

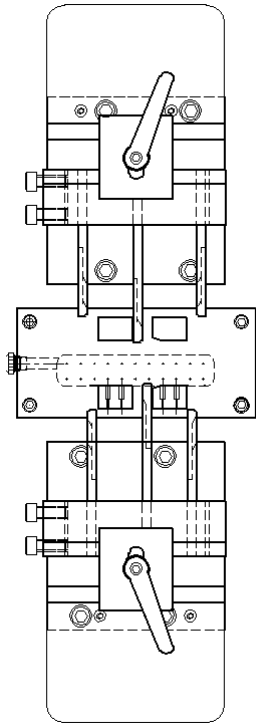
## CS327 Blades for 3 blade cutterhead

REV 1 12/19/2019

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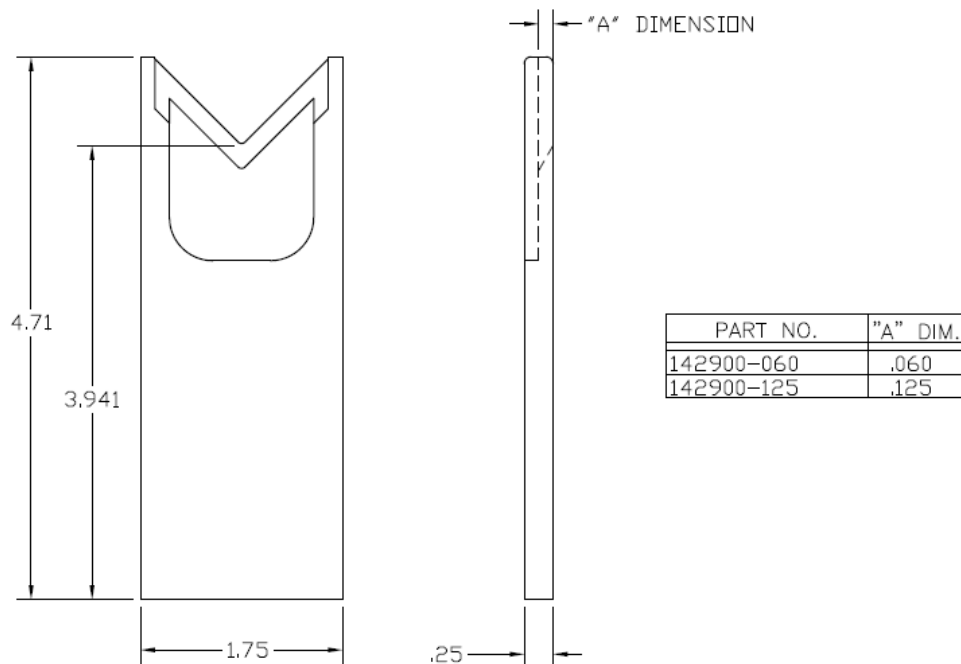
Dimensions on blade sketches are in inches.



View of 3 blade machine.

## Wire cut off blades

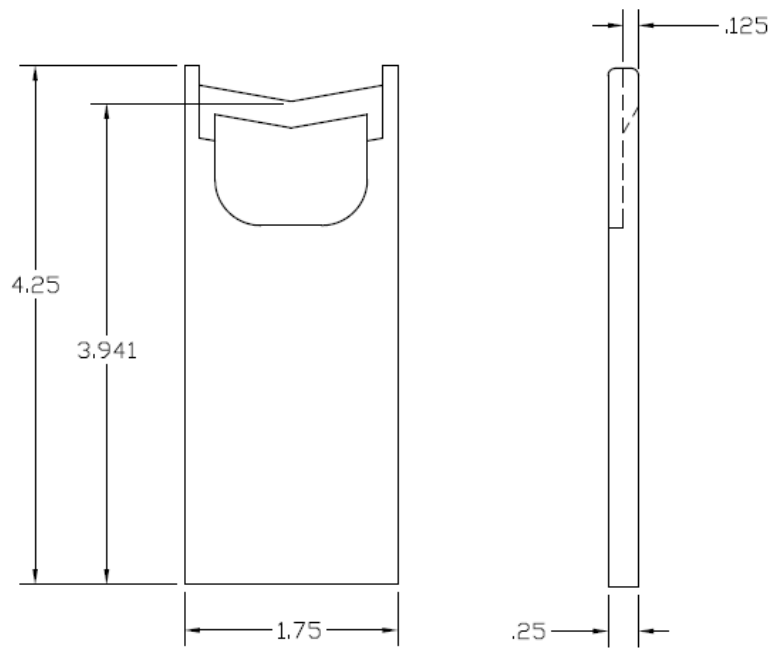
### *Standard cutoff blades*



**142900-125** Wire cut off blade. This is the standard blade for all general cutting.

**142900-060** Wire cut off blade. This blade has a relief cut out so the wire strands do not cone out as noticeably as with the -125 blade, and the blade will cut through easier. It is mainly for larger diameter wires with fine stranding.

