

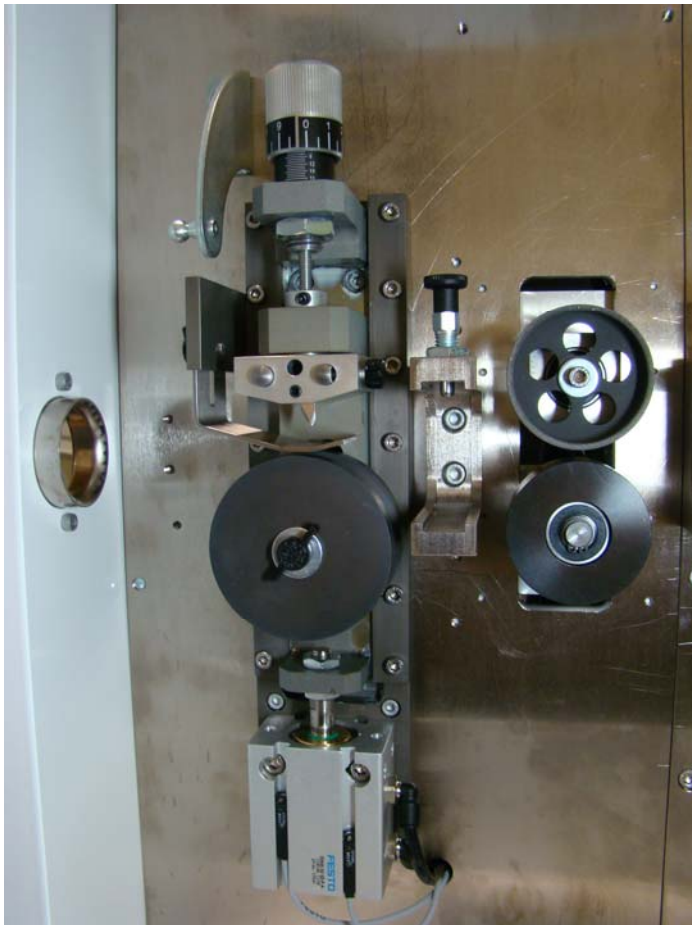
# CS327 Slitter tooling

REV 14 02/10/2015

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There are 3 tooling parts required for each wire to be slit, see each section below to determine what is needed.

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Slitter assembly

Dimensions on blade sketches are in inches and are only approximate overall dimensions.

## Wire hold down

The part number is dependent on the number of conductors to be slit, and the distance between the conductors.

For a one or two conductor wire use part number 142960-1

For a three conductor wire you have to calculate the A and B dimensions.

C= the conductor center to center distance

If using metric units of measure.

$$"A" = 19.1 - C/2 -.762$$

$$"B" = 1.60 + C$$

If using English units of measure.

$$"A" = .75 - C/2 -.03$$

$$"B" = .063 + C$$

For a four conductor wire you have to calculate the A and B dimensions.

C= the conductor center to center distance

If using metric units of measure.

