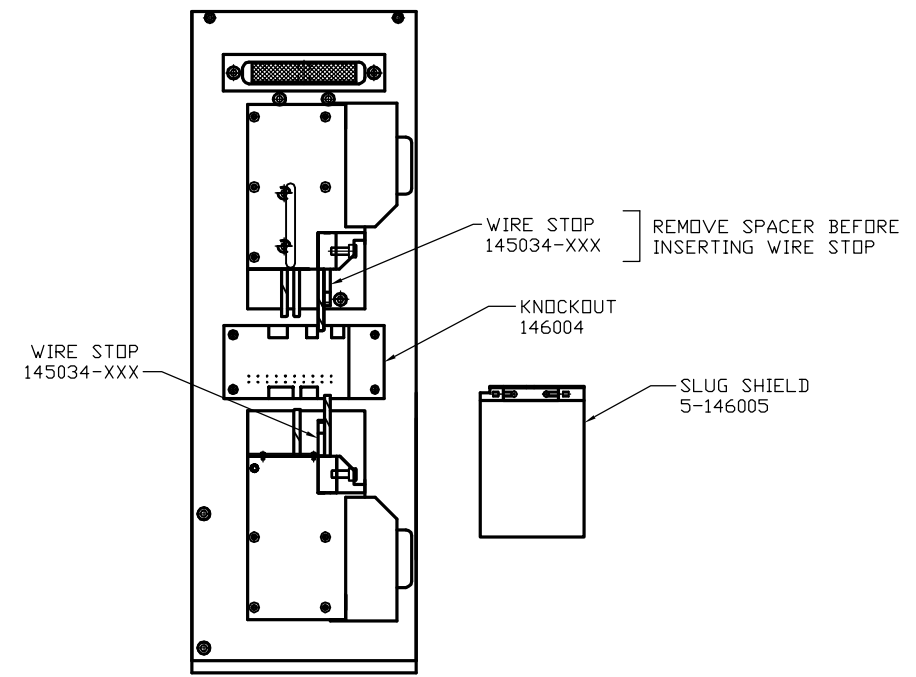
I.D.	PART NO.	TUBE HOLDER NUMBER
.31 (7.87)	143644-1	5-143346
.50 (12.7)	143644-2	
.75 (19.1)	143644-3	
1.00 (25.4)	143644-4	
1.25 (31.8)	143644-5	

NOTE, THIS PART HAS TUBES TO GUIDE THE WIRE WHEN IT BACKS UP

DIMENSIONS IN (PARENTHESIS) ARE IN MILLIMETERS  
REFERENCE GAGE 142770  
REF: FOR 3-BLADES TOOL HOLDER SEE SHEET 2  
\* REQUIRES MACHINE TO HAVE HOLDER 5-142325-4

- ECO 06-47
- 03/27/2006
- LALUMONDIER
- ECO 06-50
- 04/06/2006
- LALUMONDIER
- ECO 06-58
- 04/17/2006
- H. KEENE
- ECO 06-85
- 05/08/2006
- LALUMONDIER
- ECO 06-142
- 7/20/2006
- LALUMONDIER
- ECO 06-150
- 7/25/2006
- LALUMONDIER
- ECO 07-53
- 4/5/2007
- LALUMONDIER
- ECO 07-258
- 11/05/2007
- D.WESTRICK
- ECO 08-57
- 02/27/2008
- D.WESTRICK
- ECO 08-157
- 7/8/2008
- LALUMONDIER

6-142406	HEAT TREATMENT/SURFACE TREATMENT	MATERIAL DESCRIPTION	USED FOR	<p>CLASS CODE 327</p> <p>REVISION DATE 01/17/13</p> <p>REVISION 10</p> <p>SHEET NUMBER 1 of 3</p>
	CONFIDENTIAL	D	9-CS327999000	
	WIRE ADAPTION KIT 2-BLADES CS-327			
	WORK TO MEAN DIMENSIONS DO NOT SCALE DRAWING	DESIGNED BY LALUMONDIER	SCALE 1:4	
ES-1 STANDARDS APPLY PLEASE READ THEM BEFORE MFG.		CHECKED BY K.COOTE	DATE 10/11/2009	