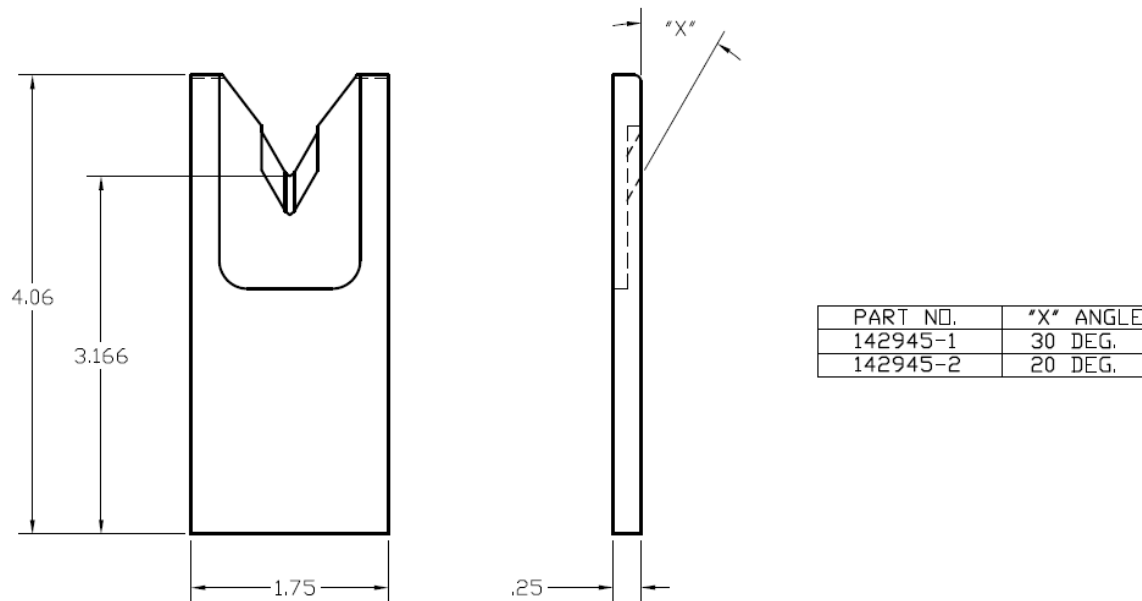
***Flat material cutoff blade***



**143058** Flat wire cut off blade.

## Wire stripping blades

### *Universal V style stripping blades*



**142945-1** Strip blade "V" 30 degree.

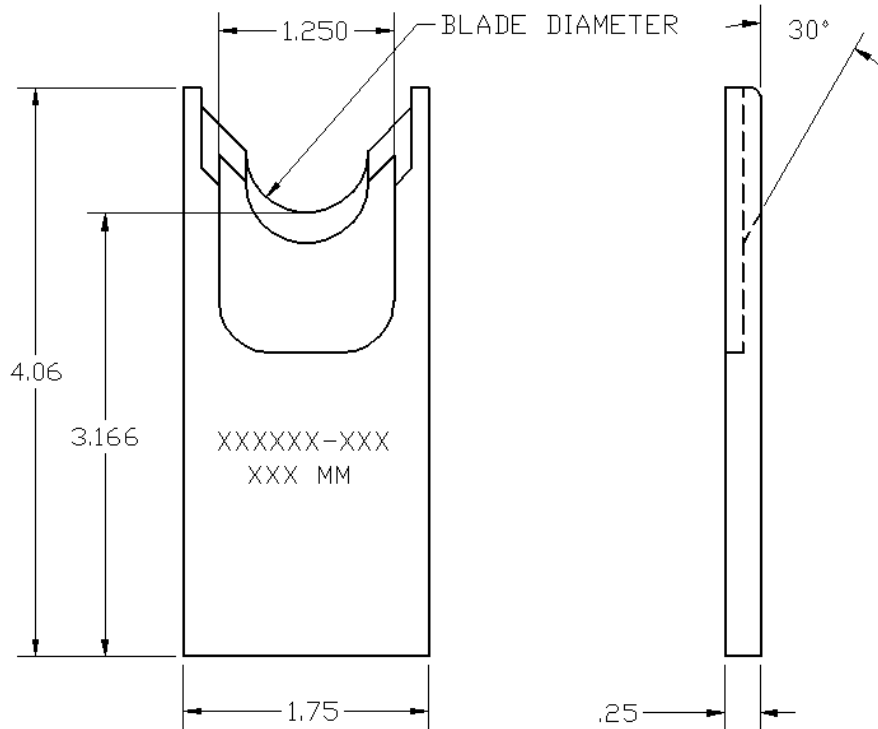
**142945-2** Strip blade "V" 20 degree, the 20 degree edge has a steeper angle and will give a very clean cut. The downside is that they do not stay sharp as long as 30 degree would.

### *True radius style stripping blades, 30 deg*

The sharp edge is ground to a half circle whose radius approximates awg wire size. The entry angle lines intersect the half circle at the quadrant points. This type of blade, when closed, presents a true circle profile.

**Advantages:** this type of blade is excellent for precise and clean jacket removal because it combines the scissor-like shearing action of the by-pass blade with the exact hole profile matching a conductor gauge. Excellent for thin wall cross-link PVC and most rubbery or elastic insulations (thin or thick wall).

**Disadvantages:** shut height cannot be modified to process adjacent wire sizes. Off center wire condition has to be considered when choosing blade size.

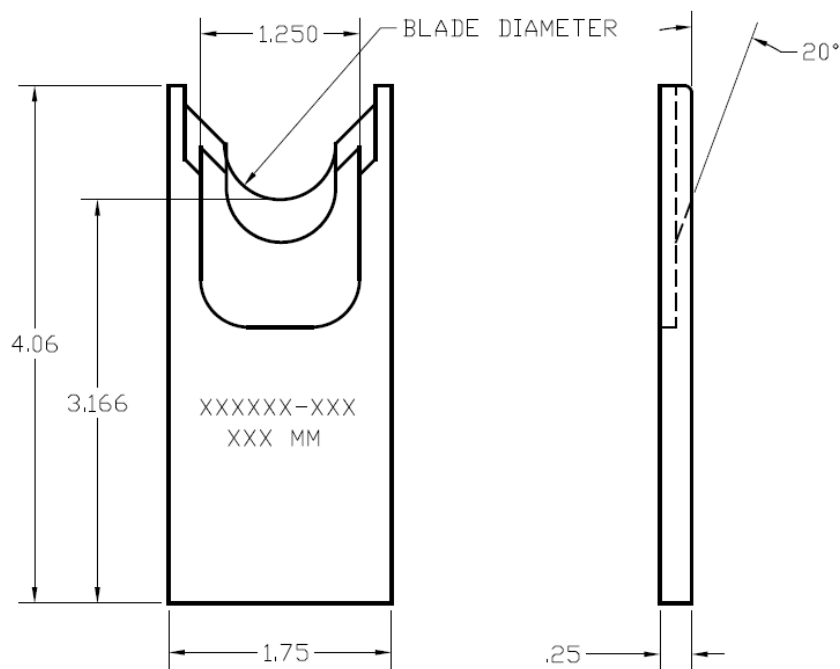


**142337-xxx** Strip blade, radius style 30 degree, the dash number is the diameter of the hole in the blade in inches. Example -028 is .028 inches