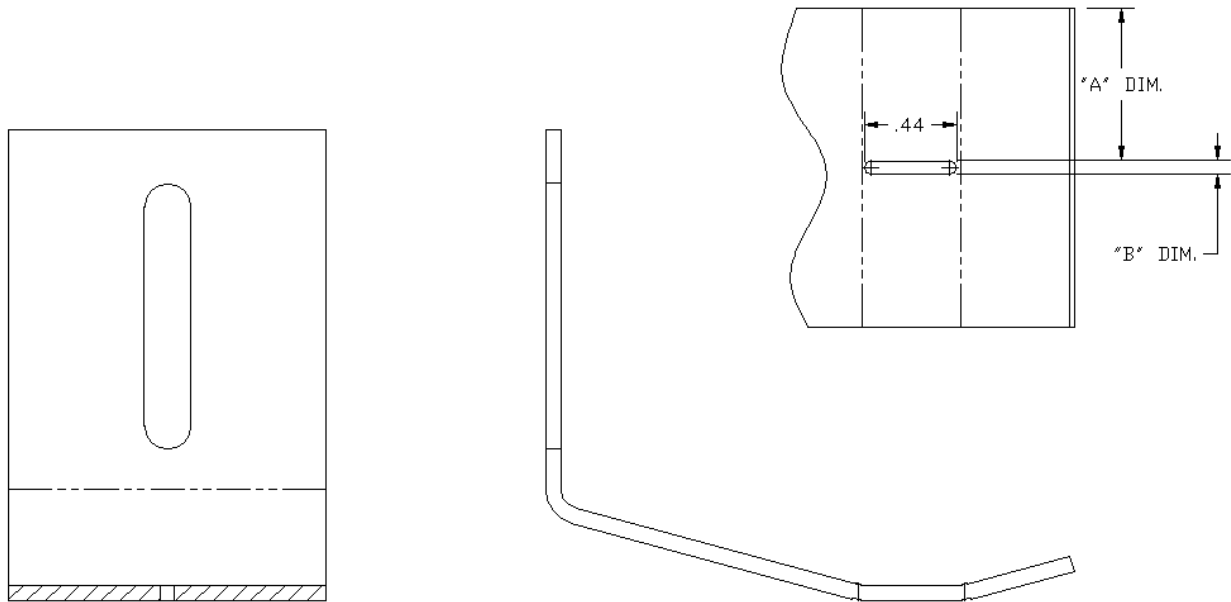
$$"A" = 19.1 - C -.762$$

$$"B" = 1.5748 + 2(C)$$

If using English units of measure.

$$"A" = .75 - C -.03$$

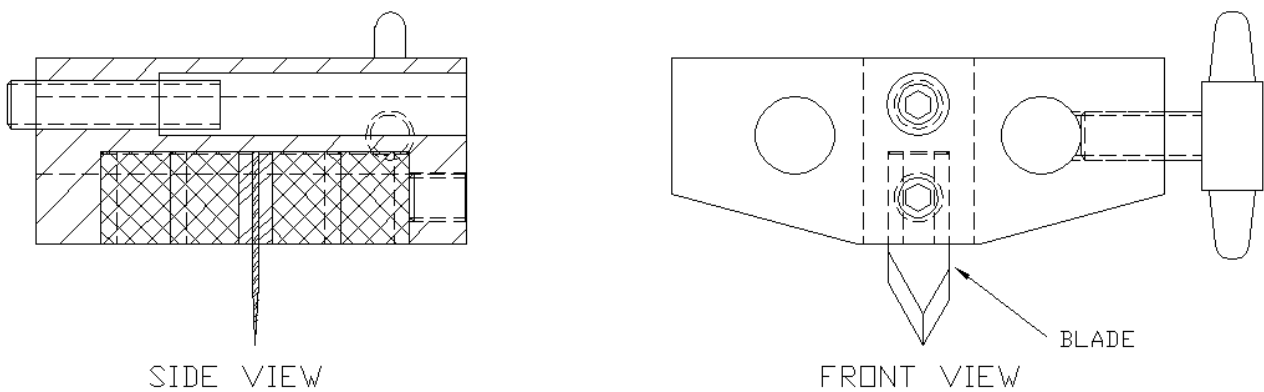
$$"B" = .062 + 2(C)$$



**142960-xx** Slitter hold down.

Dash number	"A" Dim. inches	"A" Dim. mm	"B" Dim. inches	"B" Dim. mm
-1	0.72	18.29	0.063	1.60
-2	0.62	15.75	0.26	6.60

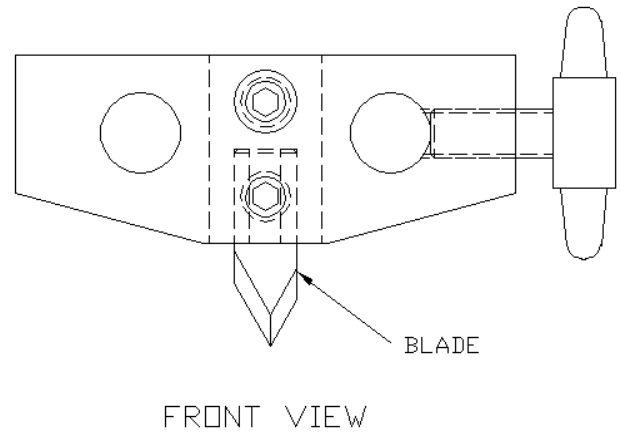
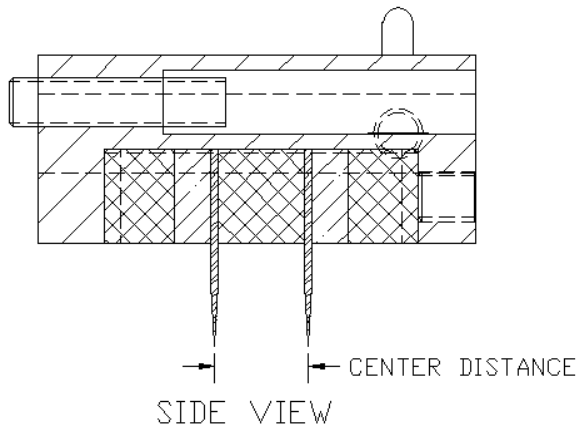
## Blade assembly