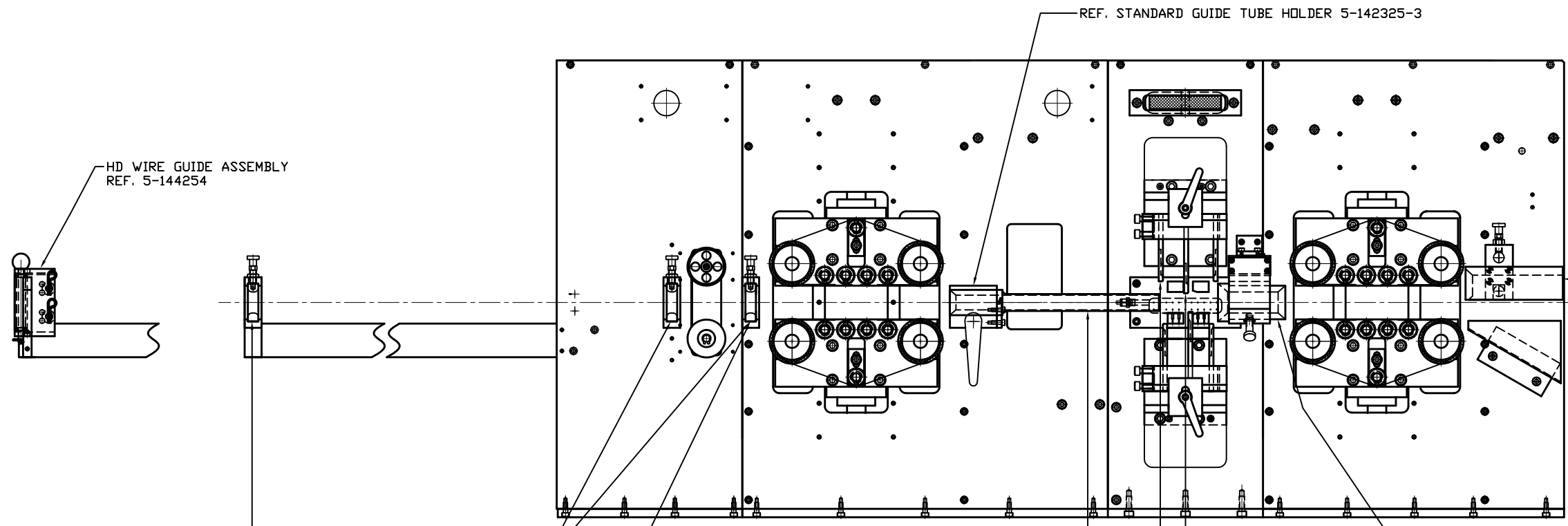


WIRE STOP MODIFICATION

REVISIONS

- △ ECD 06-47  
03/27/2006  
LALUMONDIER
- △ ECD 06-50  
04/06/2006  
LALUMONDIER
- △ ECD 06-58  
04/17/2006  
H KEENE
- △ ECD 06-85  
05/8/2006  
LALUMONDIER
- △ ECD 06-142  
7/20/2006  
LALUMONDIER
- △ ECD 06-150  
7/25/2006  
LALUMONDIER
- △ ECD 07-53  
4/5/2007  
LALUMONDIER
- △ ECD 07-258  
11/05/2007  
D.WESTRICK
- △ ECD 08-57  
02/27/2008  
D.WESTRICK
- △ ECD 08-157  
7/8/2008  
LALUMONDIER

6-142406	HEAT TREATMENT/SURFACE TREATMENT		MATERIAL DESCRIPTION		USED FOR	
	-		-		9-CS327999000	
	<small>CONFIDENTIAL</small> <small>This document contains</small> <small>proprietary information</small> <small>which shall not be used,</small> <small>reproduced, or disclosed</small> <small>to others without prior</small> <small>written approval of Artos</small> <small>Engineering Company.</small>		D			
	<small>WORK TO MEAN DIMENSIONS</small> <small>DO NOT SCALE DRAWING</small>		<b>WIRE ADAPTION KIT</b> 2-BLADES CS-327		CLASS CODE 327	
<small>ES-1 STANDARDS APPLY</small> <small>PLEASE READ THEM BEFORE MFG.</small>		<small>DESIGNED BY</small> LALUMONDIER	<small>SCALE</small> 1:4	<small>DATE</small> 10/11/2005	<small>DRAWING NO.</small> 6-142406	<small>REVISION DATE</small> 01/17/13
		<small>CHECKED BY</small> K.COOTE				<small>REVISION</small> 10
						<small>SHEET NUMBER</small> 2 of 3