| Dash #      millimeters |      |      |       |      |       |
|-------------------------|------|------|-------|------|-------|
| -024                    | 0.61 | -250 | 6.35  | -560 | 14.22 |
| -031                    | 0.78 | -256 | 6.50  | -580 | 14.73 |
| -039                    | 0.99 | -260 | 6.60  | -600 | 15.24 |
| -047                    | 1.19 | -270 | 6.86  | -620 | 15.75 |
| -055                    | 1.40 | -280 | 7.11  | -640 | 16.26 |
| -062                    | 1.57 | -285 | 7.24  | -660 | 16.76 |
| -067                    | 1.70 | -290 | 7.37  | -680 | 17.27 |
| -070                    | 1.78 | -300 | 7.62  | -700 | 17.78 |
| -074                    | 1.88 | -320 | 8.13  | -720 | 18.29 |
| -078                    | 1.98 | -340 | 8.64  | -740 | 18.80 |
| -090                    | 2.29 | -350 | 8.89  | -760 | 19.30 |
| -102                    | 2.59 | -360 | 9.14  | -780 | 19.81 |
| -112                    | 2.84 | -370 | 9.40  | -800 | 20.32 |
| -125                    | 3.17 | -380 | 9.65  | -820 | 20.83 |
| -135                    | 3.43 | -390 | 9.91  | -840 | 21.34 |
| -140                    | 3.56 | -400 | 10.16 | -860 | 21.84 |
| -145                    | 3.68 | -410 | 10.41 | -880 | 22.35 |
| -150                    | 3.81 | -420 | 10.67 | -900 | 22.86 |

|      |      |      |       |       |       |
|------|------|------|-------|-------|-------|
| -160 | 4.06 | -440 | 11.18 | -920  | 23.37 |
| -170 | 4.32 | -450 | 11.43 | -940  | 23.88 |
| -175 | 4.45 | -460 | 11.68 | -960  | 24.38 |
| -200 | 5.08 | -480 | 12.19 | -980  | 24.89 |
| -210 | 5.33 | -500 | 12.70 | -1000 | 25.40 |
| -220 | 5.59 | -520 | 13.21 | -1010 | 25.65 |
| -230 | 5.84 | -540 | 13.72 | -1170 | 29.72 |
| -240 | 6.10 | -550 | 13.97 |       |       |

### ***True radius style stripping blades, 20 deg***

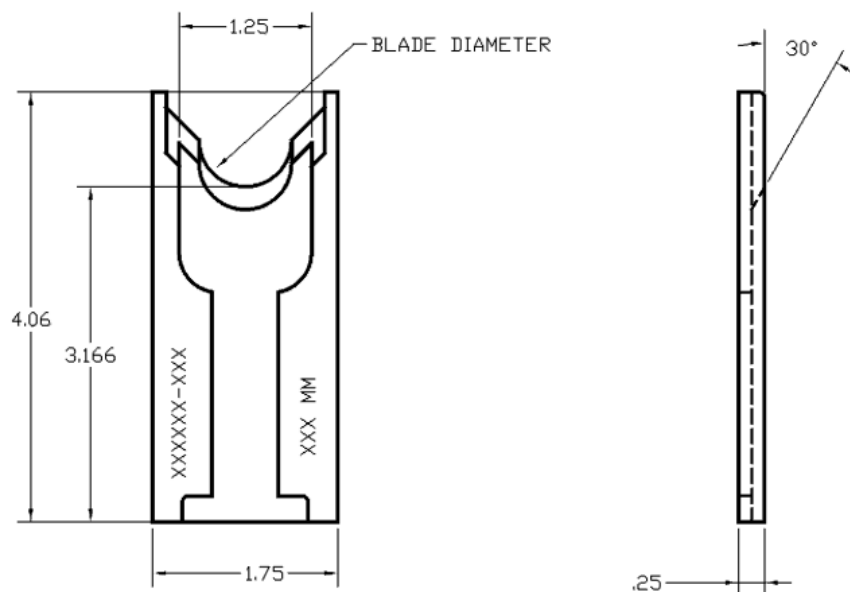


**149311-xxx** Strip blade, radius style 20 degree, the dash number is the diameter of the hole in the blade in inches. Example -028 is .028 inches. These are only for insulations that are hard to cut through. The sharper (thinner) edge is not as strong as the 30 degree edge.

| Dash # | millimeters |      |      |      |       |
|--------|-------------|------|------|------|-------|
| -024   | 0.61        | -230 | 5.84 | -620 | 15.75 |
| -031   | 0.78        | -240 | 6.10 | -640 | 16.26 |
| -039   | 0.99        | -260 | 6.60 | -660 | 16.76 |
| -047   | 1.19        | -270 | 6.86 | -680 | 17.27 |
| -055   | 1.40        | -280 | 7.11 | -700 | 17.78 |