**5-142971** Blade assembly for single slitting blade

**H-22896** Replacement blade

**H-22896TC** Replacement blade, Titanium Nitrite coated.

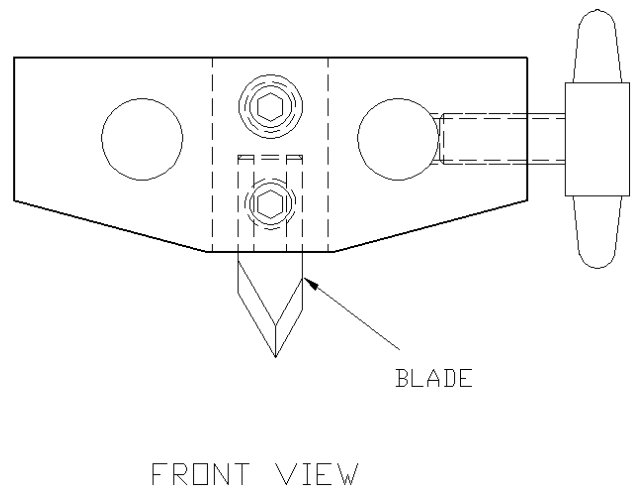
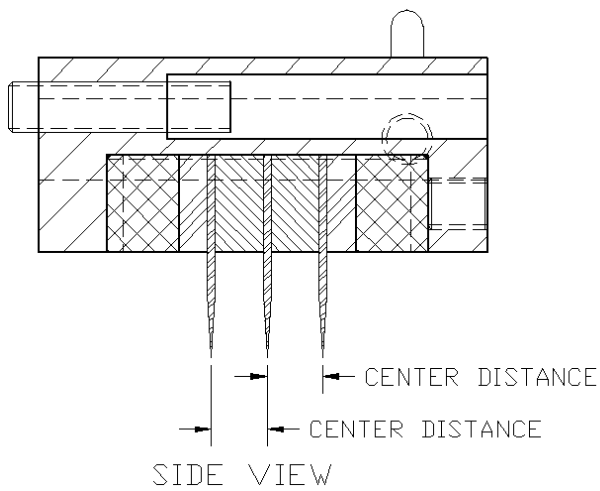


**5-142972-XX** Blade assembly for double slitting blade

**H-22896** Replacement blade

**H-22896TC** Replacement blade, Titanium Nitrite coated.

Dash number	Center Distance inch	Center distance mm
-1	0.156	3.96



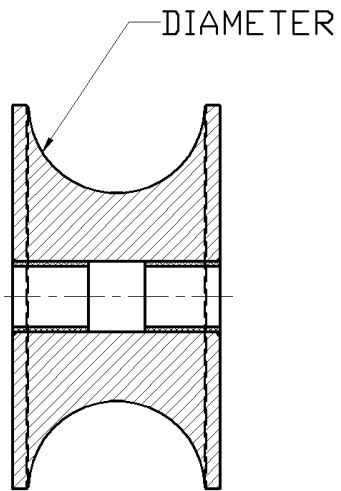
**5-142973-XX** Blade assembly for triple slitting blade

**H-22896** Replacement blade

**H-22896TC** Replacement blade, Titanium Nitrite coated.

Dash number	Center Distance inch	Center distance mm

## Wire guide wheel assembly

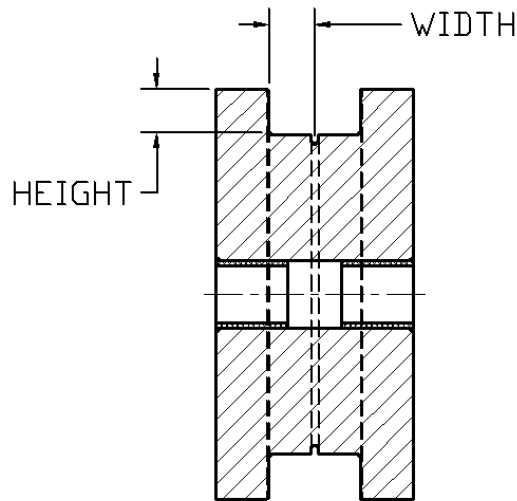


**5-142964-XX** Wheel assembly for single conductor wire.

Normally you select a diameter that is about 0.008 inches (.20mm) larger than your wire size.