SLOTTED DISCHARGE GUIDE ASSEMBLY

I.D.	PART NO.
.31 (7.87)	5-142736-4
.56 (14.2)	5-142736-8
.88 (22.4)	5-142736-12
1.25 (31.8)	5-142736-15

ROUND DISCHARGE GUIDE ASSEMBLY

I.D.	PART NO.
.31 (7.87)	5-143114-1
.50 (12.7)	5-143114-2
.75 (19.1)	5-143114-3
1.00 (25.4)	5-143114-4
1.25 (31.8)	5-143114-5

RAMATECH DISCHARGE GUIDE ASSEMBLY

I.D.	PART NO.
1.50 (38.1)	5-143326

WIRE GUIDE FOR BOWL COLLECTOR CD-17  
 WIRE GUIDE FOR STATIONARY PASSIVE COLLECTOR  
 WIRE GUIDE FOR 3M COLLECTOR ASSEMBLY  
 GUIDE TUBE 7.0 (178) LONG

I.D.	PART NO.	TUBE HOLDER NUMBER
.31 (7.87)	143347-1	5-143346
.50 (12.7)	143347-2	
.75 (19.1)	143347-3	
1.00 (25.4)	143347-4	
1.25 (31.8)	143347-5	

WIRE GUIDE FOR ROLLUP PASSIVE COLLECTOR  
 GUIDE TUBE 4.63 (118) LONG

I.D.	PART NO.	TUBE HOLDER NUMBER
.31 (7.87)	143644-1	5-143346
.50 (12.7)	143644-2	
.75 (19.1)	143644-3	
1.00 (25.4)	143644-4	
1.25 (31.8)	143644-5	

WIRE GUIDE FOR BAR  
 OPTIONAL

I.D.	PART NO.
.25 (6.35)	142405-3
.50 (12.7)	142405-7
.75 (19.1)	142405-11
1.00 (25.4)	142405-13
1.25 (31.8)	142405-15

WIRE GUIDE FOR ENCODER  
 STANDARD SERIES

I.D.	PART NO.
.12 (3.05)	142405-1
.19 (4.06)	142405-2
.25 (6.35)	142405-3
.31 (7.87)	142405-4
.37 (9.40)	142405-5
.43 (10.9)	142405-6
.50 (12.7)	142405-7
.56 (14.2)	142405-8
.62 (15.7)	142405-9
.69 (17.5)	142405-10
.75 (19.1)	142405-11
.88 (22.4)	142405-12
1.00 (25.4)	142405-13
1.12 (28.4)	142405-14
1.25 (31.8)	142405-15

WIRE GUIDE FOR ENCODER  
 SPECIAL SMALL WIRE

I.D.	PART NO.
.06 (1.52)	5-143259-1
.09 (2.29)	5-143259-2
.12 (3.05)	5-143259-3
.18 (4.72)	5-143259-4
.25 (6.35)	5-143259-5

NOTE, THIS PART HAS TUBES TO  
 GUIDE THE WIRE WHEN IT BACKS UP

FEED TUBE FOR WIRE  
 O.D. 30mm OR LESS  
 WITH IMAJE

I.D.	PART NO.
.12 (3.05)	5-143060-1
.19 (4.06)	5-143060-2
.25 (6.35)	5-143060-3
.31 (7.87)	5-143060-4
.37 (9.40)	5-143060-5
.43 (10.9)	5-143060-6
.50 (12.7)	5-143060-7
.56 (14.2)	5-143060-8
.62 (15.7)	5-143060-9
.69 (17.5)	5-143060-10
.75 (19.1)	5-143060-11
.88 (22.4)	5-143060-12
1.00 (25.4)	5-143060-13
1.12 (28.4)	5-143060-14
1.25 (31.8)	5-143060-15