|      |      |      |       |       |       |
|------|------|------|-------|-------|-------|
| -062 | 1.57 | -300 | 7.62  | -720  | 18.29 |
| -067 | 1.70 | -320 | 8.13  | -740  | 18.80 |
| -070 | 1.78 | -340 | 8.64  | -760  | 19.30 |
| -074 | 1.88 | -350 | 8.89  | -780  | 19.81 |
| -078 | 1.98 | -360 | 9.14  | -800  | 20.32 |
| -090 | 2.29 | -370 | 9.40  | -820  | 20.83 |
| -102 | 2.59 | -380 | 9.65  | -840  | 21.34 |
| -112 | 2.84 | -400 | 10.16 | -860  | 21.84 |
| -125 | 3.17 | -410 | 10.41 | -880  | 22.35 |
| -135 | 3.43 | -420 | 10.67 | -900  | 22.86 |
| -140 | 3.56 | -440 | 11.18 | -920  | 23.37 |
| -145 | 3.68 | -460 | 11.68 | -940  | 23.88 |
| -150 | 3.81 | -480 | 12.19 | -960  | 24.38 |
| -160 | 4.06 | -500 | 12.70 | -980  | 24.89 |
| -170 | 4.32 | -520 | 13.21 | -1000 | 25.40 |
| -175 | 4.45 | -540 | 13.72 | -1010 | 25.65 |
| -200 | 5.08 | -560 | 14.22 | -1170 | 29.72 |
| -210 | 5.33 | -580 | 14.73 |       |       |
| -220 | 5.59 | -600 | 15.24 |       |       |

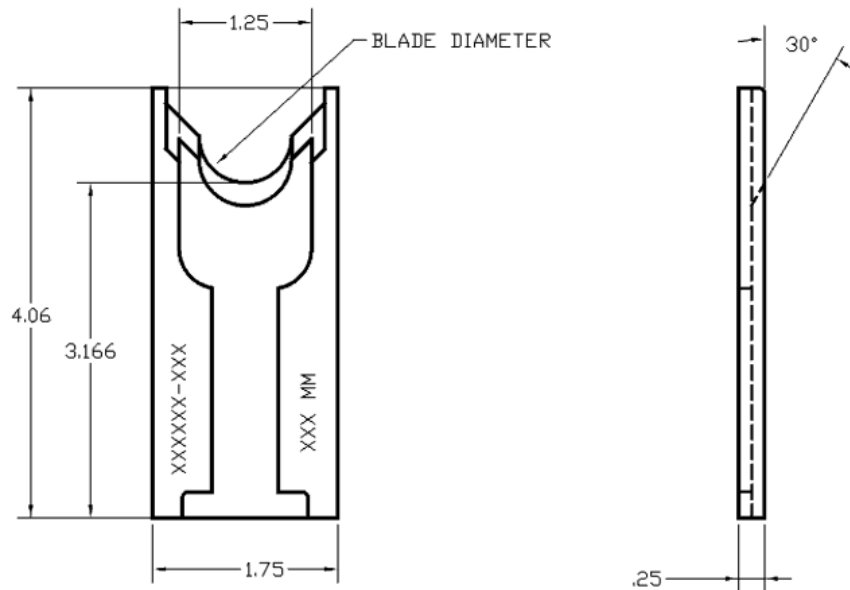
***True radius style strip, 30 deg, for use with built in depth stop 149626***



**149625-xxx** Strip blade, radius style 30 degree, the dash number is the diameter of the hole in the blade in inches. Example -028 is .028 inches

| Dash # | millimeters |      |       |       |       |
|--------|-------------|------|-------|-------|-------|
| -024   | 0.61        | -250 | 6.35  | -560  | 14.22 |
| -031   | 0.78        | -256 | 6.50  | -580  | 14.73 |
| -039   | 0.99        | -260 | 6.60  | -600  | 15.24 |
| -047   | 1.19        | -270 | 6.86  | -620  | 15.75 |
| -055   | 1.40        | -280 | 7.11  | -640  | 16.26 |
| -062   | 1.57        | -285 | 7.24  | -660  | 16.76 |
| -067   | 1.70        | -300 | 7.62  | -680  | 17.27 |
| -070   | 1.78        | -320 | 8.13  | -700  | 17.78 |
| -074   | 1.88        | -340 | 8.64  | -720  | 18.29 |
| -078   | 1.98        | -350 | 8.89  | -740  | 18.80 |
| -090   | 2.29        | -360 | 9.14  | -760  | 19.30 |
| -102   | 2.59        | -370 | 9.40  | -780  | 19.81 |
| -112   | 2.84        | -380 | 9.65  | -800  | 20.32 |
| -125   | 3.17        | -390 | 9.91  | -820  | 20.83 |
| -135   | 3.43        | -400 | 10.16 | -840  | 21.34 |
| -140   | 3.56        | -410 | 10.41 | -860  | 21.84 |
| -145   | 3.68        | -420 | 10.67 | -880  | 22.35 |
| -150   | 3.81        | -440 | 11.18 | -900  | 22.86 |
| -160   | 4.06        | -450 | 11.43 | -920  | 23.37 |
| -170   | 4.32        | -460 | 11.68 | -940  | 23.88 |
| -175   | 4.45        | -480 | 12.19 | -960  | 24.38 |
| -200   | 5.08        | -500 | 12.70 | -980  | 24.89 |
| -210   | 5.33        | -520 | 13.21 | -1000 | 25.40 |
| -220   | 5.59        | -540 | 13.72 | -1010 | 25.65 |
| -230   | 5.84        | -550 | 13.97 | -1170 | 29.72 |
| -240   | 6.10        |      |       |       |       |