Item Number	diameter inches	diameter mm
-46	0.076	1.93
-23	0.096	2.44
-45	0.110	2.79
-22	0.130	3.30
-44	0.134	3.40
-43	0.164	4.17
-2	0.196	4.97
-42	0.206	5.23
-13	0.222	5.64
-40	0.252	6.40
-21	0.262	6.65
-39	0.272	6.91
-9	0.328	8.33
-36	0.351	8.92
-33	0.378	9.60
-3	0.392	9.96
-28	0.410	10.41
-41	0.420	10.67
-37	0.429	10.90
-31	0.434	11.02
-24	0.448	11.38
-8	0.468	11.88
-26	0.478	12.14
-38	0.490	12.45
-25	0.508	12.90
-7	0.534	13.56
-12	0.568	14.43

-34	0.582	14.78
-6	0.612	15.54
-19	0.634	16.10
-27	0.644	16.36
-32	0.656	16.66
-5	0.668	16.97
-14	0.718	18.24
-4	0.736	18.69
-15	0.758	19.25
-10	0.788	20.02
-35	0.814	20.68
-16	0.858	21.79
-11	0.878	22.30
-29	0.928	23.57
-17	0.972	24.69
-20	1.068	27.13
-30	1.076	27.33
-1	1.386	35.20

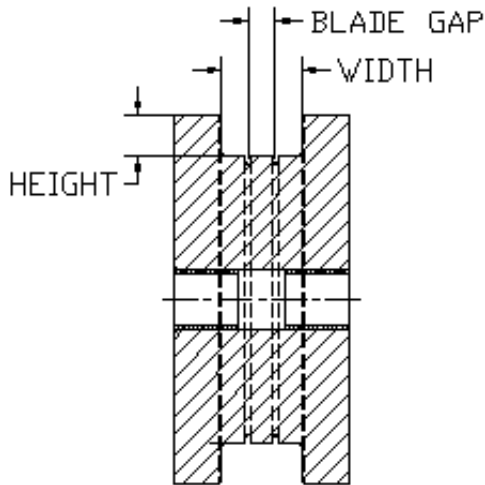


**5-142966-XX** Wheel assembly for two conductor wire.

Normally you select a width that is about 0.008 inches (.20mm) larger than your wire size and a height that is 0.000 to 0.008 greater than the wire size.

Item Number	Width inches	Width mm	Height inches	Height mm
-10	0.403	10.24	0.170	4.32
-9	0.528	13.41	0.220	5.59
-8	0.648	16.46	0.305	7.75
-2	0.698	17.73	0.320	8.13
-4	0.724	18.39	0.320	8.13
-1	0.788	20.02	0.365	9.27
-7	0.848	21.54	0.390	9.91

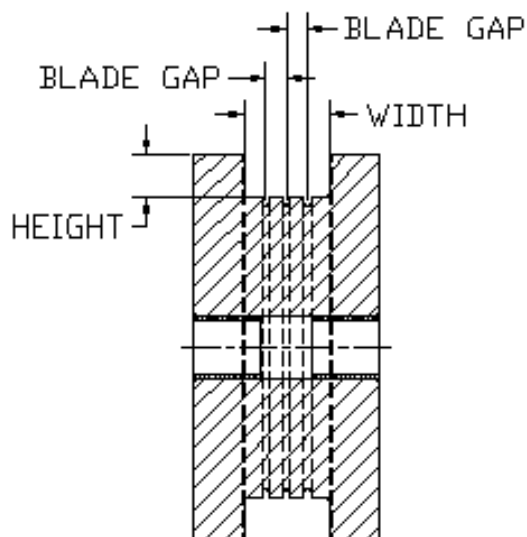
-5	0.908	23.06	0.405	10.29
-6	0.948	24.08	0.415	10.54
-3	1.000	25.40	0.470	11.94
-11	1.168	29.67	0.520	13.21



**5-142968-XX** Wheel assembly for three conductor wire.

Normally you select a width that is about 0.008 inches (.20mm) larger than your wire size and a height that is 0.000 to 0.008 greater than the wire size.

Item Number	Width inches	Width mm	Blade Gap inch	Blade Gap mm	Height inches	Height mm
-1	0.642	16.31	0.156	3.96	0.282	7.16



**5-142970-XX** Wheel assembly for four conductor wire.

Normally you select a width that is about 0.008 inches (.20mm) larger than your wire size and a height that is 0.000 to 0.008 greater than the wire size.

<b>Item Number</b>	<b>Width inches</b>	<b>Width mm</b>	<b>Blade Gap inch</b>	<b>Blade Gap mm</b>	<b>Height inches</b>	<b>Height mm</b>