FEED TUBE FOR WIRE  
 O.D. 30mm OR LESS  
 WITHOUT IMAJE

I.D.	PART NO.
.12 (3.05)	5-142400-1
.19 (4.06)	5-142400-2
.25 (6.35)	5-142400-3
.31 (7.87)	5-142400-4
.37 (9.40)	5-142400-5
.43 (10.9)	5-142400-6
.50 (12.7)	5-142400-7
.56 (14.2)	5-142400-8
.62 (15.7)	5-142400-9
.69 (17.5)	5-142400-10
.75 (19.1)	5-142400-11
.88 (22.4)	5-142400-12
1.00 (25.4)	5-142400-13
1.12 (28.4)	5-142400-14
1.25 (31.8)	5-142400-15

FEED TUBE FOR SMALL  
 WIRE O.D.  
 WITHOUT IMAJE

I.D.	PART NO.
.06 (1.52)	5-143269-1
.09 (2.29)	5-143269-2
.12 (3.05)	5-143269-3

STANDARD  
 FEED TUBE 2.25 (57)  
 DIAMETER, 60° INLET

I.D.	PART NO.
.12 (3.05)	143057-1
.19 (4.06)	143057-2
.25 (6.35)	143057-3
.31 (7.87)	143057-4
.37 (9.40)	143057-5
.43 (10.9)	143057-6
.50 (12.7)	142318-7
.56 (14.2)	142318-8
.62 (15.7)	142318-9
.69 (17.5)	142318-10
.75 (19.1)	142318-11
.88 (22.4)	142318-12
1.00 (25.4)	142318-13
1.12 (28.4)	142318-14
1.25 (31.8)	142318-15

FEED TUBE 2.75 (70)  
 DIAMETER, 82° INLET

I.D.	PART NO.
.50 (12.7)	143139-1
.56 (14.2)	143139-2
.62 (15.7)	143139-3
.69 (17.5)	143139-4
.75 (19.1)	143139-5
.88 (22.4)	143139-6
1.00 (25.4)	143139-7
1.12 (28.4)	143139-8
1.25 (31.8)	143139-9

PART NO.	DESCRIPTION
142900-060	CUT OFF BLADE WIRE (V)
142900-125	CUT OFF BLADE WIRE (V)
143058	CUT OFF BLADE WIRE (-)

PART NO.	DESCRIPTION
142337-XXX	STRIPPING BLADE (TRUE RADIUS)
143066-XXX	STRIPPING BLADE (TANGENT V)
142945-1	STRIPPING BLADE (UNIVERSAL 30°)
142945-2	STRIPPING BLADE (UNIVERSAL 20°)
123723	STRIPPING BLADE (MULTI-V)

DIMENSIONS IN (PARENTHESIS) ARE IN MILLIMETERS  
 REFERENCE GAGE 142770  
 REF: FOR 2-BLADES TOOL HOLDER SEE SHEET 1

REVISIONS

ECO 06-85	5/8/2006	LALUMONDIER
ECO 06-142	7/20/2006	LALUMONDIER
ECO 06-150	7/25/2006	LALUMONDIER
ECO 07-53	4/5/2007	LALUMONDIER
ECO 07-258	11/05/2007	D.WESTRICK
ECO 08-57	02/27/2008	D.WESTRICK
ECO 08-157	7/8/2008	LALUMONDIER

6-142406	HEAT TREATMENT/SURFACE TREATMENT	MATERIAL DESCRIPTION	USED FOR	<p>CLASS CODE 327</p> <p>REVISION DATE 01/17/13</p> <p>REVISION 10</p> <p>SHEET NUMBER 3 of 3</p>
	CONFIDENTIAL	D	9-CS327999000	
			WIRE ADAPTION KIT	
	WORK TO MEAN DIMENSIONS DO NOT SCALE DRAWING		3-BLADES CS-327	
ES-1 STANDARDS APPLY		DRAWN BY: LALUMONDIER	SCALE: 1:4	6-142406
PLEASE READ THEM BEFORE MFG.		CHECKED BY: K.COOTE	DATE: 5/8/2006	