**True radius style strip, 20 deg, for use with built in depth stop 149626**

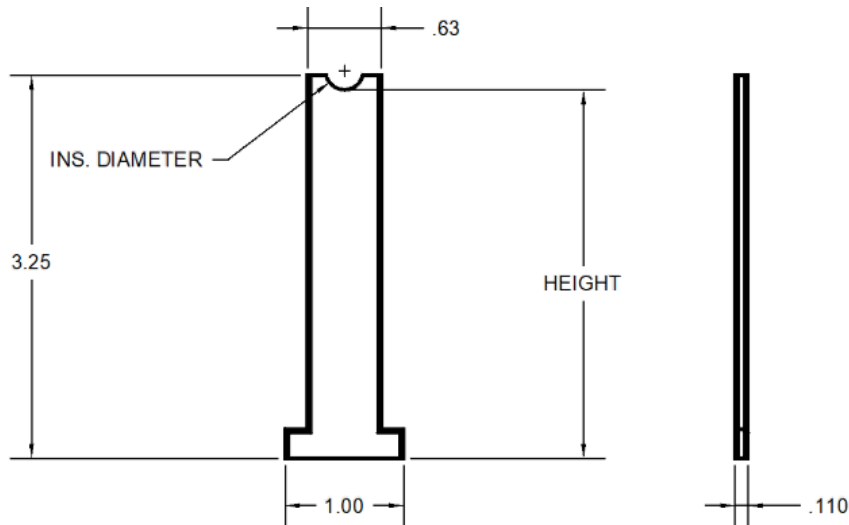


**150266-xxx** Strip blade, radius style 20 degree, the dash number is the diameter of the hole in the blade in inches. Example -028 is .028 inches

| Dash # | millimeters |      |       |      |       |
|--------|-------------|------|-------|------|-------|
| -024   | 0.61        | -250 | 6.35  | -560 | 14.22 |
| -031   | 0.78        | -256 | 6.50  | -580 | 14.73 |
| -039   | 0.99        | -260 | 6.60  | -600 | 15.24 |
| -047   | 1.19        | -270 | 6.86  | -620 | 15.75 |
| -055   | 1.40        | -280 | 7.11  | -640 | 16.26 |
| -062   | 1.57        | -285 | 7.24  | -660 | 16.76 |
| -067   | 1.70        | -300 | 7.62  | -680 | 17.27 |
| -070   | 1.78        | -320 | 8.13  | -700 | 17.78 |
| -074   | 1.88        | -340 | 8.64  | -720 | 18.29 |
| -078   | 1.98        | -350 | 8.89  | -740 | 18.80 |
| -090   | 2.29        | -360 | 9.14  | -760 | 19.30 |
| -102   | 2.59        | -370 | 9.40  | -780 | 19.81 |
| -112   | 2.84        | -380 | 9.65  | -800 | 20.32 |
| -125   | 3.17        | -390 | 9.91  | -820 | 20.83 |
| -135   | 3.43        | -400 | 10.16 | -840 | 21.34 |
| -140   | 3.56        | -410 | 10.41 | -860 | 21.84 |
| -145   | 3.68        | -420 | 10.67 | -880 | 22.35 |
| -150   | 3.81        | -440 | 11.18 | -900 | 22.86 |
| -160   | 4.06        | -450 | 11.43 | -920 | 23.37 |
| -170   | 4.32        | -460 | 11.68 | -940 | 23.88 |
| -175   | 4.45        | -480 | 12.19 | -960 | 24.38 |

|      |      |      |       |       |       |
|------|------|------|-------|-------|-------|
| -200 | 5.08 | -500 | 12.70 | -980  | 24.89 |
| -210 | 5.33 | -520 | 13.21 | -1000 | 25.40 |
| -220 | 5.59 | -540 | 13.72 | -1010 | 25.65 |
| -230 | 5.84 | -550 | 13.97 | -1170 | 29.72 |
| -240 | 6.10 |      |       |       |       |

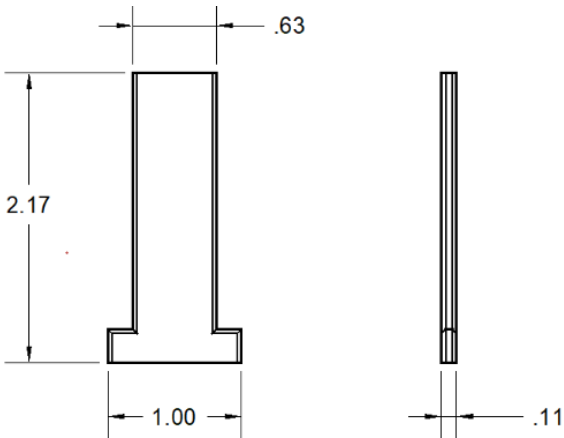
### ***Depth stop for blade 149625 and 150266***



**149626-xxx-xxxx** Depth stop, the stop must be selected according to the conductor diameter and the insulation diameter.

| Dash #    | Insulation diameter inch | Insulation diameter mm | Strip blade diameter inch | Strip blade diameter mm | "HEIGHT" inch | "HEIGHT" mm |
|-----------|--------------------------|------------------------|---------------------------|-------------------------|---------------|-------------|
| -320-3126 | 0.320                    | 8.13                   | 0.240                     | 6.10                    | 3.126         | 79.40       |
| -336-3127 | 0.336                    | 8.53                   | 0.256                     | 6.50                    | 3.127         | 79.43       |
| -336-3129 | 0.336                    | 8.53                   | 0.270                     | 6.86                    | 3.129         | 79.48       |
| -382-3137 | 0.382                    | 9.70                   | 0.320                     | 8.13                    | 3.137         | 79.68       |
| -402-3127 | 0.402                    | 10.21                  | 0.320                     | 8.13                    | 3.127         | 79.43       |
| -630-3093 | 0.630                    | 16.00                  | 0.500                     | 12.70                   | 3.093         | 78.56       |
| -750-3084 | 0.750                    | 19.05                  | 0.600                     | 15.24                   | 3.084         | 78.33       |
| -844-3086 | 0.844                    | 21.44                  | 0.700                     | 17.78                   | 3.086         | 78.38       |

**149627** Depth stop plug for blade 149625. This can close the opening in blade, if you do not want to run the blade with a depth stop.

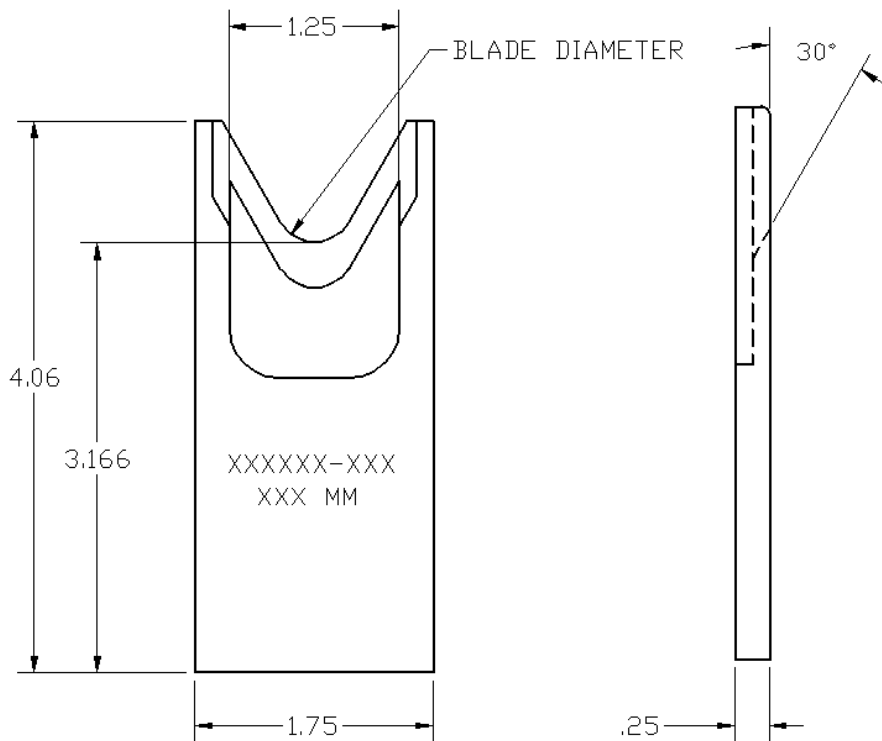


### ***Tangent radius style stripping blades***

The sharp edge is ground to an arc whose radius approximates awg wire size. The entry angle lines meet the arc at a tangent point. This type of blade, when closed, presents a diamond shaped edge profile.

Advantages: by adjusting cutter head shut height, (if insulation material and wall thickness allow), you can process adjacent wire extrusions. It also tips the slug less as it is pulled from the wire, sometimes reducing the amount of scrapping on the conductors.

Disadvantages: inadequate for processing thin wall and/or hard insulations such as cross-link or fiberglass jackets.

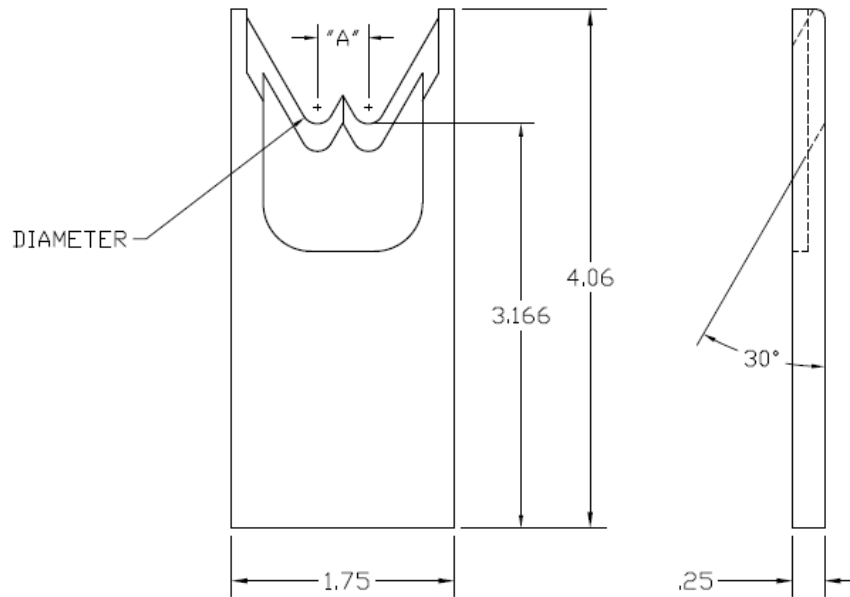


**143066-xxx** Strip blade, tangent radius style 30 degree. The dash number is the diameter of the hole in the blade in inches. Example -028 is .028 inches

| Dash # | millimeters |      |       |      |       |
|--------|-------------|------|-------|------|-------|
| -024   | 0.61        | -280 | 7.11  | -660 | 16.76 |
| -031   | 0.78        | -300 | 7.62  | -680 | 17.27 |
| -039   | 0.99        | -320 | 8.13  | -700 | 17.78 |
| -047   | 1.19        | -340 | 8.64  | -720 | 18.29 |
| -055   | 1.40        | -360 | 9.14  | -740 | 18.80 |
| -067   | 1.70        | -380 | 9.65  | -760 | 19.30 |
| -078   | 1.98        | -400 | 10.16 | -780 | 19.81 |
| -090   | 2.29        | -420 | 10.67 | -800 | 20.32 |
| -102   | 2.59        | -440 | 11.18 | -820 | 20.83 |
| -112   | 2.84        | -460 | 11.68 | -840 | 21.34 |
| -125   | 3.17        | -480 | 12.19 | -860 | 21.84 |
| -140   | 3.56        | -500 | 12.70 | -880 | 22.35 |
| -150   | 3.81        | -520 | 13.21 | -900 | 22.86 |
| -160   | 4.06        | -540 | 13.72 | -920 | 23.37 |
| -175   | 4.45        | -560 | 14.22 | -940 | 23.88 |
| -200   | 5.08        | -580 | 14.73 | -960 | 24.38 |
| -220   | 5.59        | -600 | 15.24 | -980 | 24.89 |
| -240   | 6.10        | -620 | 15.75 |      |       |
| -260   | 6.60        | -640 | 16.26 |      |       |

## Parallel cord stripping blades

These blades are for stripping 2 or more conductor flat cable. Special wire guides may be required to hold the wire flat as it runs through the machine. Typically each different type of cord needs a different blade size. Contact the Artos sales department for information on how to submit a sample wire for blade sizing and design.



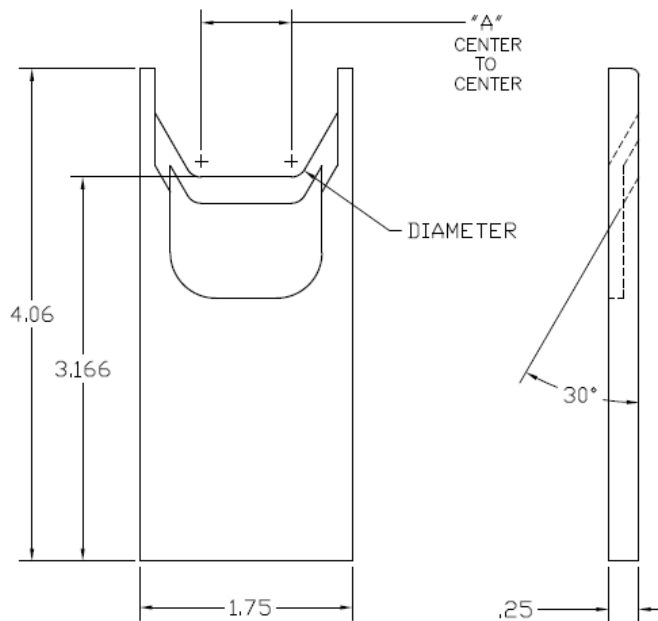
**123723-x** Parallel cord stripping blade

| -x  | Mark on blade | Qty of "V"s | Diameter inch | "A" dimension inch | Diameter mm | "A" dimension mm |
|-----|---------------|-------------|---------------|--------------------|-------------|------------------|
| -22 | 2V-042-125    | 2           | .042          | .125               | 1.07        | 3.18             |
| -6  | 2V-052-135    | 2           | .052          | .135               | 1.32        | 3.43             |
| -2  | 2V-062-108    | 2           | .062          | .108               | 1.57        | 2.74             |
| -3  | 2V-076-120    | 2           | .076          | .120               | 1.93        | 3.05             |
| -8  | 2V-076-170    | 2           | .076          | .170               | 1.93        | 4.32             |
| -7  | 2V-096-195    | 2           | .096          | .195               | 2.44        | 4.95             |
| -18 | 2V-096-225    | 2           | .096          | .225               | 2.44        | 5.72             |
| -9  | 2V-120-205    | 2           | .120          | .205               | 3.05        | 5.21             |
| -19 | 2V-120-240    | 2           | .120          | .240               | 3.05        | 6.10             |
| -10 | 2V-156-325    | 2           | .156          | .325               | 3.96        | 8.26             |
| -15 | 2V-156-360    | 2           | .156          | .360               | 3.96        | 9.14             |
| -25 | 2V-160-410    | 2           | .160          | .410               | 4.06        | 10.41            |
| -4  | 2V-172-325    | 2           | .172          | .325               | 4.37        | 8.26             |
| -11 | 2V-172-365    | 2           | .172          | .365               | 4.37        | 9.27             |
| -12 | 2V-210-385    | 2           | .210          | .385               | 5.33        | 9.78             |
| -26 | 2V-210-415    | 2           | .210          | .415               | 5.33        | 10.54            |
| -20 | 2V-225-350    | 2           | .225          | .350               | 5.72        | 8.89             |
| -1  | 2V-250-400    | 2           | .250          | .400               | 6.35        | 10.16            |

|     |            |   |       |       |      |       |
|-----|------------|---|-------|-------|------|-------|
| -13 | 2V-250-420 | 2 | .250  | .420  | 6.35 | 10.67 |
| -30 | 2V-255-220 | 2 | .255  | .220  | 6.48 | 5.59  |
| -29 | 2V-255-455 | 2 | .255  | .455  | 6.48 | 11.56 |
| -21 | 2V-270-410 | 2 | .270  | .410  | 6.86 | 10.41 |
| -17 | 2V-280-460 | 2 | .280  | .460  | 7.11 | 11.68 |
| -16 | 2V-280-485 | 2 | .280  | .485  | 7.11 | 12.32 |
| -27 | 2V-295-480 | 2 | .148  | .480  | 3.76 | 12.19 |
| -23 | 2V-312-610 | 2 | .312  | .610  | 7.92 | 15.49 |
| -31 | 2V-325-500 | 2 | .325  | .500  | 8.26 | 12.70 |
| -5  | 2V-350-530 | 2 | .350  | .530  | 8.89 | 13.46 |
| -28 | 2V-380-625 | 2 | .380  | .625  | 9.65 | 15.88 |
| -14 | 3V-062-105 | 3 | .062  | .105  | 1.57 | 2.67  |
| -24 | 3V-096-156 | 3 | .096  | .156  | 2.44 | 3.96  |
| -32 | 3V-134-134 | 3 | 0.134 | 0.134 | 3.40 | 3.40  |

### ***Oval strip blades***

This type of blade is for stripping the outer jacket off of a flat multi-conductor cord. Typically each different type of cord needs a different blade size. Contact the Artos sales department for information on how to submit a sample wire for blade sizing and design.



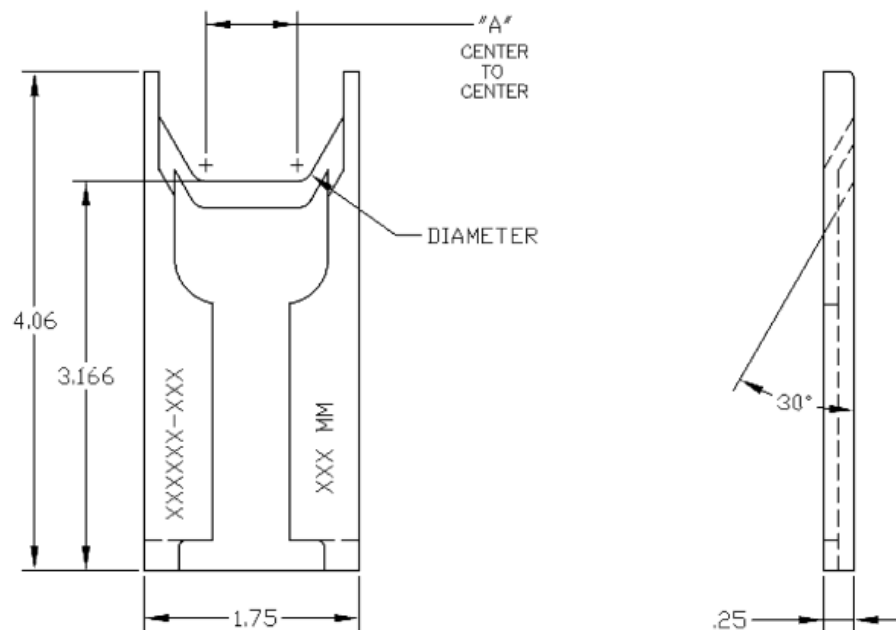
#### **123758-x Oval cord stripping blade**

| -x  | Diameter<br>inch | "A" dimension<br>inch | Diameter<br>mm | "A" dimension<br>mm |
|-----|------------------|-----------------------|----------------|---------------------|
| -12 | .080             | .735                  | 2.03           | 18.67               |
| -11 | .080             | 1.130                 | 2.03           | 28.70               |
| -4  | .130             | .117                  | 3.30           | 2.97                |

|     |      |      |       |       |
|-----|------|------|-------|-------|
| -1  | .130 | .367 | 3.30  | 9.32  |
| -13 | .140 | .265 | 3.56  | 6.73  |
| -15 | .144 | .828 | 3.66  | 21.03 |
| -10 | .150 | .150 | 3.81  | 3.81  |
| -9  | .150 | .290 | 3.81  | 7.37  |
| -8  | .180 | .330 | 4.57  | 8.38  |
| -7  | .200 | .385 | 5.08  | 9.78  |
| -2  | .208 | .601 | 5.28  | 15.27 |
| -3  | .260 | .742 | 6.60  | 18.85 |
| -5  | .290 | .572 | 7.37  | 14.53 |
| -6  | .330 | .630 | 8.38  | 16.00 |
| -14 | .410 | .060 | 10.41 | 1.52  |

### ***Oval strip blades, for use with built in depth stop 150105***

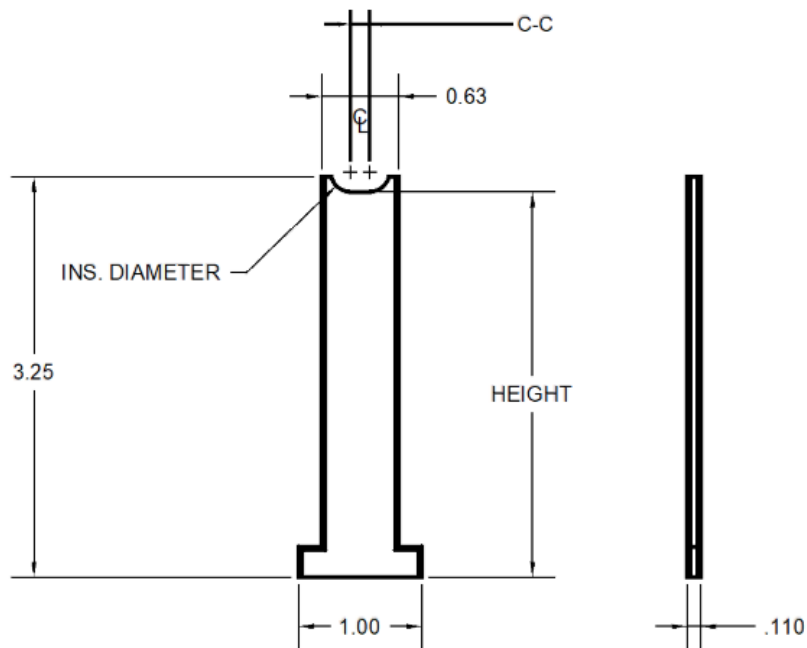
This type of blade is for stripping the outer jacket off of a flat multi-conductor cord. In addition this blade can have a cutting depth stop inserted that will prevent the edge of the blade from contacting the inner conductors. Typically each different type of cord needs a different blade and depth stop size. Contact the Artos sales department for information on how to submit a sample wire for blade sizing and design.



#### **150104-x Oval cord stripping blade**

| -x | Overall cutting size, inch | Overall cutting size, mm | Diameter inch | "A" dimension inch | Diameter mm | "A" dimension mm |
|----|----------------------------|--------------------------|---------------|--------------------|-------------|------------------|
| -1 | 0.490 x 0.540              | 12.45 x 13.72            | 0.490         | 0.050              | 12.44       | 1.27             |
|    |                            |                          |               |                    |             |                  |

## Oval depth stop for blade 150104



**150105-xx**

Depth stop, the stop must be selected according to the conductor diameter and the insulation diameter.

| Dash # | Insulation diameter inch | Insulation diameter mm | Strip blade diameter inch | Strip blade diameter mm | "HEIGHT" inch | "HEIGHT" mm |
|--------|--------------------------|------------------------|---------------------------|-------------------------|---------------|-------------|
| -1     | 0.630 x 0.690            | 16.00 x 17.53          | 0.490 x 0.540             | 12.45 x 13.72           | 3.101         | 78.77       |
|        |                          |                        |                           |                         |               |             |

**149627** Depth stop plug for blade 150104. This can close the opening in blade, if you do not want to run the blade with a depth stop.

